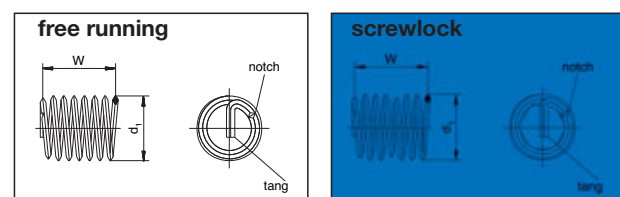


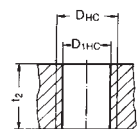
HELICOIL® plus Thread Inserts



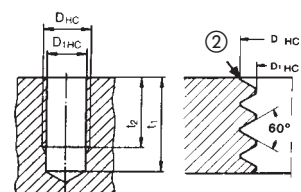
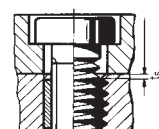
The free running and screwlock thread insert control values are W and d₁, when not inserted.

Its length can only be measured when the insert is in position.

Holding thread



Composition



tang not broken off

- d = thread diameter
- P = pitch
- d₁ = outer diameter of thread insert prior to installation
- W = number of coils prior to installation
- D_{Hc} = outer thread of tapped hole
- D_{1Hc} = thread core diameter
- B = recommended twist drill diameter
- t₁ = minimum depth of core hole according to DIN 76 Part 1
- t₂ = nominal length of thread insert and minimum length of holding thread
- t₃ = maximum screw-in depth if tang has not been broken off
- t₅ = distance of thread insert from separating surface = 0.25 P, if t₂ complies with the above mentioned minimum value

② 90° countersinking or deburring before tapping:
Countersinking diameter = D_{Hc} + 0,1 mm.

■ Angle of pressure 60° with UNC/UNF.
Deviating is valid for G-pipe threads of the angles of pressure 55° and for BA Thread 48°.

■ By utilisation of HELICOIL® plus thread inserts in series production it is recommended that the values t₁ and t₂ at a minimum however the size of 1 x P is always added.

① Materials or surfaces are always to be recorded with the 5th digit of the ordering ref. no.:

Example:

- 0 = Stainless steel A 2, X 5 CrNi 18 10
 - 1 = Bronze, CuSn 6
 - 2 = Nimonic 90, NiCr 20 Co 18 Ti, silver plated*
 - 3 = Stainless steel A 4, X 6 CrNiMoTi 17 12 2
 - 4 = Inconel X 750, NiCr 15 fe 7 TiAl, silver plated*
 - 5 = Inconel X 750, NiCr 15 fe 7 TiAl, polished
 - 6 = Stainless steel A 2, X 5 CrNi 18 10, cadmium plated
 - 7 = Stainless steel A 2, X 5 CrNi 18 10, magazine loaded**
 - 8 = Bronze, CuSn 6, magazine loaded**
- Other materials upon request

* utilise special tools
** see pages 20 and 21

All dimensions in mm. Subject to technical modifications.

Thread Inserts HELICOIL® plus – UNC/NC = American National Coarse threads

d	P	t ₂ min.*			d ₁ min. max.	D _{1Hc} min. max.	B	t ₃ max.	D _{Hc} min.	free running Order no. ①	screwlock Order no. ①
		x d	mm	W							
2-56	0.435	1 d	2.2	3.0	2.7 2.9	2.28 2.44	2.4	1.8 2.9 3.9 5.0	2.84	4130 063 6004	4132 063 6004
		1.5 d	3.3	5.25						4130 063 6006	4132 063 6006
		2 d	4.4	7.4						4130 063 6008	4132 063 6008
		2.5 d	5.5	9.6						4130 063 6010	4132 063 6010
4-40	0.635	1 d	2.9	2.8	3.6 4.0	3.00 3.15	3.1	2.5 3.9 5.4 6.8	3.67	4130 065 6004	4132 065 6004
		1.5 d	4.3	4.8						4130 065 6006	4132 065 6006
		2 d	5.8	6.8						4130 065 6008	4132 065 6008
		2.5 d	7.2	8.8						4130 065 6010	4132 065 6010
5-40	0.635	1 d	3.2	3.3	4.0 4.4	3.33 3.48	3.4	2.8 4.3 6.0 7.5	4.00	4130 066 6004	4132 066 6004
		1.5 d	4.8	5.5						4130 066 6006	4132 066 6006
		2 d	6.4	7.8						4130 066 6008	4132 066 6008
		2.5 d	7.9	10.0						4130 066 6010	4132 066 6010
6-32	0.794	1 d	3.5	2.8	4.5 4.9	3.68 3.89	3.8	3.1 4.9 6.6 8.4	4.54	4130 067 6004	4132 067 6004
		1.5 d	5.3	4.8						4130 067 6006	4132 067 6006
		2 d	7.0	6.7						4130 067 6008	4132 067 6008
		2.5 d	8.8	8.7						4130 067 6010	4132 067 6010
8-32	0.794	1 d	4.2	3.5	5.2 5.6	4.34 4.52	4.4	3.8 5.9 8.0 10.1	5.20	4130 068 6004	4132 068 6004
		1.5 d	6.3	5.9						4130 068 6006	4132 068 6006
		2 d	8.3	8.3						4130 068 6008	4132 068 6008
		2.5 d	10.5	10.7						4130 068 6010	4132 068 6010
10-24	1.058	1 d	4.8	2.9	6.2 6.6	5.06 5.28	5.2	4.3 6.7 9.1 11.6	6.20	4130 069 6004	4132 069 6004
		1.5 d	7.2	5.0						4130 069 6006	4132 069 6006
		2 d	9.6	7.1						4130 069 6008	4132 069 6008
		2.5 d	12.1	9.2						4130 069 6010	4132 069 6010
12-24	1.058	1 d	5.5	3.5	6.8 7.2	5.72 5.92	5.8	5.0 7.7 10.5 13.2	6.86	4130 070 6004	4132 070 6004
		1.5 d	8.2	5.9						4130 070 6006	4132 070 6006
		2 d	11.0	8.3						4130 070 6008	4132 070 6008
		2.5 d	13.7	10.7						4130 070 6010	4132 070 6010
1/4"-20	1.270	1 d	6.4	3.4	8.0 8.4	6.62 6.86	6.7	5.8 8.9 12.1 15.3	8.00	4130 074 6004	4132 074 6004
		1.5 d	9.5	5.7						4130 074 6006	4132 074 6006
		2 d	12.7	8.0						4130 074 6008	4132 074 6008
		2.5 d	15.9	10.3						4130 074 6010	4132 074 6010
5/16"-18	1.411	1 d	7.9	4.0	9.7 10.2	8.24 8.49	8.4	7.2 11.2 15.2 19.1	9.77	4130 076 6004	4132 076 6004
		1.5 d	11.9	6.6						4130 076 6006	4132 076 6006
		2 d	15.9	9.3						4130 076 6008	4132 076 6008
		2.5 d	19.8	11.9						4130 076 6010	4132 076 6010
3/8"-16	1.588	1 d	9.5	4.4	11.5 12.0	9.89 10.12	10.0	8.7 13.5 18.3 23.0	11.59	4130 077 6004	4132 077 6004
		1.5 d	14.3	7.2						4130 077 6006	4132 077 6006
		2 d	19.1	10.1						4130 077 6008	4132 077 6008
		2.5 d	23.8	12.9						4130 077 6010	4132 077 6010

