HELICOIL[®] Plus Kit - Thread repair

M10 x 1 - M14 x 1,25 | 1 size in 3 lengths

HELICOIL® kit - to repair spark plug and glow plug threads.

Delivery scope:

 \bullet HELICOIL $^{\otimes}$ Plus thread inserts of the same size and in three different lengths (1 d, 1.5 d, 2 d)

- Combined HELICOIL[®] drilling and tapping tool 2 in 1
- \bullet HELICOIL $^{\ensuremath{\mathbb{R}}}$ Plus installation mandrel
- Practical case for storage and transport
- Operating instructions

Technical information can be found on the last page.



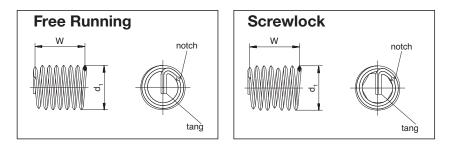
Diameter	Article number	Pitch	D _{HC}	D _{1HC}			d ₁	
(d)		(P)	min.	min.	max.	В	min.	max.
M 10x1	41851103100	1.00	11.30	10.22	10.41	10.25	12.1	12.5
M 12x1.25	41851129100	1.25	13.62	12.27	12.48	12.25	14.4	14.8
M 14x1.25	41851149100	1.25	15.62	14.27	14.48	14.25	16.8	17.2



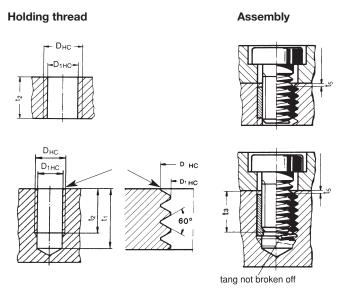
Böllhoff Group · Archimedesstr. 1-4 · 33649 Bielefeld · Phone: +49 521 4482-1387 · fat@boellhoff.com · eshop.boellhoff.de/en/home

This document was generated automatically. Subject to technical changes and errors. Distribution as well as duplication of this document, its utilisation and communication of its content only permitted with express consert.

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.



Prior to tapping, counter-bore 90° and deburr. Outside diameter of **countersink** = D_{HC} + 0.1 mm.

- d = Nominal thread diameter
- P = Thread pitch
- $d_1 \quad = \mbox{ Outside diameter of thread insert prior to installation} \\$
- W = Number of threads prior to installation
- D_{HC} = Outside diameter of the parent thread
- D_{1HC} = Crest diameter
 - = 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)
 - = 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.
 - = Maximum screw-in depth when the tang is not removed
 - Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t₂ corresponds to the abovementioned 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 $t_2.$

t₂

t3

 t_5



В

Böllhoff Group · Archimedesstr. 1-4 · 33649 Bielefeld · Phone: +49 521 4482-1387 · fat@boellhoff.com · eshop.boellhoff.de/en/home

This document was generated automatically. Subject to technical changes and errors. Distribution as well as duplication of this document, its utilisation and communication of its content only permitted with express consert.