Plug gauge for HELICOIL® holding threads

according to DIN 8140-T2 tolerance class 5H (6H mod.)



Plug gauge to check if holding threads for HELICOIL® thread inserts which have been produced with a threading tool are true to gauge.

For metric coarse and fine threads. Complies with tolerance class 5H (6H mod.) as per DIN 8140-2.

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
M 2	01473020500	0.40
M 2.5	01473250500	0.45
M 3	01473030500	0.50
M 3.5	01473350500	0.60
M 4	01473040500	0.70
M 5	01473050500	0.80
M 6	01473060500	1.00
M 7	01473070500	1.00
M 8	01473080500	1.25
M 8x1	01473083500	1.00
M 9	01473090500	1.25
M 10	01473100500	1.50
M 10x1	01473103500	1.00
M 10x1.25	01473109500	1.25
M 11	01473110500	1.50
M 12	01473120500	1.75
M 12x1	01473123500	1.00
M 12x1.25	01473129500	1.25
M 12x1.5	01473124500	1.50
M 14	01473140500	2.00
M 14x1.5	01473144500	1.50
M 16	01473160500	2.00
M 16x1.5	01473164500	1.50
M 18	01473180500	2.50
M 18x1.5	01473184500	1.50
M 18x2	01473185500	2.00
M 20	01473200500	2.50
M 20x1.5	01473204500	1.50
M 22	01473220500	2.50
M 22x1.5	01473224500	1.50
M 24	01473240500	3.00
M 24x1.5	01473244500	1.50
M 24x2	01473245500	2.00
M 26x1.5	01473264500	1.50
M 27	01473270500	–
M 27x1.5	01473274500	1.50
M 27x2	01473275500	2.00
M 30	01473300500	3.50
M 30x1.5	01473304500	1.50
M 30x2	01473305500	2.00
M 33	01473330500	3.50

All technical data refer to the measure mm

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

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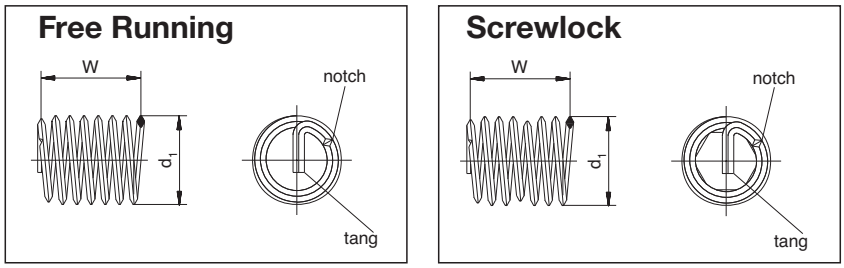
according to DIN 8140-T2 tolerance class 5H (6H mod.)

Diameter (d)	Article number	Pitch (P)
M 36	01473360500	4.00
M 36x1.5	01473364500	1.50
M 36x2	01473365500	2.00
M 36x3	01473366500	3.00

All technical data refer to the measure mm

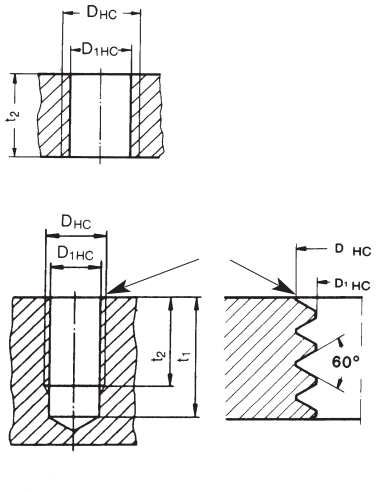
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HELICOIL® Plus thread inserts

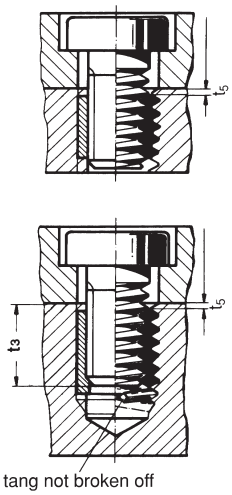


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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.