

**HELICOIL®** manual installation tool

The H-PM manual installation tool allows an easy installation of HELICOIL® Classic and HELICOIL® Plus thread inserts. The tool features a leader cartridge, a threaded mandrel and a depth stop and fits BSF threads (British Standard Fine Thread).



**Note:**  
 Only required for HELICOIL® Plus for fine screw threads and special applications. As an alternative, a HELICOIL® Plus installation mandrel can be used.

- Properties:**
- No pitch control
  - With depth stop
  - With leader cartridge
  - For HELICOIL® Classic, HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock

Technical information can be found on the last page.

| Diameter<br>(d) | Article number | Pitch<br>(P) | Nominal length<br>t <sub>2</sub> |
|-----------------|----------------|--------------|----------------------------------|
| BSF 1/4"-26     | 01500474500    | 0.98         | 6.4                              |
| BSF 5/16"-22    | 01500476500    | 1.16         | 7.9                              |
| BSF 3/8"-20     | 01500477500    | 1.27         | 9.5                              |
| BSF 1/2"-16     | 01500479500    | 1.59         | 12.7                             |
| BSF 9/16"-16    | 01500480500    | 1.59         | 21.5                             |
| BSF 5/8"-14     | 01500481500    | 1.81         | 15.9                             |
| BSF 3/4"-12     | 01500483500    | 2.12         | 19.1                             |

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



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  $t_2$ .