

## HELICOIL® manual installation tool

The H-PMG manual installation tool allows an easy installation of HELICOIL® Classic and HELICOIL® Plus thread inserts. The tool features a leader cartridge, a pitch-controlled threaded mandrel and a depth stop and fits metric coarse threads.



**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:**

- Smooth mandrel
- Pitch-controlled
- 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) |
|-----------------|----------------|--------------|
| M6              | 01500406000    | 1.00         |
| M8              | 01500408000    | 1.25         |
| M9              | 01500409000    | 1.25         |
| M10             | 01500410000    | 1.50         |
| M11             | 01500411000    | 1.50         |
| M12             | 01500412000    | 1.75         |
| M14             | 01500414000    | 2.00         |
| M15             | 01500415000    | 2.00         |
| M16             | 01500416000    | 2.00         |

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts



W and d<sub>1</sub> 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
- P = Thread pitch
- d<sub>1</sub> = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- D<sub>HC</sub> = Outside diameter of the parent thread
- D<sub>1HC</sub> = Crest diameter
- B = Suitable twist drill diameter. Please note: D<sub>1HC</sub> is critical for selecting the correct twist drill diameter.
- t<sub>1</sub> = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t<sub>2</sub> = 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<sub>3</sub> = Maximum screw-in depth when the tang is not removed
- t<sub>5</sub> = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> 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<sub>1</sub> and t<sub>2</sub>.

All technical data refer to the measure mm

