

## HELICOIL® manual installation tool

The H-PSG manual installation tool allows an easy installation of HELICOIL® Classic and HELICOIL® Plus thread inserts without loss of performance. The manual installation tool features a leader cartridge, a pitch-controlled threaded mandrel and a depth stop and fits metric normal and fine screw threads.



**Note:**

Only required for HELICOIL® Plus for fine screw threads and special applications. As an alternative, a HELICOIL® Plus installation mandrel can be used.

**Properties:**

- Pitch-controlled
- With depth stop
- With leader cartridge
- For HELICOIL® Classic, HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
M 2	01500102000	0.40
M 2.5	01500125000	0.45
M 3	01500103000	0.50
M 4	01500104000	0.70
M 5	01500105000	0.80
M 6	01500106000	1.00
M 7	01500107000	1.00
M 8	01500108000	1.25
M 8x1	01500108300	1.00
M 10	01500110000	1.50
M 10x1	01500110300	1.00
M 10x1.25	01500110900	1.25
M 12	01500112000	1.75
M 12x1	01500112300	1.00
M 12x1.25	01500112900	1.25
M 12x1.5	01500112400	1.50
M 14	01500114000	2.00
M 14x1	01500114300	1.00
M 14x1.25	01500114900	1.25
M 14x1.5	01500114400	1.50
M 16	01500116000	2.00
M 16x1.5	01500116400	1.50
M 18x1.5	01500118400	1.50
M 18x2	01500118500	2.00
M 20x1.5	01500120400	1.50
M 20x2	01500120500	2.00
M 22x1.5	01500122400	1.50
M 22x2	01500122500	2.00
M 24x1.5	01500124400	1.50
M 24x2	01500124500	2.00
M 26x1.5	01500126400	1.50
M 27x1.5	01500127400	1.50

All technical data refer to the measure mm



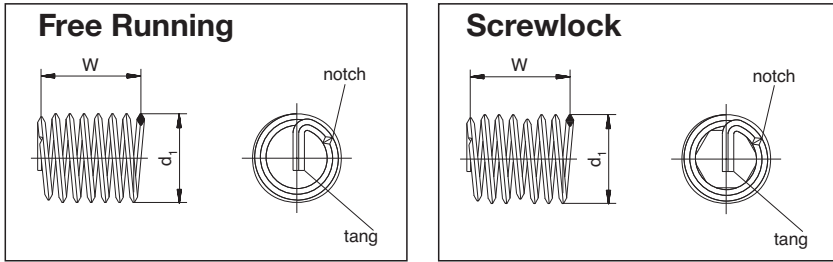
## HELICOIL® manual installation tool

Diameter (d)	Article number	Pitch (P)
M 27x2	01500127500	2.00
M 28x1.5	01500128400	1.50
M 30x1.5	01500130400	1.50
M 30x2	01500130500	2.00
M 33x2	01500133500	2.00
M 36x1.5	01500136400	1.50
M 36x2	01500136500	2.00
M 36x3	01500136600	3.00

All technical data refer to the measure mm

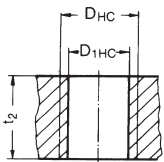


## HELICOIL® Plus thread inserts

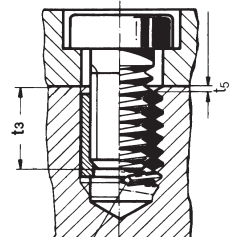
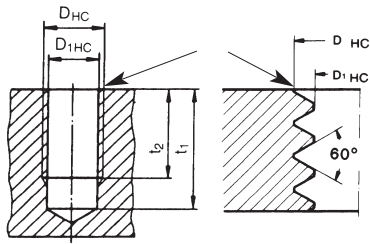
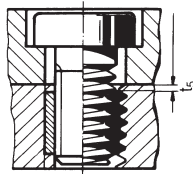


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

