HELICOIL® Plus Kit - Thread repair

M18 - M36 x 1,5 | 1 dimension in 1 length



Delivery scope:

- 10 HELICOIL® Plus thread inserts of the same size and length
- HELICOIL® manual tap (single tap or two-parts set consisting of pre and final cutter)
- HELICOIL® Plus installation mandrel (M18–M24 normal screw thread)
- HELICOIL® Plus manual installation tool (M27–M33 normal screw thread, M18 x 1.5–M36 x 1.5 fine screw thread)
- Practical case for storage and transport
- Operating instructions

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 18	41851180018	2.5	21.25	18.54	18.90	1.0	18.0	5.6	16.7	18.75	21.5	22.0
	41851180027					1.5	27.0	9.0	25.7			
	41851180036					2.0	36.0	12.3	34.7			
M 18x1.5	41851184018	1.5	19.95	18.32	18.56	1.0	18.0	9.5	17.2	18.50	21.5	22.0
	41851184027					1.5	27.0	14.9	26.2			
	41851184036					2.0	36.0	20.2	35.2			
M 18x2	41851185027	2.0	20.60	18.43	18.72	1.5	27.0	11.2	26.0	18.50	21.5	22.0
M 20	41851200020	2.5	23.25	20.54	20.90	1.0	20.0	6.3	19.2	20.75	23.7	24.2
	41851200030					1.5	30.0	10.0	29.2			
	41851200040					2.0	40.0	13.7	39.2			
M 20x1.5	41851204020	1.5	21.95	20.32	20.56	1.0	20.0	10.7	19.2	20.50	23.7	24.2
	41851204030					1.5	30.0	16.7	29.2			
	41851204040					2.0	40.0	22.4	39.2			
M 20x2	41851205020	2.0	22.60	20.43	20.73	1.0	20.0	8.0	19.0	20.50	23.7	24.2
	41851205030					1.5	30.0	12.5	29.0			
	41851205040					2.0	40.0	16.8	39.0			
M 22	41851220022	2.5	25.25	22.54	22.90	1.0	22.0	6.9	20.7	22.75	26.3	26.8
	41851220033					1.5	33.0	10.9	31.7			
	41851220044					2.0	44.0	15.0	42.7			
M 22x1.5	41851224022	1.5	23.95	22.32	22.56	1.0	22.0	11.7	21.2	22.50	26.3	26.8
	41851224033					1.5	33.0	18.1	32.2			
	41851224044					2.0	44.0	24.5	43.2			
M 22x2	41851225033	2.0	24.60	22.43	22.73	1.5	33.0	13.6	32.0	22.50	26.3	26.8
	41851225044					2.0	44.0	18.4	43.0			
M 24	41851240024	3.0	27.90	24.65	25.05	1.0	24.0	6.2	22.5	24.75	28.6	29.1
	41851240036					1.5	36.0	10.0	34.5			
	41851240048					2.0	48.0	14.0	46.5			
M 24x1.5	41851244024	1.5	25.95	24.33	24.56	1.0	24.0	12.9	23.2	24.50	28.6	29.1
	41851244036					1.5	36.0	19.8	35.2			
	41851244048					2.0	48.0	26.7	47.2			
M 24x2	41851245024	2.0	26.60	24.43	24.73	1.0	24.0	9.6	23.0	24.50	28.6	29.1
	41851245036					1.5	36.0	15.0	35.0			
	41851245048					2.0	48.0	20.2	47.0			
M 26x1.5	41851264026	1.5	27.95	26.33	26.56	1.0	26.0	14.0	25.2	26.50	31.0	31.5
	41851264039					1.5	39.0	21.6	38.2			
	41851264052					2.0	52.0	29.1	51.2			

All technical data refer to the measure mm

All technical data without obligation. Subject to technical changes and errors.

