

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}		Nominal length		W	t ₃ max.	B	d ₁	
				min.	max.	t ₂ (x d)	t ₂				min.	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			
	41300124012					1.00	12.0	6.2	11.2			
M 12x1.5	41300124018	1.50	13.95	12.32	12.56	1.50	18.0	9.8	17.2	12.50	14.40	14.8
	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			
	41300143014					1.00	14.0	11.2	13.5			
M 14x1	41300143021	1.00	15.30	14.22	14.41	1.50	21.0	17.2	20.5	14.25	16.80	17.2
	41300149084					0.60	8.4	4.6	7.8			
M 14x1.25	41300149124	1.25	15.62	14.27	14.48	0.90	12.4	7.4	11.8	14.25	16.80	17.2
	41300149144					1.00	14.4	9.1	13.8			
	41300149164					1.20	16.4	10.2	15.8			
	41300144014					1.00	14.0	7.4	13.2			
M 14x1.5	41300144021	1.50	15.95	14.38	14.56	1.50	21.0	11.6	20.2	14.50	16.80	17.2
	41300144028					2.00	28.0	15.7	27.2			
	41300144035					2.50	35.0	19.9	34.2			

All technical data refer to the measure mm



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				min.	max.	t ₂ (x d)	t ₂				min.	max.
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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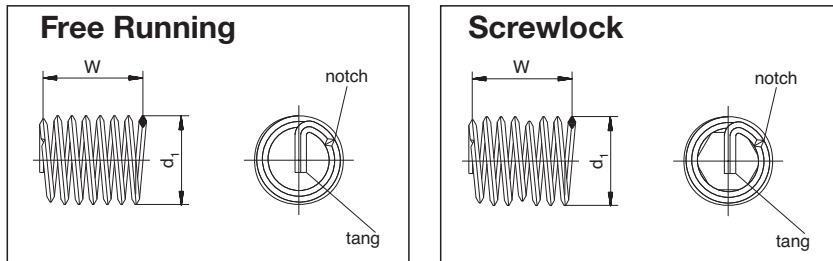
Stainless steel A2 | coloured green | Metric fine thread

Diameter (d)	Article number	Pitch (P)	D _{HC} min.	D _{1HC} min. max.		Nominal length t ₂ (x d)	Nominal length t ₂	W	t ₃ max.	B	d ₁ min. 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

All technical data refer to the measure mm

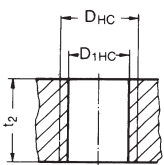


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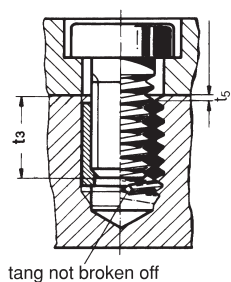
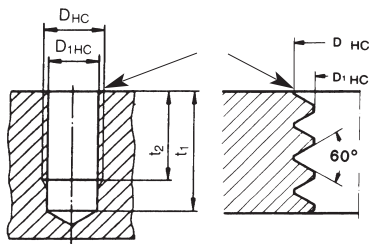
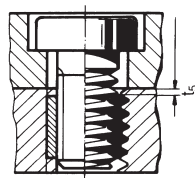


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



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

- | | |
|---|--|
| 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 .