HELICOIL® Plus Free Running thread inserts

Stainless steel A2 | coloured green | Metric fine thread



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 (d)	Article number	Pitch (P)	D_{HC} min.	D_{1HC} min.	D_{1HC} max.	Nominal length t_2 (x d)	Nominal length t_2	W	t_3 max.	B	d_1 min.	d_1 max.
M 8x1	41300083008	1.00	9.30	8.22	8.41	1.00	8.0	6.1	7.5	8.30	9.85	10.1
	41300083012					1.50	12.0	9.5	11.5			
	41300083016					2.00	16.0	12.9	15.5			
	41300083020					2.50	20.0	16.5	19.5			
M 10x1	41300103010	1.00	11.30	10.22	10.41	1.00	10.0	7.6	9.5	10.25	12.10	12.5
	41300103015					1.50	15.0	12.1	14.5			
	41300103020					2.00	20.0	16.3	19.5			
	41300103030					3.00	30.0	25.0	29.5			
M 10x1.25	41300109010	1.25	11.62	10.27	10.48	1.00	10.0	6.0	9.4	10.40	12.10	12.5
	41300109015					1.50	15.0	9.7	14.4			
	41300109020					2.00	20.0	13.1	19.4			
	41300109025					2.50	25.0	16.9	24.4			
	41300109030					3.00	30.0	20.1	29.4			
M 12x1	41300123012	1.00	13.30	12.22	12.41	1.00	12.0	9.3	11.5	12.25	14.40	14.8
	41300123018					1.50	18.0	14.5	17.5			
	41300123024					2.00	24.0	19.5	23.5			
M 12x1.25	41300129012	1.25	13.62	12.27	12.48	1.00	12.0	7.4	11.4	12.25	14.40	14.8
	41300129018					1.50	18.0	11.6	17.4			
	41300129024					2.00	24.0	15.9	23.4			
	41300129036					3.00	36.0	24.3	35.4			
M 12x1.5	41300124012	1.50	13.95	12.32	12.56	1.00	12.0	6.2	11.2	12.50	14.40	14.8
	41300124018					1.50	18.0	9.8	17.2			
	41300124024					2.00	24.0	13.5	23.2			
	41300124030					2.50	30.0	17.1	29.2			
	41300124036					3.00	36.0	20.8	35.2			
M 14x1	41300143014	1.00	15.30	14.22	14.41	1.00	14.0	11.2	13.5	14.25	16.80	17.2
	41300143021					1.50	21.0	17.2	20.5			
M 14x1.25	41300149084	1.25	15.62	14.27	14.48	0.60	8.4	4.6	7.8	14.25	16.80	17.2
	41300149124					0.90	12.4	7.4	11.8			
	41300149144					1.00	14.4	9.1	13.8			
	41300149164					1.20	16.4	10.2	15.8			
M 14x1.5	41300144014	1.50	15.95	14.38	14.56	1.00	14.0	7.4	13.2	14.50	16.80	17.2
	41300144021					1.50	21.0	11.6	20.2			
	41300144028					2.00	28.0	15.7	27.2			
	41300144035					2.50	35.0	19.9	34.2			

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M 16x1.5	41300164016	1.50	17.95	16.32	16.56	1.00	16.0	8.7	15.2	16.50	19.00	19.4
	41300164024					1.50	24.0	13.4	23.2			
	41300164032					2.00	32.0	18.1	31.2			
	41300164040					2.50	40.0	22.9	39.2			
M 18x1.5	41300184009	1.50	19.95	18.32	18.56	0.50	9.0	4.2	8.2	18.50	21.50	22.0
	41300184018					1.00	18.0	9.5	17.2			
	41300184027					1.50	27.0	14.9	26.2			
	41300184036					2.00	36.0	20.2	35.2			
	41300184135					0.75	13.5	7.0	12.7			
M 18x2	41300185018	2.00	20.60	18.43	18.72	1.00	18.0	7.1	17.0	18.50	21.50	22.0
	41300185027					1.50	27.0	11.2	26.0			
	41300185036					2.00	36.0	15.1	35.0			
M 20x1.5	41300204010	1.50	21.95	20.32	20.56	0.50	10.0	4.9	9.2	20.50	23.70	24.2
	41300204015					0.75	15.0	7.9	14.2			
	41300204020					1.00	20.0	10.7	19.2			
	41300204030					1.50	30.0	16.7	29.2			
	41300204040					2.00	40.0	22.4	39.2			
M 20x2	41300205015	2.00	22.60	20.43	20.73	0.75	15.0	5.8	14.0	20.50	23.70	24.2
	41300205020					1.00	20.0	8.0	19.0			
	41300205030					1.50	30.0	12.5	29.0			
	41300205040					2.00	40.0	16.8	39.0			
M 22x1.5	41300224011	1.50	23.95	22.32	22.56	0.50	11.0	5.5	10.2	22.50	26.30	26.8
	41300224022					1.00	22.0	11.7	21.2			
	41300224033					1.50	33.0	18.1	32.2			
	41300224044					2.00	44.0	24.5	43.2			
	41300224165					0.75	16.5	8.6	15.7			
M 22x2	41300225044	2.00	24.60	22.43	22.73	2.00	44.0	18.4	43.0	22.50	26.30	26.8
M 24x1.5	41300244012	1.50	25.95	24.33	24.56	0.50	12.0	6.0	11.2	24.50	28.60	29.1
	41300244018					0.75	18.0	9.5	17.2			
	41300244024					1.00	24.0	12.9	23.2			
	41300244036					1.50	36.0	19.8	35.2			
	41300244048					2.00	48.0	26.7	47.2			
M 24x2	41300245036	2.00	26.60	24.43	24.73	1.50	36.0	15.0	35.0	24.50	28.60	29.1
	41300245048					2.00	48.0	20.2	47.0			
M 26x1.5	41300264013	1.50	27.95	26.33	26.56	0.50	13.0	6.5	12.2	26.50	31.00	31.5
	41300264026					1.00	26.0	14.0	25.2			
	41300264039					1.50	39.0	21.6	38.2			
	41300264052					2.00	52.0	29.1	51.2			
	41300264195					0.75	19.5	10.3	18.7			
M 27x1.5	41300274027	1.50	28.95	27.33	27.56	1.00	27.0	14.6	26.2	27.50	32.20	32.7
	41300274135					0.50	13.5	6.7	12.7			
	41300274405					1.50	40.5	22.6	39.7			
M 27x2	41300275027	2.00	29.60	27.43	27.73	1.00	27.0	10.8	26.0	29.60	32.20	32.7
	41300275054					2.00	54.0	22.6	53.0			
	41300275203					0.75	20.3	7.9	19.3			
	41300275405					1.50	40.5	16.8	39.5			
M 28x1.5	41300284028	1.50	29.95	28.33	28.56	1.00	28.0	15.2	27.2	28.50	33.10	33.6
M 30x1.5	41300304015	1.50	31.95	30.33	30.56	0.50	15.0	7.8	14.2	30.50	35.20	35.7
	41300304030					1.00	30.0	16.5	29.2			
	41300304045					1.50	45.0	25.3	44.2			
	41300304060					2.00	60.0	34.0	59.2			
	41300304225					0.75	22.5	12.2	21.7			