*Other lengths upon request.

① see folding page 9b

Further thread inserts on the following pages

Thread Inserts HELICOIL® plus – UNC/NC = American National Coarse threads

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ①	screwlock Order no. ①
		x d	mm								
7/16"-14	1.814	1 d	11.1	4.5	13.4	11.51	11.6	10.2	13.47	4130 078 6004	4132 078 6004
		1.5 d	16.7	7.4						4130 078 6006	4132 078 6006
		2 d	22.2	10.3						4130 078 6008	4132 078 6008
		2.5 d	27.8	13.1						4130 078 6010	4132 078 6010
1/2"-13	1.954	1 d	12.7	4.8	15.2	13.12	13.2	11.7	15.24	4130 079 6004	4132 079 6004
		1.5 d	19.1	7.9						4130 079 6006	4132 079 6006
		2 d	25.4	10.9						4130 079 6008	4132 079 6008
		2.5 d	31.8	13.9						4130 079 6010	4132 079 6010

Thread Inserts HELICOIL® – UNC/NC

9/16"-12	2.117	1 d	14.3	5.1	17.0	14.75	14.9	13.2	17.04	0130 080 6004	0132 080 6004
		1.5 d	21.5	8.3						0130 080 6006	0132 080 6006
		2 d	28.6	11.5						0130 080 6008	0132 080 6008
		2.5 d	35.7	14.7						0130 080 6010	0132 080 6010
5/8"-11	2.309	1 d	15.9	5.3	18.9	16.38	16.6	14.7	18.88	0130 081 6004	0132 081 6004
		1.5 d	23.8	8.3						0130 081 6006	0132 081 6006
		2 d	31.8	11.8						0130 081 6008	0132 081 6008
		2.5 d	39.7	15.0						0130 081 6010	0132 081 6010
3/4"-10	2.540	1 d	19.1	5.9	22.4	19.60	19.7	17.8	22.35	0130 083 6004	0132 083 6004
		1.5 d	28.6	9.4						0130 083 6006	0132 083 6006
		2 d	38.1	13.0						0130 083 6008	0132 083 6008
		2.5 d	47.6	16.6						0130 083 6010	0132 083 6010
7/8"-9	2.822	1 d	22.2	6.3	26.0	22.84	23.0	20.8	25.89	0130 085 6004	–
		1.5 d	33.3	10.0						0130 085 6006	–
		2 d	44.5	13.7						0130 085 6008	–
		2.5 d	55.6	17.4						0130 085 6010	–
1"-8	3.175	1 d	25.4	6.4	29.6	26.09	26.2	23.8	29.53	0130 086 6004	–
		1.5 d	38.1	10.2						0130 086 6006	–
		2 d	50.8	14.0						0130 086 6008	–
		2.5 d	63.5	17.8						0130 086 6010	–
1 1/8"-7	3.629	1 d	28.6	6.3	33.4	29.36	29.5	26.8	33.29	0130 087 6004	–
		1.5 d	42.9	10.0						0130 087 6006	–
		2 d	57.2	13.8						0130 087 6008	–
		2.5 d	–	–						0130 087 6010	–
1 1/4"-7	3.629	1 d	31.8	7.1	36.7	32.54	33.0	30.0	36.46	0130 088 6004	–
		1.5 d	47.6	11.3						0130 088 6006	–
		2 d	63.5	15.4						0130 088 6008	–
		2.5 d	–	–						0130 088 6010	–
1 3/8"-6	4.234	1 d	34.9	6.6	40.6	35.84	36.0	32.8	40.42	0130 089 6004	–
		1.5 d	52.4	10.6						0130 089 6006	–
		2 d	69.9	14.4						0130 089 6008	–
		2.5 d	–	–						0130 089 6010	–
1 1/2"-6	4.234	1 d	38.1	7.4	43.9	39.02	39.5	36.0	43.60	0130 090 6004	–
		1.5 d	57.2	11.6						0130 090 6006	–
		2 d	76.2	15.9						0130 090 6008	–
		2.5 d	–	–						0130 090 6010	–

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® plus – UNF/NF = American National Fine threads

