HELICOIL® Plus installation mandrels with depth stop

for processing of HELICOIL® Plus Free Running and Screwlock with installation tool types: B-S 824 | E-S 410 | P-S 412 | P-S 1216



Type 4160.25 installation mandrel with depth stop to process HELICOIL® Plus Free Running and Screwlock coil thread inserts with UNC thread.

Suited for:
- Type E-S 410 electrical installation tool
- Type B-S 824 cordless installation tool
- P-S 412 and P-S 1216 pneumatic installation tools

Properties:
- With external hexagon as per DIN 3126 – E 6.3/DIN ISO 1173

Note:
These installation mandrels can also be used as manual installation mandrels.

HELICOIL® Plus Screwlock installation mandrels are marked with a ring groove on the guide shaft. HELICOIL® Plus Free Running installation mandrels have a smooth guide shaft.

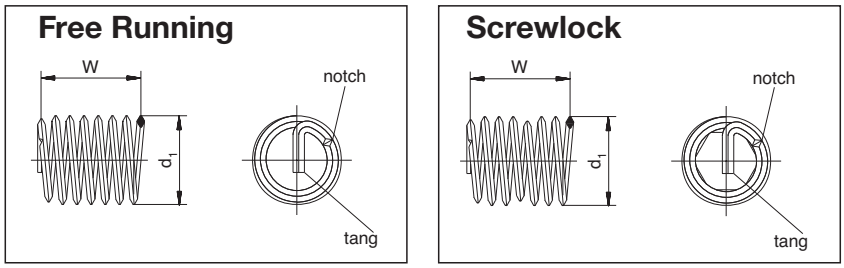
Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	Nominal length t_2	Design
UNC 1/4"-20	41602574620	1.27	6.4	HELICOIL® Plus Free Running & Screwlock
UNC 5/16"-18	41602576620	1.41	7.9	HELICOIL® Plus Free Running & Screwlock
UNC 3/8"-16	41602577620	1.58	9.5	HELICOIL® Plus Free Running & Screwlock
UNC 1/2"-13	41602579620	1.95	25.4	HELICOIL® Plus Free Running & Screwlock

All technical data refer to the measure mm

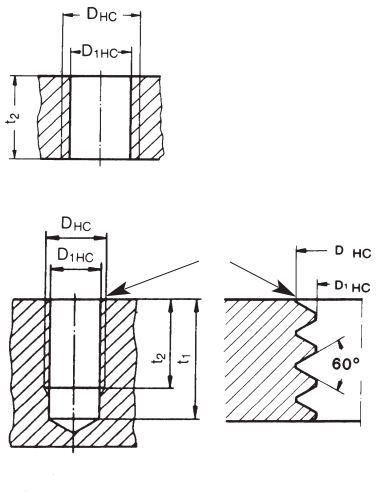
All technical data without obligation. Subject to technical changes and errors.

HELICOIL® Plus thread inserts

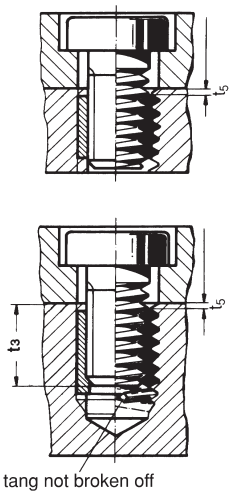


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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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