

# HELICOIL® manual taps

Type 0140.0 | UNC

Short machine tap to create a holding thread (acc. to NASM33537) for HELICOIL® coil thread inserts.

**Properties:**

- For through holes
- For blind holes (only if sufficient chip space is provided)
- Machining of materials with 700 N/mm<sup>2</sup> strength max.
- Tolerance class 6H mod. corresponds with 5H

**Note:**

Only suited for blind holes if sufficient chip space is provided. Minimum requirement: 1 d deeper than the full thread length.

The short machine tap can also be used as a machine tap.

Technical information can be found on the last page.



Diameter (d)	Article number	Pitch (P)
UNC 1/4"-20	01400746104	1.27
UNC 5/16"-18	01400766104	1.41
UNC 3/8"-16	01400776104	1.58
UNC 7/16"-14	01400786104	1.81
UNC 1/2"-13	01400796104	1.95
UNC 9/16"-12	01400806104	2.12
UNC 5/8"-11	01400816104	2.31
UNC 3/4"-10	01400836104	2.54
UNC 7/8"-9	01400856104	2.82
UNC 1"-8	01400866104	3.18
UNC 1 1/8"-7	01400876104	3.63
UNC 1 1/4"-7	01400886104	3.63
UNC 1 3/8"-6	01400896104	4.23
UNC 1 1/2"-6	01400906104	4.23
UNC 2-56	01400636104	0.43
UNC 4-40	01400656104	0.63
UNC 5-40	01400666104	0.63
UNC 6-32	01400676104	0.79
UNC 8-32	01400686104	0.79
UNC 10-24	01400696104	1.05
UNC 12-24	01400706104	1.05

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

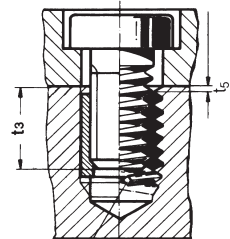


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

