Twist drill for HELICOIL® Plus and HELICOIL® Classic

Type 0149.5 for HELICOIL® Plus and HELICOIL® Classic



Twist drill type 0149.5 for tap drilling for HELICOIL® Plus and HELICOIL® Classic.

Properties:

- Version as per DIN 338
- Helix angle, web thickness and web taper standard

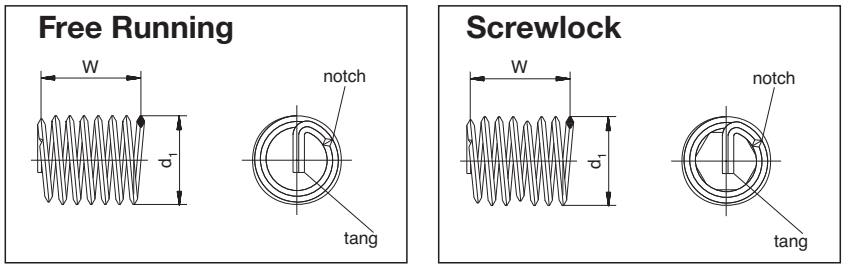
Technical information can be found on the last page.

Diameter (d)	Article number	Length (l) nominal size
2.1	01495021000	49
2.4	01495024000	57
2.6	01495026000	57
2.7	01495027000	61
3	01495030000	61
3.1	01495031000	65
3.2	01495032000	65
3.4	01495034000	70
3.7	01495037000	70
3.8	01495038000	75
4.2	01495042000	75
4.4	01495044000	80
4.5	01495045000	80
5.1	01495051000	86
5.2	01495052000	86
5.8	01495058000	93
6.3	01495063000	101
6.7	01495067000	101
7.3	01495073000	109
7.6	01495076000	117
9.4	01495094000	125
10.25	01495102500	89
10.4	01495104000	133

All technical data refer to the measure mm

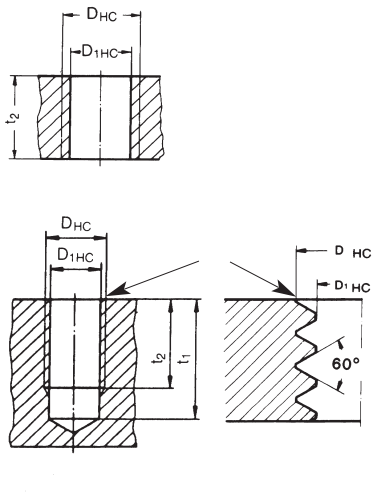
All technical data without obligation. Subject to technical changes and errors.

HELICOIL® Plus thread inserts

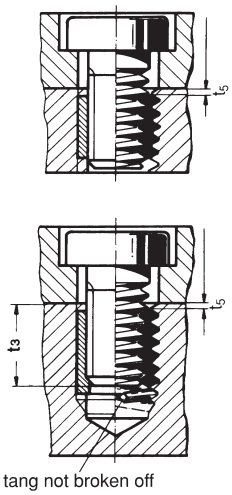


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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

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