# HELICOIL® Plus prewinder

**for HELICOIL® pneumatic and electrical installation tool P-PSG 1626**



Leader cartridge for HELICOIL® installation tools to process HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock thread inserts with coarse thread.

**Suited for:**

- P-PSG 1626 pneumatic installation tool

Technical information can be found on the last page.

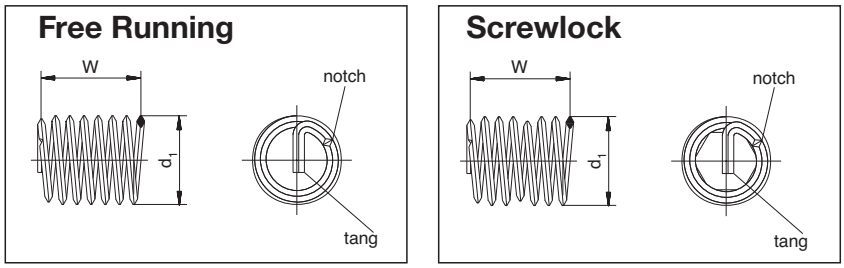
| Diameter (d) | Article number | Pitch (P) |
|---|---|---|
| M 16 | 01601916032 | 2.0 |
| M 16x1.5 | 01601916432 | 1.5 |
| M 18x1.5 | 01601918432 | 1.5 |
| M 20 | 01601920032 | 2.5 |
| M 20x1.5 | 01601920432 | 1.5 |
| M 22x1.5 | 01601922432 | 1.5 |
| M 24x1.5 | 01601924432 | 1.5 |
| M 26x1.5 | 01601926432 | 1.5 |

All technical data refer to the measure mm



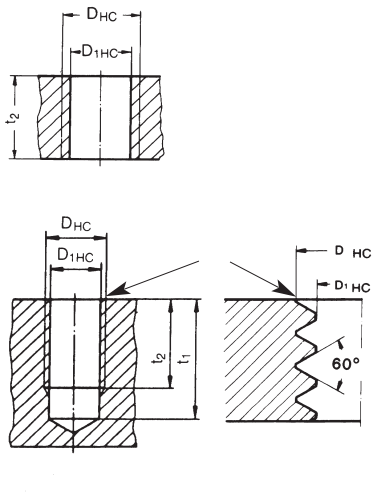
All technical data without obligation. Subject to technical changes and errors.

# **HELICOIL® Plus** thread inserts

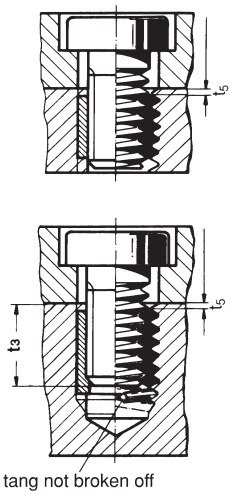



W and $d_1$ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

**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.