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ①	screwlock Order no. ①
		x d	mm								
4-48	0.529	1 d	2.8	3.4	3.7 4.1	2.97 3.12	3.0	2.5	3.53	4130 065 7004	4132 065 7004
		1.5 d	4.3	5.6				4.0		4130 065 7006	4132 065 7006
		2 d	5.7	7.9				5.4		4130 065 7008	4132 065 7008
		2.5 d	7.1	10.3				6.7		4130 065 7010	4132 065 7010
6-40	0.635	1 d	3.5	3.6	4.5 4.9	3.66 3.81	3.8	3.1	4.33	4130 067 7004	4132 067 7004
		1.5 d	5.3	6.0				4.9		4130 067 7006	4132 067 7006
		2 d	7.0	8.4				6.6		4130 067 7008	4132 067 7008
		2.5 d	8.8	10.8				8.4		4130 067 7010	4132 067 7010
8-36	0.706	1 d	4.2	4.0	5.3 5.7	4.32 4.47	4.4	3.8	5.08	4130 068 7004	4132 068 7004
		1.5 d	6.3	6.6				5.9		4130 068 7006	4132 068 7006
		2 d	8.3	9.1				7.9		4130 068 7008	4132 068 7008
		2.5 d	10.5	11.7				10.1		4130 068 7010	4132 068 7010
10-32	0.794	1 d	4.8	4.1	6.1 6.5	5.00 5.16	5.1	4.4	5.86	4130 069 7004	4132 069 7004
		1.5 d	7.2	6.8				6.8		4130 069 7006	4132 069 7006
		2 d	9.6	9.5				9.2		4130 069 7008	4132 069 7008
		2.5 d	12.1	12.1				11.7		4130 069 7010	4132 069 7010
1/4"-28	0.907	1 d	6.4	5.0	7.8 8.3	6.55 6.72	6.7	5.9	7.53	4130 074 7004	4132 074 7004
		1.5 d	9.5	8.1				9.0		4130 074 7006	4132 074 7006
		2 d	12.7	11.3				12.2		4130 074 7008	4132 074 7008
		2.5 d	15.9	14.4				15.4		4130 074 7010	4132 074 7010
5/16"-24	1.058	1 d	7.9	5.5	9.7 10.2	8.17 8.35	8.2	7.4	9.31	4130 076 7004	4132 076 7004
		1.5 d	11.9	8.9				11.4		4130 076 7006	4132 076 7006
		2 d	15.9	12.2				15.4		4130 076 7008	4132 076 7008
		2.5 d	19.8	15.6				19.3		4130 076 7010	4132 076 7010
3/8"-24	1.058	1 d	9.5	6.9	11.4 11.9	9.75 9.93	9.8	9.0	10.90	4130 077 7004	4132 077 7004
		1.5 d	14.3	10.9				13.8		4130 077 7006	4132 077 7006
		2 d	19.1	14.9				18.6		4130 077 7008	4132 077 7008
		2.5 d	23.8	19.0				23.3		4130 077 7010	4132 077 7010
7/16"-20	1.270	1 d	11.1	6.6	13.4 13.9	11.39 11.59	11.5	10.5	12.76	4130 078 7004	4132 078 7004
		1.5 d	16.7	10.6				16.1		4130 078 7006	4132 078 7006
		2 d	22.2	14.5				21.6		4130 078 7008	4132 078 7008
		2.5 d	27.8	18.4				27.2		4130 078 7010	4132 078 7010
1/2"-20	1.270	1 d	12.7	7.8	15.1 15.7	12.97 13.16	13.1	12.1	14.35	4130 079 7004	4132 079 7004
		1.5 d	19.1	12.3				18.5		4130 079 7006	4132 079 7006
		2 d	25.4	16.8				24.8		4130 079 7008	4132 079 7008
		2.5 d	31.8	21.3				31.2		4130 079 7010	4132 079 7010

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – UNF/NF = American National Fine threads

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no.①	screwlock Order no.②
		x d	mm								
9/16"-18	1.411	1 d	14.3	7.9	16.9	14.59	14.7	13.6	16.12	0130 080 7004	0132 080 7004
		1.5 d	21.5	12.5						0130 080 7006	0132 080 7006
		2 d	28.6	17.1						0130 080 7008	0132 080 7008
		2.5 d	35.7	21.6						0130 080 7010	0132 080 7010
5/8"-18	1.411	1 d	15.9	8.9	18.6	16.18	16.3	15.2	17.71	0130 081 7004	0132 081 7004
		1.5 d	23.8	14.1						0130 081 7006	0132 081 7006
		2 d	31.8	19.1						0130 081 7008	0132 081 7008
		2.5 d	39.7	24.3						0130 081 7010	0132 081 7010
3/4"-16	1.588	1 d	19.1	9.7	22.2	19.39	19.5	18.3	21.11	0130 083 7004	0132 083 7004
		1.5 d	28.6	15.1						0130 083 7006	0132 083 7006
		2 d	38.1	20.6						0130 083 7008	0132 083 7008
		2.5 d	47.7	26.0						0130 083 7010	0132 083 7010
7/8"-14	1.814	1 d	22.2	9.9	26.0	22.62	22.7	21.3	24.58	0130 085 7004	–
		1.5 d	33.3	15.4						0130 085 7006	–
		2 d	44.5	21.0						0130 085 7008	–
		2.5 d	55.6	26.6						0130 085 7010	–
1"-14	1.814	1 d	25.4	11.5	29.4	25.86	26.0	24.5	27.76	0130 086 9004	–
		1.5 d	38.1	17.9						0130 086 9006	–
		2 d	50.8	24.3						0130 086 9008	–
		2.5 d	63.5	30.6						0130 086 9010	–
1"-12	2.117	1 d	25.4	9.7	29.7	25.86	26.0	24.3	28.15	0130 086 7004	–
		1.5 d	38.1	15.1						0130 086 7006	–
		2 d	50.8	20.6						0130 086 7008	–
		2.5 d	63.5	26.1						0130 086 7010	–
1 1/8"-12	2.117	1 d	28.6	10.1	33.2	29.03	29.0	27.5	31.33	0130 087 7004	–
		1.5 d	42.9	17.3						0130 087 7006	–
		2 d	57.2	23.4						0130 087 7008	–
		2.5 d	–	–						0130 087 7010	–
1 1/4"-12	2.117	1 d	31.8	12.4	36.6	32.21	32.5	30.7	34.50	0130 088 7004	–
		1.5 d	47.6	19.3						0130 088 7006	–
		2 d	63.5	26.1						0130 088 7008	–
		2.5 d	–	–						0130 088 7010	–
1 3/8"-12	2.117	1 d	34.9	13.8	40.0	35.38	35.5	33.8	37.68	0130 089 7004	–
		1.5 d	52.4	21.3						0130 089 7006	–
		2 d	69.9	28.9						0130 089 7008	–
		2.5 d	–	–						0130 089 7010	–
1 1/2"-12	2.117	1 d	38.1	15.2	43.4	38.56	38.5	37.0	40.85	0130 090 7004	–
		1.5 d	57.2	23.4						0130 090 7006	–
		2 d	76.2	31.6						0130 090 7008	–
		2.5 d	–	–						0130 090 7010	–

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – BSW = British Standard Withworth Thread

