

## HELICOIL® Plus prewinder

for HELICOIL® pneumatic and electrical installation tool P-PSG 256 SF for processing magazined thread inserts

Leader cartridge for HELICOIL® installation tools to process magazined HELICOIL® Classic STRIPFEED® and HELICOIL® Plus STRIPFEED® thread inserts.

**Suited for:**

- P-PSG 256 SF pneumatic installation tool

Technical information can be found on the last page.



Diameter (d)	Article number	Pitch (P)
M 2.5	01601725035	0.45
M 3	01601703034	0.50
	01601703035	
M 4	01601704033	0.70
	01601704035	
M 5	01601705033	0.80
	01601705035	
M 6	01601706033	1.00
	01601706035	

All technical data refer to the measure mm

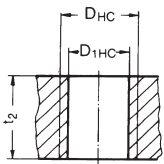


## HELICOIL® Plus thread inserts

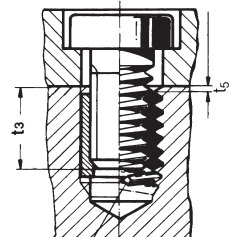
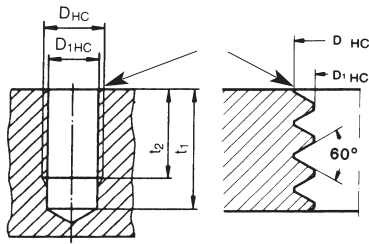


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

