# HELICOIL® tang break-off tool

**pneumatic, with thrust trigger**



TB-P pneumatic HELICOIL® tang break-off tool for tang removal without loss of performance. Easy-to-use, economical and fitting for HELICOIL® Plus and HELICOIL® Classic thread inserts with lengths between 1 d and 2 d.

**Properties:**

- Fits HELICOIL® Plus and HELICOIL® Classic
- Thrust trigger
- Operating pressure min. 4 bar – max. 6.3 bar, connection G 1⁄8"

**Note:**

From M14 and UNC 5/9"-18, the tang must be removed using snipe nose pliers.

Technical information can be found on the last page.

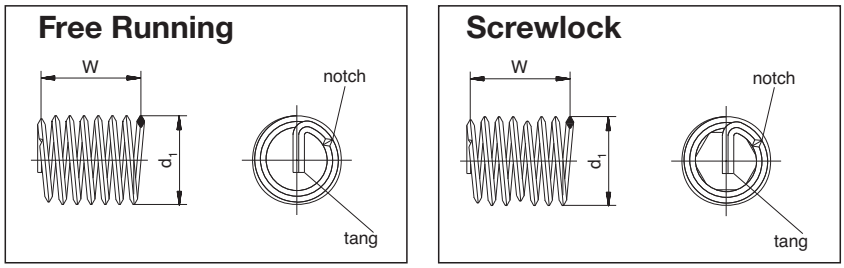
| Diameter (d) | Article number |
|---|---|
| M 3 ; UNC 4-40 -UNC 5-40 ; UNF 4-48 | 01680403000 |
| M 4 ; UNC 6-32 - UNC 8-32 ; UNF 6-40 - UNF 8-36 | 01680404000 |
| M 5 ; UNC 10-24 - UNC 12-24 ; UNF 10-32 | 01680405000 |
| M 6 ; UNC 1/4"-20 ; UNF 1/4"-28 | 01680406000 |
| M 8 ; UNC 5/16"-18 ; UNF 5/16"-24 | 01680408000 |
| M 10 ; UNC 3/8"-16 - UNC 7/16"-14 ; UNF 3/8"-24 - UNF 7/16"-20 | 01680410000 |
| M 12 ; UNC 1/2"-13 ; UNF 1/2"-20 | 01680412000 |

All technical data refer to the measure mm



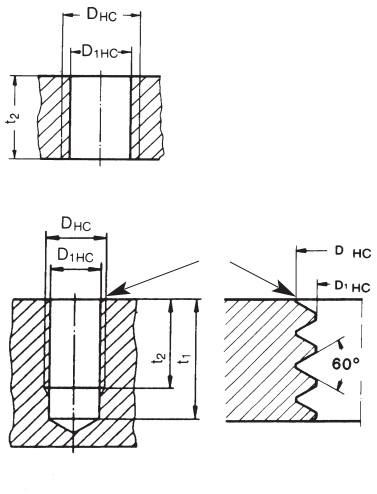
All technical data without obligation. Subject to technical changes and errors.

# **HELICOIL® Plus** thread inserts

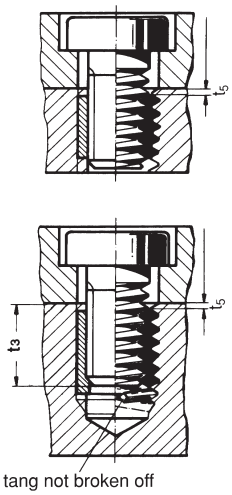



W and $d_1$ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

**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


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