

HELICOIL® Plus pneumatic installation tool

with prewinder | For fast processing of HELICOIL® Plus

P-PSG 714 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: 4.0–5.0 bar
- Air consumption: 282 l/min
- Diameter: 42 mm
- Length: 360 mm
- Weight: 1.4 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 1626 (for large sizes, metric)
- P-PSG 714 SF (to process magazined thread inserts)

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
UNF 5/16"-24	01602876700	1.05
UNF 3/8"-24	01602877700	1.05
UNF 7/16"-20	01602878700	1.27
UNC 1/2"-13	01602879600	1.95
UNF 1/2"-20	01602879700	1.27
M 8	01602808000	1.25
M 8x1	01602808300	1.00
M 10	01602810000	1.50
M 10x1	01602810300	1.00
M 10x1.25	01602810900	1.25
M 12	01602812000	1.75
M 12x1.25	01602812900	1.25
M 12x1.5	01602812400	1.50
M 14	01602814000	2.00
M 14x1.5	01602814400	1.50

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

