HELICOIL® Plus electrical installation tool

To easily and economically install HELICOIL® Plus thread inserts

The following sizes can be processed:

- M4 to M10
- UNC 8-32 to UNC 3/8"-16
- UNF 8-36 to UNF 3/8"-24

Note:

- Processing with installation mandrels (to be ordered separately)

Properties:

- Idle speed 1,200 rpm (continuously adjustable)
- Automatic reversal of the direction of rotation when the screw-in depth is reached
- Torque: 0.9 Nm–3 Nm (continuously adjustable at the control unit)
- Tool holder: quick-change chuck 1⁄4" hexagon socket with radial bearing for installation mandrel
- Weight: 0.57 kg

Delivery scope:

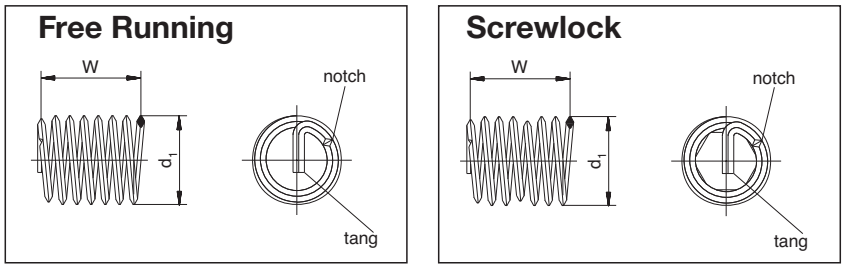
- Straight screwdriver with quick-change chuck
- Speed control with ramp control on the control unit, type EDU 2AE
- Case

Technical information can be found on the last page.

Diameter (d)	Article number	Weight g
M 4 - M 10	41605400000	570

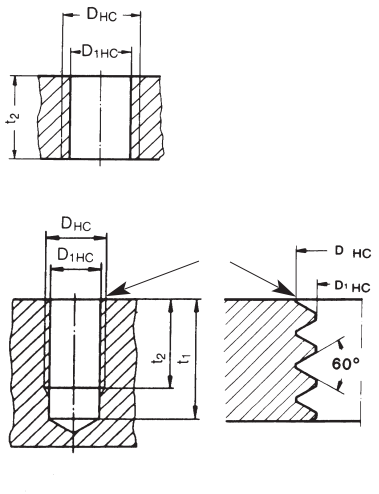
All technical data refer to the measure mm

HELICOIL® Plus thread inserts

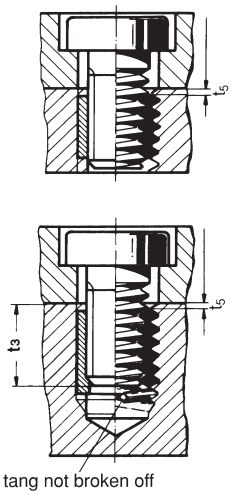


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



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