

## HELICOIL® tang break-off tool

TB-M mechanical HELICOIL® tang break-off tool for tang removal without loss of performance. Easy-to-use, economical and fitting for HELICOIL® Plus and HELICOIL® Classic ranging from 1 d to 2 d.

**Note:**

From M14 and UNC 5/9"-18, the tang must be removed using snipe nose pliers.

Technical information can be found on the last page.



Diameter (d)	Article number
M 2 ; UNC 2-56	01586020000
M 2.5	01586250000
M 3 ; UNC 4-40 - UNC 6-32 ; UNF 4-48 - UNF 6-40	01586030000
M 3.5	01586350000
M 4 ; UNC 8-32 - UNC 10-24 ; UNF 8-36 - UNF 10-32	01586040000
M 5 ; UNC 12-24	01586050000
M 6 ; UNC 1/4"-20 ; UNF 1/4"-28	01586060000
M 7 ; UNC 5/16"-18	01586070000
M 8 ; UNF 5/16"-24	01586080000
M 9 ; UNC 3/8"-16 ; UNF 3/8"-24	01586090000
M 10 - M 11 ; UNC 7/16"-14 - UNC 1/2"-13	01586100000
M 12 ; UNC 9/16"-12 ; UNF 1/2"-20	01586120000

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

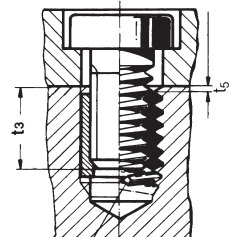
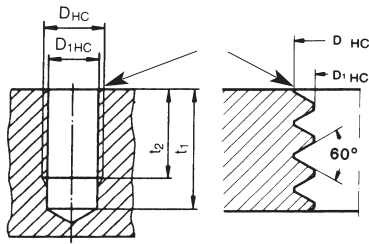


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

