

**HELICOIL® Plus Free Running thread inserts**

Stainless steel A2 | coloured green | BSP/G

**Advantages:**

- High thread loading
- Increased quality and value
- Wear-resistant, low and constant thread friction
- Highly resilient
- Corrosion and temperature resistant
- Cost-effective
- Tight fit



Technical information can be found on the last page.

| Diameter<br>(d) | Article number | Pitch<br>(P) | D <sub>HC</sub><br>min. | D <sub>1HC</sub><br>min.   max. |       | Nominal length<br>t <sub>2</sub> (x d) | Nominal length<br>t <sub>2</sub> | W    | t <sub>3</sub><br>max. | B    | d <sub>1</sub><br>min.   max. |      |
|-----------------|----------------|--------------|-------------------------|---------------------------------|-------|----------------------------------------|----------------------------------|------|------------------------|------|-------------------------------|------|
| G 1/8"-28       | 41300714004    | 0.91         | 10.82                   | 9.91                            | 10.16 | 1.0                                    | 3.2                              | 1.9  | 2.7                    | 10.0 | 11.5                          | 12.0 |
|                 | 41300714006    |              |                         |                                 |       | 1.5                                    | 4.8                              | 3.6  | 4.3                    |      |                               |      |
|                 | 41300714008    |              |                         |                                 |       | 2.0                                    | 6.4                              | 5.1  | 5.9                    |      |                               |      |
|                 | 41300714010    |              |                         |                                 |       | 2.5                                    | 7.9                              | 6.6  | 7.4                    |      |                               |      |
| G 1/4"-19       | 41300744004    | 1.34         | 14.74                   | 13.46                           | 13.72 | 1.0                                    | 6.4                              | 3.1  | 5.7                    | 13.6 | 15.7                          | 16.2 |
|                 | 41300744006    |              |                         |                                 |       | 1.5                                    | 9.5                              | 5.3  | 8.8                    |      |                               |      |
|                 | 41300744008    |              |                         |                                 |       | 2.0                                    | 12.7                             | 7.4  | 12.0                   |      |                               |      |
| G 3/8"-19       | 41300774004    | 1.34         | 18.25                   | 17.02                           | 17.27 | 1.0                                    | 9.5                              | 5.3  | 8.8                    | 17.1 | 19.5                          | 20.0 |
|                 | 41300774006    |              |                         |                                 |       | 1.5                                    | 14.3                             | 8.5  | 13.6                   |      |                               |      |
| G 1/2"-14       | 41300794004    | 1.81         | 23.09                   | 21.34                           | 21.59 | 1.0                                    | 12.7                             | 5.2  | 11.7                   | 21.5 | 24.6                          | 25.2 |
|                 | 41300794006    |              |                         |                                 |       | 1.5                                    | 19.1                             | 8.4  | 18.1                   |      |                               |      |
|                 | 41300794008    |              |                         |                                 |       | 2.0                                    | 25.4                             | 11.6 | 24.6                   |      |                               |      |

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



Prior to tapping, counter-bore 90° and deburr.  
Outside diameter of **countersink** =  $D_{HC} + 0.1 \text{ mm}$ .

- |                                                                                                                       |                                                                                                                                                                                |
|-----------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| d = Nominal thread diameter                                                                                           | $t_1$ = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)                                                                                                |
| P = Thread pitch                                                                                                      | $t_2$ = 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. |
| $d_1$ = Outside diameter of thread insert prior to installation                                                       | $t_3$ = Maximum screw-in depth when the tang is not removed                                                                                                                    |
| W = Number of threads prior to installation                                                                           | $t_5$ = 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                                           |
| $D_{HC}$ = 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. |                                                                                                                                                                                |

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least  $1 \times P$  to values  $t_1$  and  $t_2$ .