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no.①	screwlock Order no.②
		x d	mm								
1/8"-40	0.635	1 d	3.2	3.4	4.0	3.28	3.4	2.8	3.93	0130 071 3004	–
		1.5 d	4.8	5.6				4.4		0130 071 3006	0132 071 3006
		2 d	6.4	7.9				6.0		0130 071 3008	0132 071 3008
		2.5 d	7.9	10.3				7.5		0130 071 3010	0132 071 3010
3/16"-24	1.058	1 d	4.8	2.9	6.1	4.98	5.1	4.3	6.01	0130 072 3004	–
		1.5 d	7.1	5.1				6.6		0130 072 3006	0132 072 3006
		2 d	9.6	6.1				9.1		0130 072 3008	0132 072 3008
		2.5 d	11.9	9.3				11.4		0130 072 3010	0132 072 3010
1/4"-20	1.270	1 d	6.4	3.4	7.9	6.63	6.7	5.8	7.84	0130 074 3004	–
		1.5 d	9.5	5.9				8.9		0130 074 3006	0132 074 3006
		2 d	12.7	8.1				12.1		0130 074 3008	0132 074 3008
		2.5 d	15.9	10.5				15.3		0130 074 3010	0132 074 3010
5/16"-18	1.411	1 d	7.9	4.1	9.7	8.33	8.5	7.2	9.59	0130 076 3004	0132 076 3004
		1.5 d	11.9	6.7				11.2		0130 076 3006	0132 076 3006
		2 d	15.9	9.4				15.2		0130 076 3008	0132 076 3008
		2.5 d	19.8	12.0				19.1		0130 076 3010	0132 076 3010
3/8"-16	1.588	1 d	9.5	4.5	11.5	9.91	10.0	8.7	11.39	0130 077 3004	0132 077 3004
		1.5 d	14.3	7.3				13.5		0130 077 3006	0132 077 3006
		2 d	19.1	10.2				18.3		0130 077 3008	0132 077 3008
		2.5 d	23.8	13.0				23.0		0130 077 3010	0132 077 3010
7/16"-14	1.814	1 d	11.1	4.6	13.5	11.51	11.6	10.2	13.24	0130 078 3004	0132 078 3004
		1.5 d	16.7	7.5				15.8		0130 078 3006	0132 078 3006
		2 d	22.2	10.4				21.3		0130 078 3008	0132 078 3008
		2.5 d	27.8	13.3				26.9		0130 078 3010	0132 078 3010
1/2"-12	2.117	1 d	12.7	4.4	15.4	13.08	13.2	11.6	15.17	0130 079 3004	0132 079 3004
		1.5 d	19.1	7.3				18.0		0130 079 3006	0132 079 3006
		2 d	25.4	10.1				24.3		0130 079 3008	0132 079 3008
		2.5 d	31.8	13.0				30.7		0130 079 3010	0132 079 3010
9/16"-12	2.117	1 d	14.3	5.2	17.0	14.68	14.8	13.2	16.76	0130 080 3004	0132 080 3004
		1.5 d	21.5	8.4				20.4		0130 080 3006	0132 080 3006
		2 d	28.6	11.6				27.5		0130 080 3008	0132 080 3008
		2.5 d	35.7	14.8				34.6		0130 080 3010	0132 080 3010
5/8"-11	2.309	1 d	15.9	5.4	18.9	16.59	16.7	14.7	18.57	0130 081 3004	0132 081 3004
		1.5 d	23.8	8.7				22.6		0130 081 3006	0132 081 3006
		2 d	31.8	11.9				30.6		0130 081 3008	0132 081 3008
		2.5 d	39.7	15.3				38.5		0130 081 3010	0132 081 3010
11/16"-11	2.309	1 d	17.5	6.1	20.5	18.21	18.3	16.3	20.16	0130 082 3004	0132 082 3004
		1.5 d	26.2	9.7				25.0		0130 082 3006	0132 082 3006
		2 d	34.9	13.3				33.7		0130 082 3008	0132 082 3008
		2.5 d	43.6	16.9				42.4		0130 082 3010	0132 082 3010

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – BSW = British Standard Withworth Thread

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no.①	screwlock Order no.①
		x d	mm								
3/4"-10	2.540	1 d	19.1	6.0	22.4 23.0	19.84 20.09	20.0	17.8	22.02	0130 083 3004	0132 083 3004
		1.5 d	28.6	9.6				27.3		0130 083 3006	0132 083 3006
		2 d	38.1	13.2				36.8		0130 083 3008	0132 083 3008
		2.5 d	47.6	16.8				46.3		0130 083 3010	0132 083 3010
7/8"-9	2.822	1 d	22.2	6.4	26.0 26.7	23.01 23.27	23.0	20.8	25.52	0130 085 3004	–
		1.5 d	33.3	10.1				31.9		0130 085 3006	–
		2 d	44.5	13.9				43.1		0130 085 3008	–
		2.5 d	55.6	17.7				54.2		0130 085 3010	–
1"-8	3.175	1 d	25.4	6.5	27.7 30.4	26.19 26.52	26.5	23.8	29.10	0130 086 3004	–
		1.5 d	38.1	10.3				36.5		0130 086 3006	–
		2 d	50.8	14.1				49.2		0130 086 3008	–
		2.5 d	63.5	17.9				61.9		0130 086 3010	–
1 1/8"-7	3.629	1 d	28.6	6.4	33.5 34.4	29.74 30.12	30.0	26.8	32.80	0130 087 3004	–
		1.5 d	42.9	10.1				41.1		0130 087 3006	–
		2 d	57.2	13.9				55.4		0130 087 3008	–
		2.5 d	–	–				–		0130 087 3010	–
1 1/4"-7	3.629	1 d	31.8	7.3	36.7 37.7	32.92 33.30	33.0	30.0	35.97	0130 088 3004	–
		1.5 d	47.6	11.4				45.8		0130 088 3006	–
		2 d	63.5	15.6				61.7		0130 088 3008	–
		2.5 d	–	–				–		0130 088 3010	–
1 1/2"-6	4.233	1 d	38.1	7.4	43.9 45.1	39.27 39.90	39.5	36.0	43.02	0130 090 3004	–
		1.5 d	57.2	11.8				55.1		0130 090 3006	–
		2 d	76.2	16.1				74.1		0130 090 3008	–
		2.5 d	–	–				–		0130 090 3010	–

