

## HELICOIL® manual extracting tool

For the manual removal of HELICOIL® Plus and HELICOIL® Classic thread inserts.

For coarse and fine threads.

Technical information can be found on the last page.



Diameter (d)	Article number
M 2 - M 3.5 ; UNC 2-56 - UNC 6-32 ; UNF 4-48 - UNF 6-40	01803000000
M 4 - M 10x2 ; UNC 8-32 - UNC 3/8"-16 ; UNF 8-36 - UNF 3/8"-24	01803010000
M 11 - M 16x1.5 ; UNC 7/16"-14 - UNC 5/8"-11 ; UNF 7/16" - UNF 9/16"-18	01803020000
M 18 - M 22x2 ; UNC 3/4"-10 - UNC 7/8"-9 ; UNF 5/8"-18 - UNF 7/8"-14	01803030000
M 24 - M 33x2 ; UNC 1"-8 - UNC 1 1/8"-7 ; UNF 1"-14 - UNF 1 1/8"-12	01803040000
M 36 - M 36x3 ; UNC 1 1/4"-7 - UNC 1 1/2"-6 ; UNF 1 1/4"-12 - UNF 1 1/2"-12	01803050000

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

