

# HELICOIL® Plus Free Running thread inserts, refill pack

Stainless steel A2 | bright or coloured green | UNC



**Advantages:**

- High thread loading
- Increased quality and value
- Wear-resistant, low and constant thread friction
- Highly resilient
- Corrosion and temperature resistant
- Cost-effective
- Tight fit

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 t <sub>2</sub> (x d)
				min.	max.	
UNC 1/4"-20	41890746004	1.27	8.00	6.62	6.86	1.0
	41890746006					1.5
	41890746008					2.0
UNC 5/16"-18	41890766004	1.41	9.77	8.24	8.49	1.0
	41890766006					1.5
	41890766008					2.0
UNC 3/8"-16	41890776004	1.59	11.59	9.89	10.12	1.0
	41890776006					1.5
	41890776008					2.0
UNC 7/16"-14	41890786004	1.81	13.47	11.51	11.78	1.0
	41890786006					1.5
	41890786008					2.0
UNC 1/2"-13	41890796004	1.95	15.24	13.12	13.40	1.0
	41890796006					1.5
	41890796008					2.0
UNC 2-56	41890636004	0.44	2.84	2.28	2.44	1.0
	41890636006					1.5
	41890636008					2.0
UNC 4-40	41890656004	0.64	3.67	3.00	3.15	1.0
	41890656006					1.5
	41890656008					2.0
UNC 6-32	41890676004	0.79	4.54	3.68	3.89	1.0
	41890676006					1.5
	41890676008					2.0
UNC 8-32	41890686004	0.79	5.20	4.34	4.52	1.0
	41890686006					1.5
	41890686008					2.0
UNC 10-24	41890696006	1.06	6.20	5.06	5.28	1.5
	41890696008					2.0
	41890706006					1.06

Diameter (d)	Nominal length		t <sub>3</sub> max.	B	d <sub>1</sub>	
	t <sub>2</sub>	W			min.	max.
UNC 1/4"-20	6.4	3.40	5.8	6.7	8.0	8.4
	9.5	5.70	8.9			
	12.7	8.00	12.1			

All technical data refer to the measure mm



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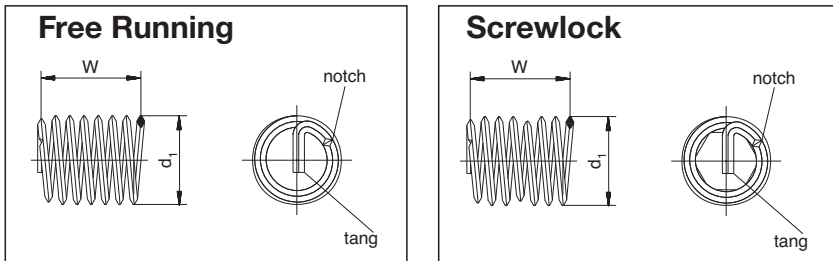
Stainless steel A2 | bright or coloured green | UNC

Diameter (d)	Nominal length		t <sub>3</sub> max.	B	d <sub>1</sub>	
	t <sub>2</sub>	W			min.	max.
UNC 5/16"-18	7.9	4.00	7.2	8.4	9.7	10.2
	11.9	6.60	11.2			
	15.9	9.30	15.2			
UNC 3/8"-16	9.5	4.40	8.7	10.0	11.5	12.0
	14.3	7.20	13.5			
	19.1	10.10	18.3			
UNC 7/16"-14	11.1	4.50	10.2	11.6	13.4	14.0
	16.7	7.40	15.8			
	22.2	10.30	21.3			
UNC 1/2"-13	12.7	7.90	18.1	13.2	15.2	15.8
	19.1	10.90	24.4			
	25.4	13.90	30.8			
UNC 2-56	2.2	3.00	1.8	2.4	2.7	2.9
	3.3	5.25	2.9			
	4.4	7.40	3.9			
UNC 4-40	2.9	2.80	2.5	3.1	3.6	4.0
	4.3	4.80	3.9			
	5.8	6.80	5.4			
UNC 6-32	3.5	2.80	3.1	3.8	4.5	4.9
	5.3	4.80	4.9			
	7.0	6.70	6.6			
UNC 8-32	4.2	3.50	3.8	4.4	5.2	5.6
	6.3	5.90	5.9			
	8.3	8.30	8.0			
UNC 10-24	7.2	5.00	6.7	5.2	6.2	6.6
	9.6	7.10	9.1			
UNC 12-24	8.2	5.90	7.7	5.8	6.8	7.2

All technical data refer to the measure mm

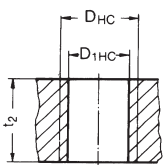


## HELICOIL® Plus thread inserts

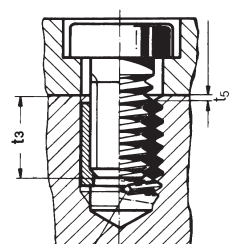
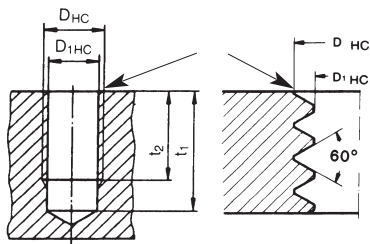
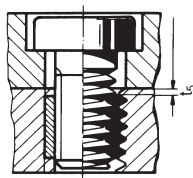


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