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – BSF = British Standard Fine Thread

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ①	screwlock Order no. ①
		x d	mm								
3/16"-32	0.794	1 d	4.8	4.1	6.0	4.88	5.0	4.4	5.71	0130 072 5004	0132 072 5004
		1.5 d	7.1	6.8						0130 072 5006	0132 072 5006
		2 d	9.5	9.4						0130 072 5008	0132 072 5008
		2.5 d	11.9	12.1						0130 072 5010	0132 072 5010
7/32"-28	0.907	1 d	5.5	4.3	7.0	5.72	5.8	5.0	6.63	0130 073 5004	0132 073 5004
		1.5 d	8.3	7.0						0130 073 5006	0132 073 5006
		2 d	11.1	9.8						0130 073 5008	0132 073 5008
		2.5 d	13.9	12.5						0130 073 5010	0132 073 5010
1/4"-26	0.977	1 d	6.4	4.6	7.9	6.53	6.6	5.9	7.51	0130 074 5004	0132 074 5004
		1.5 d	9.5	7.6						0130 074 5006	0132 074 5006
		2 d	12.7	10.4						0130 074 5008	0132 074 5008
		2.5 d	15.9	13.4						0130 074 5010	0132 074 5010
9/32"-26	0.977	1 d	7.1	5.4	8.7	7.32	7.4	6.6	8.31	0130 075 5004	0132 075 5004
		1.5 d	10.7	8.7						0130 075 5006	0132 075 5006
		2 d	14.3	11.9						0130 075 5008	0132 075 5008
		2.5 d	17.9	15.3						0130 075 5010	0132 075 5010
5/16"-22	1.155	1 d	7.9	5.0	9.8	8.20	8.3	7.3	9.30	0130 076 5004	0132 076 5004
		1.5 d	11.9	8.1						0130 076 5006	0132 076 5006
		2 d	15.9	11.2						0130 076 5008	0132 076 5008
		2.5 d	19.8	14.3						0130 076 5010	0132 076 5010
3/8"-20	1.270	1 d	9.5	5.6	11.6	9.78	9.9	8.8	11.02	0130 077 5004	0132 077 5004
		1.5 d	14.3	9.0						0130 077 5006	0132 077 5006
		2 d	19.1	12.4						0130 077 5008	0132 077 5008
		2.5 d	23.8	15.8						0130 077 5010	0132 077 5010
7/16"-18	1.411	1 d	11.1	5.9	13.6	11.43	11.5	10.4	12.78	0130 078 5004	0132 078 5004
		1.5 d	16.7	9.5						0130 078 5006	0132 078 5006
		2 d	22.2	13.1						0130 078 5008	0132 078 5008
		2.5 d	27.8	16.6						0130 078 5010	0132 078 5010
1/2"-16	1.588	1 d	12.7	6.1	15.5	13.03	13.1	11.9	14.57	0130 079 5004	0132 079 5004
		1.5 d	19.1	9.7						0130 079 5006	0132 079 5006
		2 d	25.4	13.3						0130 079 5008	0132 079 5008
		2.5 d	31.8	16.9						0130 079 5010	0132 079 5010
9/16"-16	1.588	1 d	14.3	7.0	17.2	14.66	14.8	13.5	16.16	0130 080 5004	0132 080 5004
		1.5 d	21.5	11.1						0130 080 5006	0132 080 5006
		2 d	28.6	15.1						0130 080 5008	0132 080 5008
		2.5 d	35.7	19.3						0130 080 5010	0132 080 5010
5/8"-14	1.814	1 d	15.9	6.8	19.1	16.26	16.4	15.0	18.01	0130 081 5004	0132 081 5004
		1.5 d	23.8	10.8						0130 081 5006	0132 081 5006
		2 d	31.8	14.8						0130 081 5008	0132 081 5008
		2.5 d	39.7	18.7						0130 081 5010	0132 081 5010

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – BSF = British Standard Fine Thread

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ①	screwlock Order no. ①	
		x d	mm									
11/16"-14	1.814	1 d	17.5	7.6	20.8	17.86	18.0	16.6	19.60	0130 082 5004	0132 082 5004	
		1.5 d	26.2	11.9						25.3	0130 082 5006	0132 082 5006
		2 d	34.9	16.3						34.0	0130 082 5008	0132 082 5008
		2.5 d	43.6	20.8						42.7	0130 082 5010	0132 082 5010
3/4"-12	2.117	1 d	19.1	7.0	22.9	19.43	19.5	18.0	21.53	0130 083 5004	0132 083 5004	
		1.5 d	28.6	11.1						27.5	0130 083 5006	0132 083 5006
		2 d	38.1	15.2						37.0	0130 083 5008	0132 083 5008
		2.5 d	47.6	19.3						46.5	0130 083 5010	0132 083 5010
13/16"-12	2.117	1 d	20.6	7.7	24.6	21.03	21.2	19.5	23.12	0130 084 5004	–	
		1.5 d	30.9	12.1						29.9	0130 084 5006	–
		2 d	41.3	16.6						40.2	0130 084 5008	–
		2.5 d	51.6	21.1						50.5	0130 084 5010	–
7/8"-11	2.309	1 d	22.2	7.6	26.5	22.61	22.7	21.0	24.94	0130 085 5004	–	
		1.5 d	33.3	11.9						32.1	0130 085 5006	–
		2 d	44.5	16.4						43.3	0130 085 5008	–
		2.5 d	55.6	20.8						54.4	0130 085 5010	–
1"-10	2.540	1 d	25.4	7.9	30.2	26.19	26.5	24.1	28.38	0130 086 5004	–	
		1.5 d	38.1	12.5						36.8	0130 086 5006	–
		2 d	50.8	17.1						49.5	0130 086 5008	–
		2.5 d	63.5	21.6						62.6	0130 086 5010	–
1 1/8"-9	2.822	1 d	28.6	8.1	33.9	29.36	29.5	27.2	31.88	0130 087 5004	–	
		1.5 d	42.9	12.7						41.5	0130 087 5006	–
		2 d	57.2	17.3						55.8	0130 087 5008	–
		2.5 d	–	–						–	0130 087 5010	–
1 1/4"-9	2.822	1 d	31.8	9.1	37.3	32.54	32.5	30.4	35.06	0130 088 5004	–	
		1.5 d	47.6	14.3						46.2	0130 088 5006	–
		2 d	63.5	19.4						62.1	0130 088 5008	–
		2.5 d	–	–						–	0130 088 5010	–
1 3/8"-8	3.175	1 d	34.9	8.8	41.2	35.71	36.0	33.3	38.64	0130 089 5004	–	
		1.5 d	52.4	13.9						50.8	0130 089 5006	–
		2 d	69.9	18.9						68.3	0130 089 5008	–
		2.5 d	–	–						–	0130 089 5010	–
1 1/2"-8	3.175	1 d	38.1	9.8	44.6	38.89	39.0	36.5	41.82	0130 090 5004	–	
		1.5 d	57.2	15.3						55.6	0130 090 5006	–
		2 d	76.2	20.8						74.6	0130 090 5008	–
		2.5 d	–	–						–	0130 090 5010	–

*Other lengths upon request.

