# HELICOIL® manual installation tool



The H-PMG manual installation tool allows an easy installation of HELICOIL® Classic and HELICOIL® Plus thread inserts. The tool features a leader cartridge, a pitch-controlled threaded mandrel and a depth stop and fits UNF threads (American National fine thread).

**Note:**
Only required for HELICOIL® Plus for fine screw threads and special applications. As an alternative, a HELICOIL® Plus installation mandrel can be used.

**Properties:**
- Smooth mandrel
- Pitch-controlled
- With depth stop
- With leader cartridge
- For HELICOIL® Classic, HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock

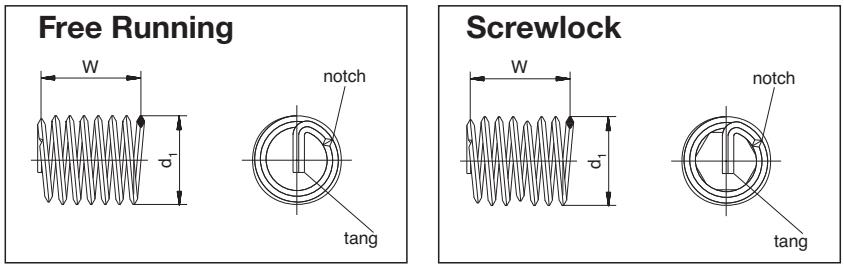
Technical information can be found on the last page.

| Diameter (d) | Article number | Pitch (P) | Nominal length $t_2$ |
|---|---|---|---|
| UNF 9/16"-18 | 01500280700 | 1.41 | 14.3 |
| UNF 5/8"-18 | 01500281700 | 1.41 | 15.9 |
| UNF 3/4"-16 | 01500283700 | 1.59 | 19.1 |
| UNF 7/8"-14 | 01500285700 | 1.81 | 22.2 |
| UNF 1"-12 | 01500286700 | 1.81 | 25.4 |
| UNF 1 1/8"-12 | 01500287700 | 2.12 | 28.6 |
| UNF 1 1/4"-12 | 01500288700 | 2.12 | 31.8 |
| UNF 1 3/8"-12 | 01500289700 | 2.12 | 34.9 |
| UNF 1 1/2"-12 | 01500290700 | 2.12 | 38.1 |

All technical data refer to the measure mm

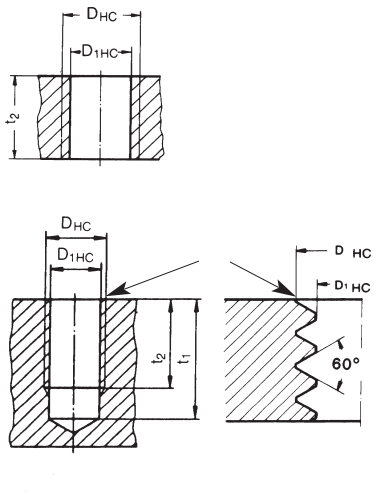

All technical data without obligation. Subject to technical changes and errors.

# **HELICOIL® Plus** thread inserts

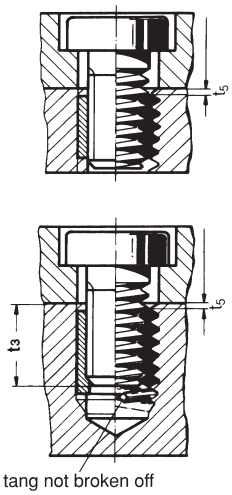



W and $d_1$ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

**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


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