

## Plug gauge for HELICOIL® holding threads according to DIN 8140-T2 tolerance class 5H (6H mod.)

Plug gauge to check if holding threads for HELICOIL® thread inserts which have been produced with a threading tool are true to gauge.

For metric coarse and fine threads. Complies with tolerance class 5H (6H mod.) as per DIN 8140-2.

Technical information can be found on the last page.



Diameter (d)	Article number	Pitch (P)
M 2	01473020500	0.40
M 2.5	01473250500	0.45
M 3	01473030500	0.50
M 3.5	01473350500	0.60
M 4	01473040500	0.70
M 5	01473050500	0.80
M 6	01473060500	1.00
M 7	01473070500	1.00
M 8	01473080500	1.25
M 8x1	01473083500	1.00
M 9	01473090500	1.25
M 10	01473100500	1.50
M 10x1	01473103500	1.00
M 10x1.25	01473109500	1.25
M 11	01473110500	1.50
M 12	01473120500	1.75
M 12x1	01473123500	1.00
M 12x1.25	01473129500	1.25
M 12x1.5	01473124500	1.50
M 14	01473140500	2.00
M 14x1.5	01473144500	1.50
M 16	01473160500	2.00
M 16x1.5	01473164500	1.50
M 18	01473180500	2.50
M 18x1.5	01473184500	1.50
M 18x2	01473185500	2.00
M 20	01473200500	2.50
M 20x1.5	01473204500	1.50
M 22	01473220500	2.50
M 22x1.5	01473224500	1.50
M 24	01473240500	3.00
M 24x1.5	01473244500	1.50
M 24x2	01473245500	2.00
M 26x1.5	01473264500	1.50
M 27	01473270500	–
M 27x1.5	01473274500	1.50
M 27x2	01473275500	2.00
M 30	01473300500	3.50
M 30x1.5	01473304500	1.50
M 30x2	01473305500	2.00
M 33	01473330500	3.50
M 33x2	01473335500	2.00

All technical data refer to the measure mm



## Plug gauge for HELICOIL<sup>®</sup> holding threads

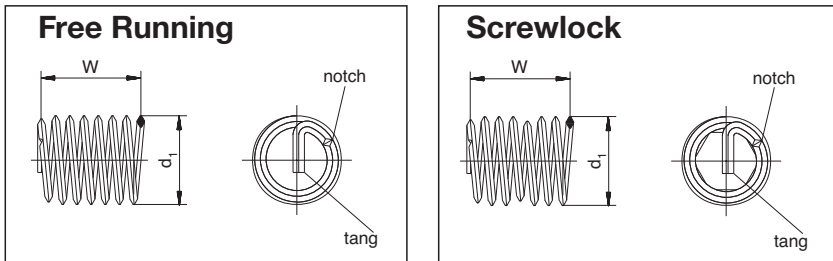
according to DIN 8140-T2 tolerance class 5H (6H mod.)

Diameter (d)	Article number	Pitch (P)
M 36	01473360500	4.00
M 36x1.5	01473364500	1.50
M 36x2	01473365500	2.00
M 36x3	01473366500	3.00

All technical data refer to the measure mm

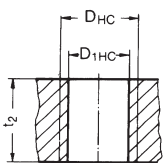


## HELICOIL® Plus thread inserts

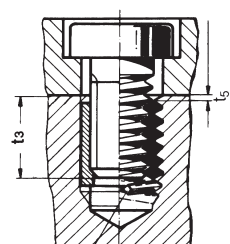
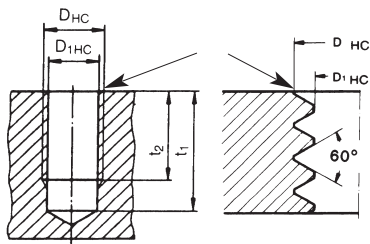
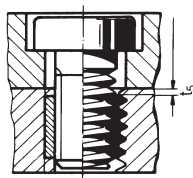


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