① see folding page 9b

Thread Inserts HELICOIL® – ISO 228/1 Pipe threads **

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ①	screwlock Order no. ①
		x d	mm								
G 1/8" – 28	0.907	1 d	3.2	1.9	11.5	9.91	10.0	2.7	10.82	4130 071 4004	–
		1.5 d	4.8	3.6				4.3		4130 071 4006	–
		2 d	6.4	5.1				5.9		4130 071 4008	–
		2.5 d	7.9	6.6				7.4		4130 071 4010	–
G 1/4" – 19	1.337	1 d	6.4	3.1	15.7	13.46	13.6	5.7	14.74	4130 074 4004	–
		1.5 d	9.5	5.3				8.8		4130 074 4006	–
		2 d	12.7	7.4				12.0		4130 074 4008	–
		2.5 d	15.9	9.6				15.2		4130 074 4010	–
G 3/8" – 19	1.337	1 d	9.5	5.3	19.5	17.02	17.1	8.8	18.25	4130 077 4004	–
		1.5 d	14.3	8.5				13.6		4130 077 4006	–
		2 d	19.1	11.8				18.4		4130 077 4008	–
		2.5 d	23.8	15.0				23.1		4130 077 4010	–
G 1/2" – 14	1.814	1 d	12.7	5.2	24.6	21.34	21.5	11.7	23.09	4130 079 4004	–
		1.5 d	19.1	8.4				18.1		4130 079 4006	–
		2 d	25.4	11.6				24.6		4130 079 4008	–
		2.5 d	31.8	14.8				30.8		4130 079 4010	–

Thread Inserts HELICOIL® – ISO 228/1 Pipe threads **

G 5/8" – 14	1.814	1 d	15.9	6.8	26.7	23.24	23.4	14.9	25.05	0130 081 4004	–
		1.5 d	23.8	10.8				22.8		0130 081 4006	–
		2 d	31.8	14.8				30.8		0130 081 4008	–
		2.5 d	39.7	18.8				38.7		0130 081 4010	–
G 3/4" – 14	1.814	1 d	19.1	8.4	30.5	26.75	27.0	18.1	28.59	0130 083 4004	–
		1.5 d	28.6	13.3				27.6		0130 083 4006	–
		2 d	38.1	18.1				37.1		0130 083 4008	–
		2.5 d	47.6	22.9				46.6		0130 083 4010	–
G 7/8" – 14	1.814	1 d	22.2	10.0	34.6	30.48	30.6	21.2	32.35	0130 085 4004	–
		1.5 d	33.3	15.6				32.3		0130 085 4006	–
		2 d	44.5	21.3				43.5		0130 085 4008	–
		2.5 d	–	–				–		0130 085 4010	–
G 1" – 11	2.309	1 d	25.4	8.9	38.4	33.53	33.7	24.3	35.96	0130 086 4004	–
		1.5 d	38.1	13.9				37.0		0130 086 4006	–
		2 d	50.8	19.0				49.7		0130 086 4008	–
		2.5 d	–	–				–		0130 086 4010	–
G 1 1/4" – 11	2.309	1 d	31.8	11.4	47.7	42.29	42.5	30.7	44.63	0130 088 4004	–
		1.5 d	47.6	17.8				46.5		0130 088 4006	–
		2 d	63.5	24.1				62.4		0130 088 4008	–
		2.5 d	–	–				–		0130 088 4010	–
G 1 1/2" – 11	2.309	1 d	38.1	13.9	54.1	48.41	48.5	37.0	50.53	0130 090 4004	–
		1.5 d	57.2	21.6				56.1		0130 090 4006	–
		2 d	–	–				–		0130 090 4008	–
		2.5 d	–	–				–		0130 090 4010	–

* Other lengths upon request.

**G ≙ BSP (British Standard Pipe thread)

① see folding page 9b

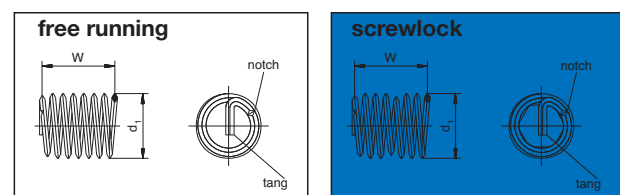
Thread Inserts HELICOIL® – BA = British Association Standard Thread

