

HELICOIL® Kits Twinsert

M 3 - M 12 | 1 dimension | Type Free Running

HELICOIL® Plus Twinsert repair kit to correct and repair extensively stripped or too large tapped holes.

Properties:

- Outer and inner HELICOIL® Plus of Free Running type

Contains:

- A number of HELICOIL® Plus pairs (consisting of one outer and one inner insert each)
- 1 twist drill for tap drilling for the outer HELICOIL® Plus insert (up to M8)
- 1 HELICOIL® tap for the outer insert
- 1 installation mandrel each for the inner and outer HELICOIL® Plus insert
- 1 tang break-off tool (not from M12)
- Practical case for storage and transport
- Operating instructions

Note:

- 20 HELICOIL® Plus pairs up to M6
- 10 HELICOIL® Plus pairs from M8
- From M12, the tang is removed in a practical way using snipe nose pliers.

Since the inner HELICOIL® Plus is the standard length, the HELICOIL® Plus Twinsert is one thread longer which must be taken into consideration for the length of the holding thread. If that thread length is not available, both HELICOIL® Plus inserts must be shortened accordingly.

Technical information can be found on the last page.



Diameter (d)	Article number	D _{HC} nominal size	D _{1HC}		Nominal length t ₂ (x d)	Nominal length t ₂
			min.	max.		
M 2.5	41859250942	3.68	3.18	3.28	2.0	5.45
M 3	41859030941	4.31	3.76	3.87	1.5	5.00
	41859030942				2.0	6.50
M 4	41859040941	5.83	5.06	5.20	1.5	6.70
	41859040942				2.0	8.70
M 5	41859050941	7.08	6.21	6.37	1.5	8.30
	41859050942				2.0	10.80
M 6	41859060941	8.59	7.52	7.71	1.5	10.00
	41859060942				2.0	13.00
M 8	41859080941	11.23	9.90	10.11	1.5	13.25
	41859080942				2.0	17.25
M 10	41859100941	13.86	12.27	12.51	1.5	16.50
	41859100942				2.0	21.50
M 12	41859120941	16.49	14.65	14.92	1.5	19.75
	41859120942				2.0	25.75
M 16	41859160941	21.12	19.03	19.33	1.5	26.00

All technical data refer to the measure mm



HELICOIL® Plus thread inserts

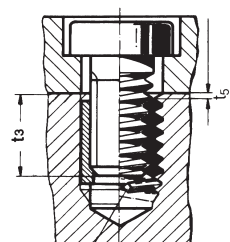
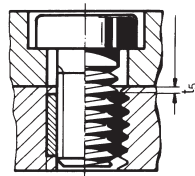


W and d₁ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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
- d₁ = 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.
- t₁ = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t₂ = 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.
- t₃ = Maximum screw-in depth when the tang is not removed
- t₅ = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t₂ 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 t₁ and t₂.

All technical data refer to the measure mm

