

HELICOIL® mechanical thread former

for holding threads according to DIN 8140-2 tolerance class 5H (6H mod.)

HELICOIL® forming tap for the chipless production of tolerance class 5H (6H mod.) holding threads for HELICOIL® thread inserts. The forming tap features lubrication grooves to provide for proper lubrication also for large depths.



Properties:

- For blind hole and through hole threads
- Lubrication grooves
- Cutting speed equals tapping speed

Lubrication:

- Oil-containing lubricants or grease-containing emulsions

Material range:

- Aluminium, copper and zinc alloys
- Steel with 700 N/mm² strength max. (1 N/mm² corresponds with 1 MPa)
- Soft stainless steels
- For materials with a minimum elongation at break of 10 %

Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
M 3	01441030004	0.50
M 4	01441040004	0.70
M 5	01441050004	0.80
M 6	01441060004	1.00
M 8	01441080004	1.25
M 10	01441100004	1.50
M 12	01441120004	1.75

All technical data refer to the measure mm



HELICOIL® Plus thread inserts

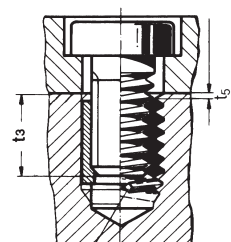
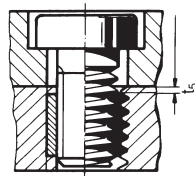


W and d₁ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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

