

# HELICOIL® Plus installation mandrels with depth stop

for processing of HELICOIL® Plus Free Running with installation tools types:  
B-S 206 | E-S 206 | E-S 410 | P-S 412



Type 4160.23 installation mandrel with depth stop to process HELICOIL® Plus Free Running coil thread inserts with coarse thread.

**Suited for:**

- B-S 206 cordless installation tool
- E-S 206 and E-S 410 electrical installation tools
- P-S 412 pneumatic installation tool

**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<br>(d) | Article number | Pitch<br>(P) | Design                      |
|-----------------|----------------|--------------|-----------------------------|
| M 2             | 41602302020    | 0.40         | HELICOIL® Plus Free Running |
| M 2.5           | 41602325020    | 0.45         | HELICOIL® Plus Free Running |
| M 3             | 41602303020    | 0.50         | HELICOIL® Plus Free Running |
| M 3.5           | 41602335020    | 0.60         | HELICOIL® Plus Free Running |
| M 4             | 41602304020    | 0.70         | HELICOIL® Plus Free Running |
| M 5             | 41602305020    | 0.80         | HELICOIL® Plus Free Running |
| M 6             | 41602306020    | 1.00         | HELICOIL® Plus Free Running |

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

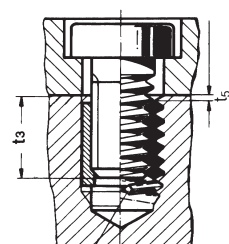
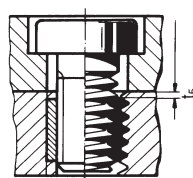


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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  $t_2$ .