All technical data refer to the measure mm

HELICOIL® machine taps spiral fluted 45° | For blind holes

Type 0141.4 HELICOIL® machine tap to create holding threads for HELICOIL® thread inserts with UNC threads as per NASM33527. The tap is suited for blind holes.

Properties:

- Spiral flute 45° right-hand spiral
- 2-pitch chamfer
- 15 % cutting angle
- For wrought aluminium alloys with 500 N/mm² strength max.
- Also for cast aluminium alloys with very low Si content (≤ 2 %)
- Tolerance class 2B

Note:

- Up to UNC 8-32 2-flute
- From UNC 10-24 3-flute and additionally for soft steels with 450 N/mm² strength max.

Technical information can be found on the last page.

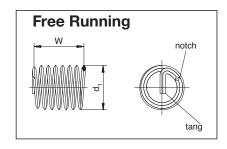
	Diameter	Article number	Pitch	Nominal length
	(d)		(P)	t ₂
L	JNC 1/4"-20	01414746152	1.27	6.4
U	NC 5/16"-18	01414766152	1.41	7.9
L	JNC 3/8"-16	01414776152	1.58	9.5
L	JNC 1/2"-13	01414796152	1.95	25.4
	UNC 2-56	01414636152	0.43	2.2
	UNC 4-40	01414656152	0.63	2.2
	UNC 6-32	01414676152	0.79	8.8
	UNC 8-32	01414686152	0.79	4.2
	UNC 10-24	01414696152	1.05	5.5

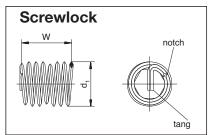




All technical data refer to the measure mm

HELICOIL® Plus thread inserts



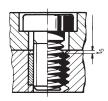


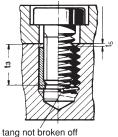
W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread

DHC D HC COO

Assembly





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

- d = Nominal thread diameter
- P = Thread pitch
- d₁ = 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
- Suitable twist drill diameter. Please note:
 D_{1HC} is critical for selecting the correct twist drill diameter.
- t₁ = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t₂ = 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.
- t₃ = 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 abovementioned minimum value

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