

# HELICOIL® Plus Kit - Thread repair

M14 x 1.5 | 1 dimension in 1 length

HELICOIL® kit - thread repair for wheel bolt threads - TÜV-certified (TÜV: German Technical Inspection Association).

**Delivery scope:**

- HELICOIL® Plus thread inserts
- Combined HELICOIL® drilling and tapping tool (special version) - 2 in 1
- Caulking tool
- HELICOIL® Plus installation mandrel
- Tang break-off pliers
- Practical case for storage and transport
- Operating instructions



For Audi, SEAT, Skoda and VW: OEM number 1J0 407 613 B/1J0 407 613 C/1J0 407 613 G.

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D <sub>HC</sub> min.	D <sub>1HC</sub>		Nominal length t <sub>2</sub>	B	d <sub>1</sub>	
				min.	max.			min.	max.
M 14x1.5	41859144003	1.5	15.95	14.38	14.56	9	14.5	16.8	17.2

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

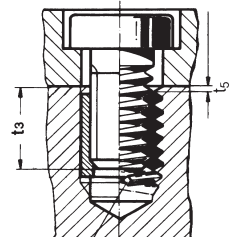
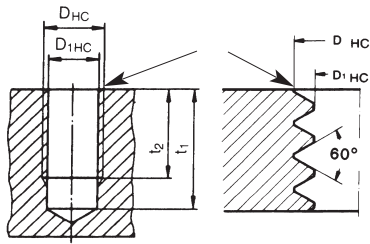


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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
- 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  $1 \times P$  to values  $t_1$  and  $t_2$ .

All technical data refer to the measure mm

