

# HELICOIL® Tangfree Screwlock thread insert

Stainless steel A2 | coloured red | Metric standard thread



**Advantages:**

- No tang break or tang removal
- Installation possible on both sides
- Screw-locking
- High thread loading
- Increased quality and value
- Wear-resistant, low and constant thread friction
- Highly resilient
- Corrosion and temperature resistant
- Cost-effective
- Tight fit

Prewailing torques similar to ISO 2320

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D <sub>HC</sub> min.	D <sub>1HC</sub>		Nominal length		W	B	d <sub>1</sub>	
				min.	max.	t <sub>2</sub> (x d)	t <sub>2</sub>			min.	max.
M 3	51320030003	0.50	3.65	3.11	3.22	1.0	3.0	3.8	3.2	3.80	4.35
	51320030006					2.0	6.0	6.4			
	51320030045					1.5	4.5	8.9			
M 4	51320040004	0.70	4.91	4.15	4.29	1.0	4.0	3.6	4.2	5.05	5.60
	51320040006					1.5	6.0	6.1			
	51320040008					2.0	8.0	8.6			
M 5	51320050005	0.80	6.04	5.17	5.33	1.0	5.0	4.1	5.2	6.25	6.80
	51320050010					2.0	10.0	9.6			
	51320050075					1.5	7.5	6.9			
M 6	51320060006	1.00	7.30	6.22	6.41	1.0	6.0	4.0	6.3	7.40	7.95
	51320060009					1.5	9.0	6.8			
	51320060012					2.0	12.0	9.5			
M 8	51320080008	1.25	9.62	8.27	8.48	1.0	8.0	4.5	8.4	9.80	10.35
	51320080012					1.5	12.0	7.4			
	51320080016					2.0	16.0	10.3			
M 10	51320100010	1.50	11.95	10.32	10.56	1.0	10.0	4.9	10.5	11.95	12.50
	51320100020					2.0	20.0	11.1			

All technical data refer to the measure mm

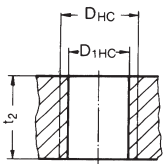


## HELICOIL® Plus thread inserts

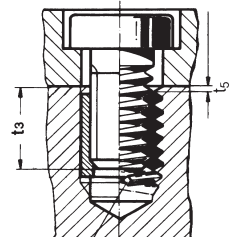
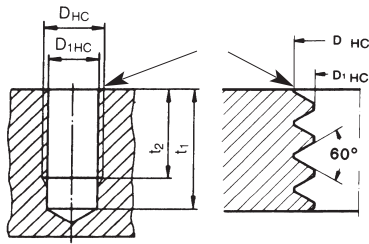


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### Holding thread



### Assembly



tang not broken off

Prior to tapping, counter-bore 90° and deburr.  
Outside diameter of countersink =  $D_{HC} + 0.1 \text{ mm}$ .

- d = Nominal thread diameter
- P = Thread pitch
- $d_1$  = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- $D_{HC}$  = Outside diameter of the parent thread
- $D_{1HC}$  = Crest diameter
- B = Suitable twist drill diameter. Please note:  $D_{1HC}$  is critical for selecting the correct twist drill diameter.
- $t_1$  = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- $t_2$  = The nominal length of the thread insert corresponds to the minimum length of the full parent thread for blind holes or the minimum plate thickness for a through hole.
- $t_3$  = Maximum screw-in depth when the tang is not removed
- $t_5$  = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if  $t_2$  corresponds to the above-mentioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least  $1 \times P$  to values  $t_1$  and  $t_2$ .

All technical data refer to the measure mm

