

# HELICOIL® manual taps

Type 0140.2 | UNC

Finishing tap (product type 0140.2)

Manual tap for through holes and blind holes to create holding threads (acc. to NASM33537) for HELICOIL® coil thread inserts. A manual tap, a taper tap (product type 0140.1), is required in addition.



**Properties:**

- 2-pitch chamfer
- Machining of materials with 700 N/mm<sup>2</sup> strength max.

**Note:**

The taper tap (product type 0140.1) must be ordered as a separate item.

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
UNC 1/4"-20	01402746102	1.27
UNC 5/16"-18	01402766102	1.41
UNC 3/8"-16	01402776102	1.58
UNC 7/16"-14	01402786102	1.81
UNC 1/2"-13	01402796102	1.95
UNC 9/16"-12	01402806102	2.12
UNC 5/8"-11	01402816102	2.31
UNC 3/4"-10	01402836102	2.54
UNC 7/8"-9	01402856102	2.82
UNC 1"-8	01402866102	3.18
UNC 1 1/8"-7	01402876102	3.63
UNC 1 1/4"-7	01402886102	3.63
UNC 1 3/8"-6	01402896102	4.23
UNC 1 1/2"-6	01402906102	4.23
UNC 2-56	01402636102	0.43
UNC 4-40	01402656102	0.63
UNC 5-40	01402666102	0.63
UNC 6-32	01402676102	0.79
UNC 8-32	01402686102	0.79
UNC 10-24	01402696102	1.05
UNC 12-24	01402706102	1.06

All technical data refer to the measure mm

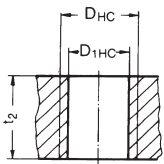


## HELICOIL® Plus thread inserts

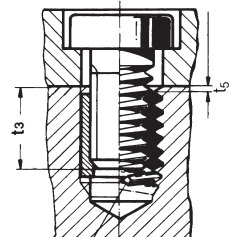
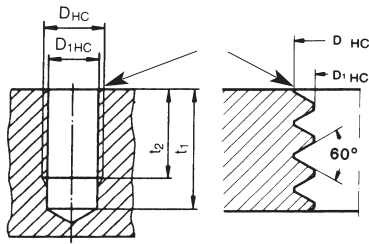


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

