

# HELICOIL® machine taps

straight fluted | For through holes

Type 0141.1 HELICOIL® machine tap to create holding threads for HELICOIL® thread inserts with British Standard Whitworth coarse threads (BSW) as per NASM33537. The tap is suited for through holes and blind holes with a deeper tap hole.



**Properties:**

- Straight-fluted
- With spiral point
- 4-pitch chamfer
- 10 % cutting angle
- For materials with 850 N/mm<sup>2</sup> strength max.
- Tolerance class 2B

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	Nominal length t <sub>2</sub>
BSW 5/16"-18	01411763104	1.41	11.9
BSW 3/8"-16	01411773104	1.59	14.3

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

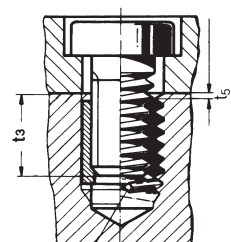
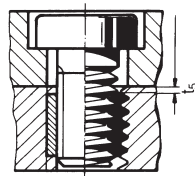


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

