

# HELICOIL® Plus installation mandrels with depth stop

for processing of HELICOIL® Plus Free Running with installation tools types: B-S 824 | E-S 410 | P-S 412 | P-S 1216



Type 4160.25 installation mandrel with depth stop to process HELICOIL® Plus Free Running coil thread inserts with fine or coarse thread.

**Suited for:**

- Type E-S 410 electrical installation tool
- Type B-S 824 cordless installation tool
- P-S 412 and P-S 1216 pneumatic installation tools

**Properties:**

- With external hexagon as per DIN 3126 – E 6.3/DIN ISO 1173

**Note:**

These installation mandrels can also be used as manual installation mandrels.

HELICOIL® Plus Screwlock installation mandrels are marked with a ring groove on the guide shaft. HELICOIL® Plus Free Running installation mandrels have a smooth guide shaft.

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	Design
M 7	41602507020	1.00	HELICOIL® Plus Free Running
M 8	41602508020	1.25	HELICOIL® Plus Free Running
M 9	41602509020	1.25	HELICOIL® Plus Free Running
M 10	41602510020	1.50	HELICOIL® Plus Free Running
M 12	41602512020	1.75	HELICOIL® Plus Free Running
M 14	41602514020	2.00	HELICOIL® Plus Free Running
M 16	41602516020	2.00	HELICOIL® Plus Free Running
M 18	41602518020	2.50	HELICOIL® Plus Free Running
M 20	41602520020	2.50	HELICOIL® Plus Free Running
M 22	41602522020	2.50	HELICOIL® Plus Free Running
M 24	41602524020	3.00	HELICOIL® Plus Free Running

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts



W and d<sub>1</sub> 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<sub>1</sub> = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- D<sub>HC</sub> = Outside diameter of the parent thread
- D<sub>1HC</sub> = Crest diameter
- B = Suitable twist drill diameter. Please note: D<sub>1HC</sub> is critical for selecting the correct twist drill diameter.
- t<sub>1</sub> = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t<sub>2</sub> = 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<sub>3</sub> = Maximum screw-in depth when the tang is not removed
- t<sub>5</sub> = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> corresponds to the above-mentioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values t<sub>1</sub> and t<sub>2</sub>.

All technical data refer to the measure mm

