

# HELICOIL® Plus pneumatic installation tool

with prewinder | For fast processing of HELICOIL® Plus

P-PSG 256 pneumatic installation tool with leader cartridge to process HELICOIL® Classic, HELICOIL® Plus Free Running and Screwlock thread inserts. It is recommended to be used in medium and large series for bulk material processing.



Complete tool with a size-specific exchange unit (further exchange units must be ordered separately).

**Properties:**

- Pitch-controlled
- Reversible compressed-air motor from the BOSCH Company
- Adjustment of the installation depth through changing compensation washers
- Connection: 2.5–4.0 bar
- Air consumption: 204 l/min
- Diameter: 28 mm
- Length: 240 mm
- Weight: 0.6 kg

**Alternative devices:**

- P-PSG 714 (for medium sizes, metric and imperial)
- P-PSG 1626 (for large sizes, metric)
- P-PSG 256 SF (to process magazined thread inserts)

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
UNF 1/4"-28	01603774700	0.91
UNC 2-56	01603763600	0.43
M 2.5	01603725000	0.45
M 3	01603703000	0.50
M 4	01603704000	0.70
UNC 4-40	01603765600	0.63
M 5	01603705000	0.80
M 6	01603706000	1.00
UNC 6-32	01603767600	0.79
UNF 6-40	01603767700	0.63
UNC 8-32	01603768600	0.79
UNF 8-36	01603768700	0.71
UNF 10-32	01603769700	0.79

All technical data refer to the measure mm

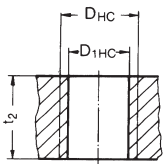


## HELICOIL® Plus thread inserts

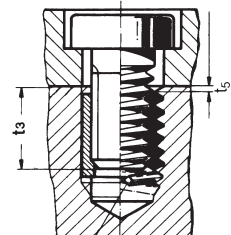
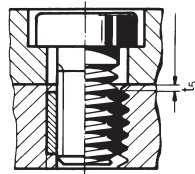


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

