

# HELICOIL® Plus pneumatic installation tool

with prewinder | For fast processing of HELICOIL® Plus

P-PSG 714 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: 4.0–5.0 bar
- Air consumption: 282 l/min
- Diameter: 42 mm
- Length: 360 mm
- Weight: 1.4 kg

**Note:**

Features a sliding sleeve for finger protection to avoid accidents. This finger guard shall not be removed.

**Alternative devices:**

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

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
UNF 5/16"-24	01602876700	1.05
UNF 3/8"-24	01602877700	1.05
UNF 7/16"-20	01602878700	1.27
UNC 1/2"-13	01602879600	1.95
UNF 1/2"-20	01602879700	1.27
M 8	01602808000	1.25
M 8x1	01602808300	1.00
M 10	01602810000	1.50
M 10x1	01602810300	1.00
M 10x1.25	01602810900	1.25
M 12	01602812000	1.75
M 12x1.25	01602812900	1.25
M 12x1.5	01602812400	1.50
M 14	01602814000	2.00
M 14x1.5	01602814400	1.50

All technical data refer to the measure mm

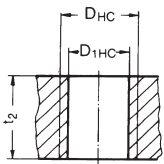


## HELICOIL® Plus thread inserts

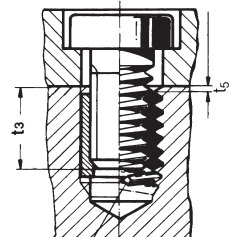
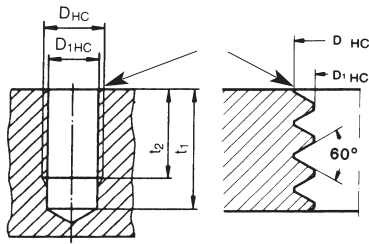


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

