

## Exchange unit

for HELICOIL® pneumatic and electrical installation tool

Exchange unit for leader cartridge tools to process HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock thread inserts with UNF threads.

An exchange unit comprises the leader cartridge, an installation mandrel, a coupling and compensation washers.

**Suited for:**

- P-PSG 256 pneumatic installation tool
- E-PSG 256 electrical installation tool

Technical information can be found on the last page.



| Diameter<br>(d) | Article number | Pitch<br>(P) | Nominal length<br>t <sub>2</sub> |
|-----------------|----------------|--------------|----------------------------------|
| UNF 1/4"-28     | 01601774750    | 0.91         | 6.4                              |
| UNF 4-48        | 01601765750    | 0.53         | 7.1                              |
| UNF 6-40        | 01601767750    | 0.63         | 7.0                              |
| UNF 8-36        | 01601768750    | 0.71         | 4.2                              |
| UNF 10-32       | 01601769750    | 0.79         | 4.8                              |

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  $t_2$ .