

# HELICOIL® Plus pneumatic installation tool

with prewinder | For fast processing of HELICOIL® Plus M16 - M26x1,5

P-PSG 1626 pneumatic installation tool with leader cartridge to process HELICOIL® Classic, HELICOIL® Plus Free Running and Screwlock thread inserts. It is recommended to be used in medium and large series for bulk material processing.

Complete tool with a size-specific exchange unit (further exchange units must be ordered separately).



**Properties:**

- Pitch-controlled
- Reversible compressed-air motor from the BOSCH Company
- Adjustment of the installation depth through changing compensation washers
- Connection: 4.0–6.0 bar
- Air consumption: 282 l/min
- Diameter: 42 mm
- Length: 440 mm
- Weight: 2.5 kg

**Note:**

Features a sliding sleeve for finger protection to avoid accidents. This finger guard shall not be removed.

**Alternative devices:**

- P-PSG 256 (for small sizes, metric and imperial)
- P-PSG 714 (for medium sizes, metric and imperial)

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
M 16	01601916000	2.0
M 16x1.5	01601916400	1.5
M 18x1.5	01601918400	1.5
M 20	01601920000	2.5
M 20x1.5	01601920400	1.5
M 22x1.5	01601922400	1.5
M 24x1.5	01601924400	1.5
M 26x1.5	01601926400	1.5

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

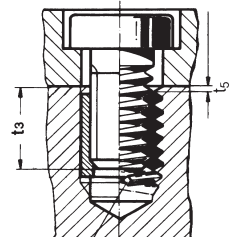
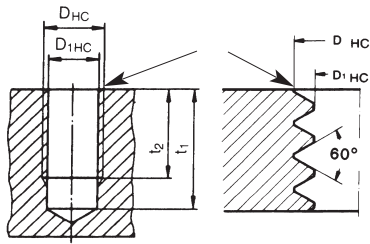


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

