HELICOIL® combined drilling and tapping tool

for holding threads according to DIN 8140-2 tolerance class 5H (6H mod.)



Combined drilling and tapping tool 0142.0 for HELICOIL® holding threads in damaged metric coarse and fine threads. Pre-drilling (tap drilling) is not required.

HELICOIL® taps create holding threads of tolerance class 5H (6H mod). After the HELICOIL® has been installed, there is an ISO thread of tolerance class 6H.

Note:
With its guide part, it can only be used for blind-hole threads under certain conditions.

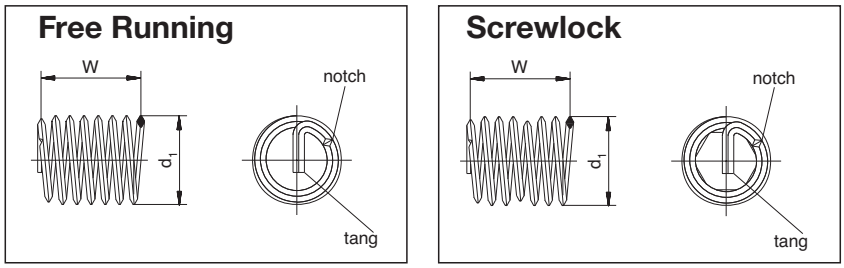
Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D_{HC} nominal size	d_2 nominal size	d_3 nominal size	L_1	L_2	L_3	K
M 6	01420060102	1.00	7.3	8	M6	90	26	9	6.2
M 8	01420080102	1.25	9.7	10	M8	90	28	11	8.0
M 10	01420100102	1.50	12.0	12	M10	100	31	12	9.0
M 10x1	01429103450	1.00	11.3	9	M10x1	92	31	10	7.0
M 12	01429120450	1.75	14.3	11	M12	92	35	12	9.0
M 12x1.25	01429129450	1.25	13.7	11	M12x1.25	92	35	12	9.0
M 12x1.5	01429124450	1.50	13.7	11	M12x1.25	92	35	12	9.0
M 14	01429140450	2.00	13.7	11	M12x1.25	92	35	12	9.0
M 14x1.25	01420149102	1.25	15.7	11	M14x1.25	153	35	12	9.0
	01429149450					92			
M 14x1.5	01429144450	1.50	16.0	11	M14x1.5	92	35	12	9.0
M 16	01429160450	2.00	18.7	14	M16	90	39	14	11.0
M 16x1.5	01429164450	1.50	18.0	14	M16x1.5	92	39	14	11.0

All technical data refer to the measure mm

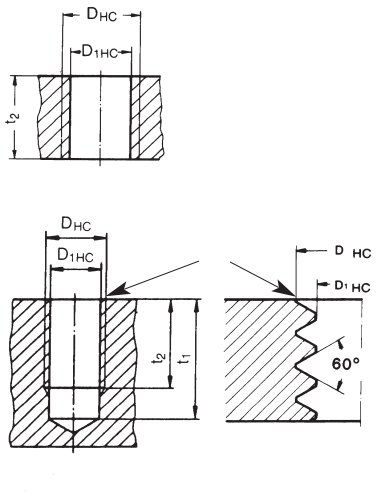
All technical data without obligation. Subject to technical changes and errors.

HELICOIL® Plus thread inserts

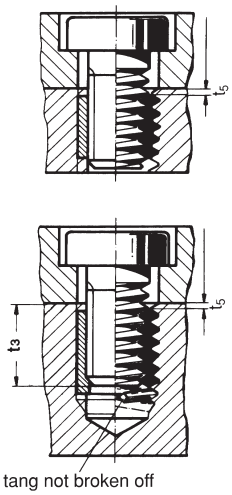


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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.