HELICOIL® Plus Kit - Thread repair

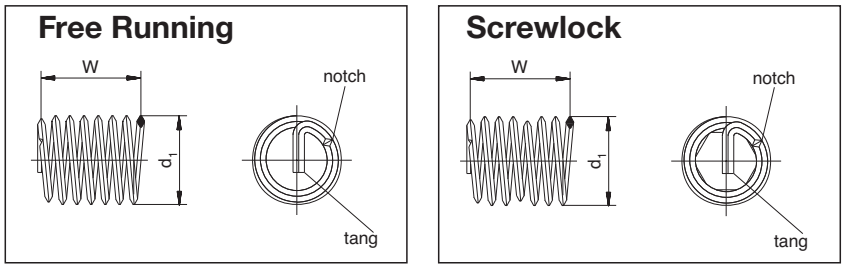
M18 - M36 x 1,5 | 1 dimension in 1 length

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 27	41851270027	3.0	30.90	27.65	28.05	1.0	27.0	7.1	25.5	27.75	32.2	32.7
	41851270054					2.0	54.0	15.4	52.5			
	41851270405					1.5	40.5	11.4	39.0			
M 27x1.5	41851274027	1.5	28.95	27.33	27.56	1.0	27.0	14.6	26.2	27.50	32.2	32.7
	41851274405					1.5	40.5	22.6	39.7			
M 27x2	41851275027	2.0	29.60	27.43	27.73	1.0	27.0	10.8	26.0	27.50	32.2	32.7
	41851275054					2.0	54.0	22.6	53.0			
	41851275405					1.5	40.5	16.8	39.5			
M 28x1.5	41851284028	1.5	29.95	28.33	28.56	1.0	28.0	15.2	27.2	28.50	33.1	33.6
M 30	41851300030	3.5	34.55	30.76	31.21	1.0	30.0	7.0	28.2	31.00	35.2	35.7
	41851300045					1.5	45.0	11.0	43.2			
	41851300060					2.0	60.0	14.9	58.2			
M 30x1.5	41851304030	1.5	31.95	30.33	30.56	1.0	30.0	16.5	29.2	30.50	35.2	35.7
	41851304045					1.5	45.0	25.3	44.2			
M 30x2	41851305030	2.0	32.60	30.43	30.73	1.0	30.0	12.3	29.0	30.50	35.2	35.7
	41851305045					1.5	45.0	19.0	44.0			
	41851305060					2.0	60.0	25.5	59.0			
M 32x1.5	41851324032	1.5	–	–	–	1.0	32.0	–	–	–	–	–
M 33	41851330033	3.5	37.55	33.76	34.21	1.0	33.0	7.8	31.2	34.00	38.3	38.8
	41851330066					2.0	66.0	16.5	64.2			
	41851330495					1.5	49.5	12.2	47.7			
M 33x2	41851335033	2.0	35.60	33.43	33.73	1.0	33.0	13.7	32.0	33.50	38.3	38.8
	41851335495					1.5	49.5	21.2	48.5			
M 35x1.5	41851354035	1.5	–	–	–	1.0	35.0	–	–	–	–	–
M 36x1.5	41851364036	1.5	37.95	36.33	36.56	1.0	36.0	19.9	35.2	36.50	42.1	42.6

All technical data refer to the measure mm

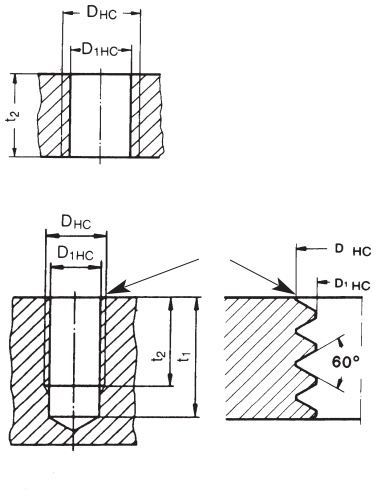
All technical data without obligation. Subject to technical changes and errors.

HELICOIL® Plus thread inserts

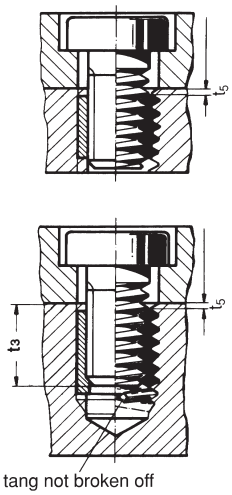


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



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

All technical data refer to the measure mm

All technical data without obligation. Subject to technical changes and errors.