## **HELICOIL<sup>®</sup>** Installation mandrel

for HELICOIL<sup>®</sup> pneumatic and electrical installation tool

Installation mandrel for pneumatic HELICOIL® installation tools (UNF).

## Suited for:

• P-PSG 714 and P-PSG 714 SF

Technical information can be found on the last page.



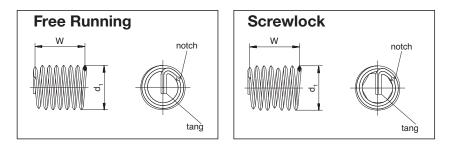
Diameter	Article number	Pitch	Nominal length
(d)		(P)	t <sub>2</sub>
UNF 5/16"-24	01602876720	1.05	19.8
UNF 3/8"-24	01602877720	1.05	9.5
UNF 1/2"-20	01602879720	1.27	12.7



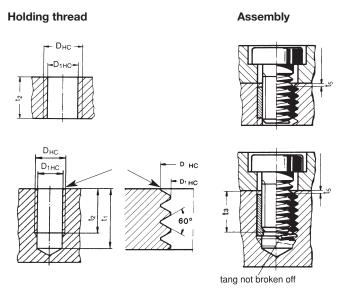
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## HELICOIL® Plus thread inserts



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.



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

- d = Nominal thread diameter
- P = Thread pitch
- $d_1 \quad = \mbox{ Outside diameter of thread insert prior to installation} \\$
- 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.
- $t_1$  = Minimum depth of tapped hole according to DIN 76 Part 1 (guide value)
  - = 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.
  - = Maximum screw-in depth when the tang is not removed
  - Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> 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  $t_2.$ 

t<sub>2</sub>

t3

 $t_5$ 



В

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