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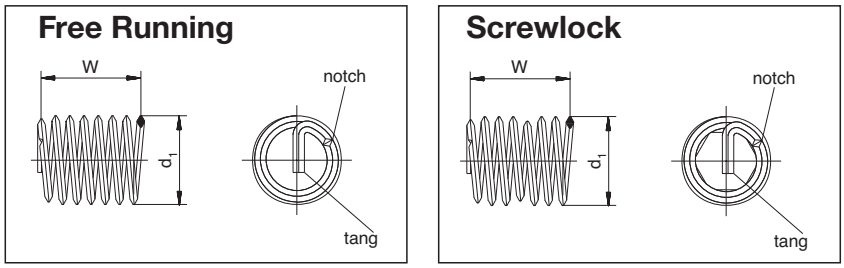
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Diameter (d)	Article number	Pitch (P)	D_{HC} min.	D_{1HC} min.	D_{1HC} max.	Nominal length t_2 (x d)	Nominal length t_2	W	t_3 max.	B	d_1 min.	d_1 max.
M 30x2	41300305015	2.00	32.60	30.43	30.73	0.50	15.0	5.7	14.0	30.50	35.20	35.7
	41300305030					1.00	30.0	12.3	29.0			
	41300305045					1.50	45.0	19.0	44.0			
	41300305060					2.00	60.0	25.5	59.0			
M 33x2	41300335033	2.00	35.60	33.43	33.73	1.00	33.0	13.7	32.0	33.50	38.30	38.8
	41300335165					0.50	16.5	6.4	15.5			
	41300335495					1.50	49.5	21.2	48.5			
M 36x1.5	41300364018	1.50	37.95	36.33	36.56	0.50	18.0	9.5	17.2	36.50	42.10	42.6
	41300364036					1.00	36.0	19.9	35.2			
M 36x2	41300365018	2.00	38.60	36.43	36.73	0.50	18.0	6.8	17.0	36.50	42.10	42.6
	41300365054					1.50	54.0	21.9	53.0			
M 36x3	41300366036	3.00	39.90	36.65	37.05	1.00	36.0	9.9	34.5	37.00	42.10	42.6
	41300366054					1.50	54.0	12.3	52.5			
	41300366072					2.00	72.0	16.6	70.5			
M 39x2	41300395488	2.00	41.60	39.43	39.73	1.25	48.8	13.7	44.3	39.50	45.10	45.6
M 39x3	41300396039	3.00	42.90	39.65	40.05	1.00	39.0	10.6	34.6	40.00	45.10	45.6

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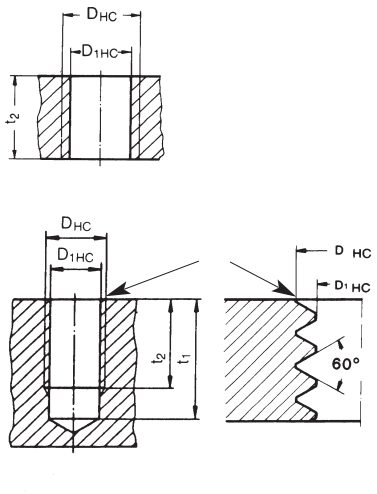
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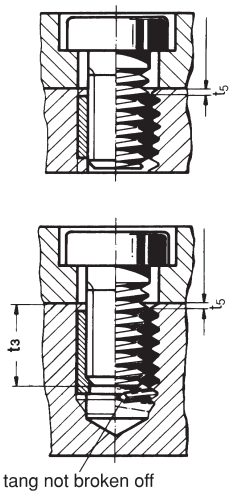


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



Prior to tapping, counter-bore 90° and deburr.
Outside diameter of **countersink = D_{HC} + 0.1 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 x P to values t_1 and t_2.

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