

# HELICOIL® Plus electrical installation tool

To easily and economically install HELICOIL® Plus thread inserts

**The following sizes can be processed:**

- M4 to M10
- UNC 8-32 to UNC 3/8"-16
- UNF 8-36 to UNF 3/8"-24

**Note:**

- Processing with installation mandrels (to be ordered separately)

**Properties:**

- Idle speed 1,200 rpm (continuously adjustable)
- Automatic reversal of the direction of rotation when the screw-in depth is reached
- Torque: 0.9 Nm–3 Nm (continuously adjustable at the control unit)
- Tool holder: quick-change chuck 1/4" hexagon socket with radial bearing for installation mandrel
- Weight: 0.57 kg

**Delivery scope:**

- Straight screwdriver with quick-change chuck
- Speed control with ramp control on the control unit, type EDU 2AE
- Case

Technical information can be found on the last page.



| Diameter   | Article number | Weight |
|------------|----------------|--------|
| (d)        |                | g      |
| M 4 - M 10 | 41605400000    | 570    |

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

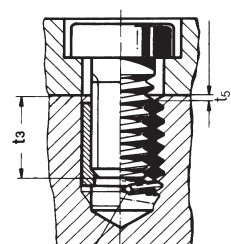


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### Holding thread



### Assembly



tang not broken off

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  $t_2$ .