

# HELICOIL® Tangfree installation mandrels with depth stop

for HELICOIL® Tangfree Screwlock

HELICOIL® Tangfree installation mandrel to process HELICOIL® Tangfree Screwlock coil thread inserts with a UNC thread. Compatible with the hexagon socket of HELICOIL® Plus installation tools.



**Suited for:**

- E-S 206 and E-S 410 electrical installation tools
- P-S 412 and P-S 1216 pneumatic installation tools

**Properties:**

- 1/4" hex drive
- With depth stop

**Delivery scope:**

- Installation mandrel
- Telescopic sleeve
- Tool for blade change
- Operating instructions
- Packaging

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	Nominal length t <sub>2</sub>
UNC 1/4"-20	51604374602	1.27	6.4
UNC 4-40	51604365602	0.63	4.3
UNC 6-32	51604367602	0.79	3.5
UNC 8-32	51604368602	0.79	6.2

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