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order no. ^①	screwlock Order no. ^①
		x d	mm								
0 BA	1.00	1 d	6.0	4.3	7.4	6.12	6.2	5.5	7.12	0130 092 2004	–
		1.5 d	9.0	6.9				8.5		0130 092 2006	–
		2 d	12.0	9.6				11.5		0130 092 2008	–
		2.5 d	15.0	12.3				14.5		0130 092 2010	–
1 BA	0.90	1 d	5.3	4.1	6.5	5.41	5.5	4.8	6.31	0130 093 2004	–
		1.5 d	8.0	6.8				7.5		0130 093 2006	–
		2 d	10.6	9.4				10.1		0130 093 2008	–
		2.5 d	13.3	12.0				12.8		0130 093 2010	–
2 BA	0.81	1 d	4.7	4.0	5.8	4.85	4.9	4.3	5.61	0130 094 2004	–
		1.5 d	7.1	6.6				6.7		0130 094 2006	–
		2 d	9.4	9.0				9.0		0130 094 2008	–
		2.5 d	11.8	11.7				11.4		0130 094 2010	–
3 BA	0.73	1 d	4.1	3.9	5.1	4.22	4.3	3.7	4.92	0130 095 2004	–
		1.5 d	6.2	6.3				5.8		0130 095 2006	–
		2 d	8.2	8.8				7.8		0130 095 2008	–
		2.5 d	10.3	11.3				9.9		0130 095 2010	–
4 BA	0.66	1 d	3.6	3.7	4.5	3.73	3.8	3.3	4.35	0130 096 2004	–
		1.5 d	5.4	6.1				5.1		0130 096 2006	–
		2 d	7.2	8.4				6.9		0130 096 2008	–
		2.5 d	9.0	10.9				8.7		0130 096 2010	–
5 BA	0.59	1 d	3.2	3.6	4.0	3.28	3.3	2.9	3.87	0130 097 2004	–
		1.5 d	4.8	6.0				4.5		0130 097 2006	–
		2 d	6.4	8.4				6.1		0130 097 2008	–
		2.5 d	8.0	10.8				7.7		0130 097 2010	–
6 BA	0.53	1 d	2.8	3.5	3.6	2.87	2.9	2.5	3.40	0130 098 2004	–
		1.5 d	4.2	5.8				3.9		0130 098 2006	–
		2 d	5.6	8.0				5.3		0130 098 2008	–
		2.5 d	7.0	10.3				6.7		0130 098 2010	–

*Other lengths upon request.

① see folding page 9b

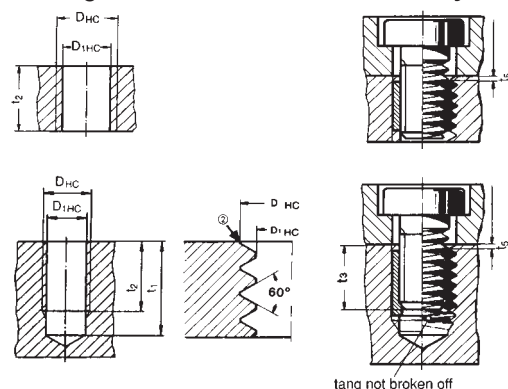
HELICOIL® plus thread inserts



The control values of not installed thread inserts free running and screwlock are W and d₁. This length can only be measured for installed thread inserts.

Holding thread

Assembly



- 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 holding thread
- D_{1HC} = crest diameter
- B = Suitable twist drill diameter. Please note: D_{1HC} is decisive for selecting the correct twist drill diameter.
- t₁ = minimum depth of tap 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 holding thread for blind holes or to the minimum plate thickness for a through hole.
- t₃ = maximum screw-in depth for not broken off tang
- t₅ = distance of the thread insert to the joint face = 0.25 to 0.5 P, if t₂ corresponds to the above-mentioned minimum value

② Prior to tapping, counter-bore 90° and deburr. Outside diameter of upset part = D_{HC} + 0.1 mm.

■ When HELICOIL® plus thread inserts are used in series production, we recommend to add at least 1 x P to values t₁ and t₂.

① Materials or surfaces are to be indicated with the 5th digit of the Order no:

Beispiel:

↓ 4130 002 0005

- 0 = stainless steel A2, X 5 CrNi 18 10
 - 1 = bronze, CuSn 6
 - 2 = Nimonic 90, NiCr 20 Co 18 Ti, silvered*
 - 3 = stainless steel A4, X 6 CrNiMoTi 17 12 2
 - 4 = Inconel X 750, NiCr 15 Fe 7 TiAl, silvered*
 - 5 = Inconel X 750, NiCr 15 Fe 7 TiAl, bright
 - 6 = stainless steel A2, X 5 CrNi 18 10, cadmium-plated
 - 7 = stainless steel A2, X 5 CrNi 18 10, magazined**
 - 8 = bronze, CuSn 6, magazined**
- Other materials on request.

* Use special tools.

** See page 18.

All measures in mm. Technical modifications reserved.

HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running	screwlock
		x d	mm							Order No ^①	Order No ^①
M 2	0.40	1 d	2.0	2.9	2.6 2.8	2.09 2.18	2.1	1.8 2.8 3.8 4.8 5.8	2.52	4130 002 0002	on request
		1.5 d	3.0	4.9						4130 002 0003	
		2 d	4.0	6.9						4130 002 0004	
		2.5 d	5.0	8.9						4130 002 0005	
		3 d	6.0	10.9					4130 002 0006		
M 2.5	0.45	1 d	2.5	3.5	3.3 3.5	2.60 2.70	2.6	2.3 3.5 4.8 6.0 7.3	3.08	4130 025 0025	4132 025 0025
		1.5 d	3.75	5.9						4130 025 0375	4132 025 0375
		2 d	5.0	8.1						4130 025 0005	4132 025 0005
		2.5 d	6.25	10.5						4130 025 0625	4132 025 0625
		3 d	7.5	12.9					4130 025 0075	4132 025 0075	
M 3	0.5	1 d	3.0	3.9	3.8 4.0	3.11 3.22	3.2	2.7 4.2 5.7 7.2 8.7	3.65	4130 003 0003	4132 003 0003
		1.5 d	4.5	6.3						4130 003 0045	4132 003 0045
		2 d	6.0	8.7						4130 003 0006	4132 003 0006
		2.5 d	7.5	11.1						4130 003 0075	4132 003 0075
		3 d	9.0	13.5					4130 003 0009	4132 003 0009	
M 3.5	0.6	1 d	3.5	3.7	4.42 4.60	3.63 3.76	3.7	3.2 5.0 6.7 8.5 10.2	4.28	4130 035 0035	4132 035 0035
		1.5 d	5.25	6.3						4130 035 0053	4132 035 0053
		2 d	7.0	8.7						4130 035 0007	4132 035 0007
		2.5 d	8.75	11.2						4130 035 0875	4132 035 0875
		3 d	10.5	13.3					4130 035 0105	4132 035 0105	
M 4	0.7	1 d	4.0	3.7	5.05 5.25	4.15 4.29	4.2	3.6 5.6 7.6 9.6 11.6	4.91	4130 004 0004	4132 004 0004
		1.5 d	6.0	6.1						4130 004 0006	4132 004 0006
		2 d	8.0	8.4						4130 004 0008	4132 004 0008
		2.5 d	10.0	10.9						4130 004 0010	4132 004 0010
		3 d	12.0	13.2					4130 004 0012	4132 004 0012	
M 5	0.8	1 d	5.0	4.3	6.35 6.6	5.17 5.33	5.2	4.6 7.1 9.6 12.1 14.6	6.04	4130 005 0005	4132 005 0005
		1.5 d	7.5	6.9						4130 005 0075	4132 005 0075
		2 d	10.0	9.7						4130 005 0010	4132 005 0010
		2.5 d	12.5	12.3						4130 005 0125	4132 005 0125
		3 d	15.0	14.8					4130 005 0015	4132 005 0015	
M 6	1.0	1 d	6.0	4.2	7.6 7.85	6.22 6.41	6.3	5.5 8.5 11.5 14.5 17.5	7.30	4130 006 0006	4132 006 0006
		1.5 d	9.0	6.9						4130 006 0009	4132 006 0009
		2 d	12.0	9.6						4130 006 0012	4132 006 0012
		2.5 d	15.0	12.3						4130 006 0015	4132 006 0015
		3 d	18.0	14.6					4130 006 0018	4132 006 0018	
M 7	1.0	1 d	7.0	5.3	8.65 8.9	7.22 7.41	7.3	6.5 10.0 13.5 17.0 20.5	8.30	4130 007 0007	4132 007 0007
		1.5 d	10.5	8.2						4130 007 0105	4132 007 0105
		2 d	14.0	11.1						4130 007 0014	4132 007 0014
		2.5 d	17.5	14.3						4130 007 0175	4132 007 0175
		3 d	21.0	17.4					4130 007 0021	4132 007 0021	
M 8	1.25	1 d	8.0	4.7	9.85 10.1	8.27 8.48	8.4	7.4 11.4 15.4 19.4 23.4	9.62	4130 008 0008	4132 008 0008
		1.5 d	12.0	7.4						4130 008 0012	4132 008 0012
		2 d	16.0	10.6						4130 008 0016	4132 008 0016
		2.5 d	20.0	13.5						4130 008 0020	4132 008 0020
		3 d	24.0	16.4					4130 008 0024	4132 008 0024	
M 8 x 1	1.0	1 d	8.0	6.1	9.85 10.1	8.22 8.41	8.3	7.5 11.5 15.5 19.5 23.5	9.30	4130 008 3008	4132 008 3008
		1.5 d	12.0	9.5						4130 008 3012	4132 008 3012
		2 d	16.0	12.9						4130 008 3016	4132 008 3016
		2.5 d	20.0	16.5						4130 008 3020	4132 008 3020
		3 d	24.0	19.9					4130 008 3024	4132 008 3024	

* Intermediate lengths also available.

① See flap page 11b.

HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order No [®]	screwlock Order No [®]
		x d	mm								
M 9	1.25	1 d	9.0	5.3	10.85 11.1	9.27 9.48	9.4	8.4	10.62	4130 009 0009	on request
		1.5 d	13.5	8.6				12.9		4130 009 0135	
		2 d	18.0	11.9				17.4		4130 009 0018	
		2.5 d	22.5	15.3				21.9		4130 009 0225	
		3 d	27.0	18.1				26.4		4130 009 0027	
M 10	1.5	1 d	10.0	5.0	12.1 12.5	10.32 10.56	10.50	9.2	11.95	4130 010 0010	4132 010 0010
		1.5 d	15.0	8.1				14.2		4130 010 0015	4132 010 0015
		2 d	20.0	11.2				19.2		4130 010 0020	4132 010 0020
		2.5 d	25.0	14.2				24.2		4130 010 0025	4132 010 0025
		3 d	30.0	17.2				29.2		4130 010 0030	4132 010 0030
M 10 x 1	1.0	1 d	10.0	7.6	12.1 12.5	10.22 10.41	10.25	9.5	11.30	4130 010 3010	4132 010 3010
		1.5 d	15.0	12.1				14.5		4130 010 3015	4132 010 3015
		2 d	20.0	16.3				19.5		4130 010 3020	4132 010 3020
		2.5 d	25.0	20.7				24.5		4130 010 3025	4132 010 3025
		3 d	30.0	25.0				29.5		4130 010 3030	4132 010 3030
M 10 x 1.25	1.25	1 d	10.0	6.0	12.1 12.5	10.27 10.48	10.40	9.4	11.62	4130 010 9010	4132 010 9010
		1.5 d	15.0	9.7				14.4		4130 010 9015	4132 010 9015
		2 d	20.0	13.1				19.4		4130 010 9020	4132 010 9020
		2.5 d	25.0	16.9				24.4		4130 010 9025	4132 010 9025
		3 d	30.0	20.1				29.4		4130 010 9030	4132 010 9030
M 11	1.5	1 d	11.0	5.6	13.1 13.5	11.33 11.56	11.50	10.2	12.95	4130 011 0011	on request
		1.5 d	16.5	9.0				15.7		4130 011 0165	
		2 d	22.0	12.3				21.2		4130 011 0022	
		2.5 d	27.5	15.7				26.7		4130 011 0275	
		3 d	33.0	19.1				32.2		4130 011 0033	
M 12	1.75	1 d	12.0	5.2	14.4 14.8	12.38 12.64	12.50	11.1	14.27	4130 012 0012	4132 012 0012
		1.5 d	18.0	8.4				17.1		4130 012 0018	4132 012 0018
		2 d	24.0	11.7				23.1		4130 012 0024	4132 012 0024
		2.5 d	30.0	14.7				29.1		4130 012 0030	4132 012 0030
		3 d	36.0	18.0				35.1		4130 012 0036	4132 012 0036
M 12 x 1	1.0	1 d	12.0	9.3	14.4 14.8	12.22 12.41	12.25	11.5	13.30	4130 012 3012	on request
		1.5 d	18.0	14.5				17.5		4130 012 3018	
		2 d	24.0	19.5				23.5		4130 012 3024	
		2.5 d	30.0	24.8				29.5		4130 012 3030	
		3 d	36.0	30.0				35.5		4130 012 3036	
M 12 x 1.25	1.25	1 d	12.0	7.4	14.4 14.8	12.27 12.48	12.25	11.4	13.62	4130 012 9012	4132 012 9012
		1.5 d	18.0	11.6				17.4		4130 012 9018	4132 012 9018
		2 d	24.0	15.9				23.4		4130 012 9024	4132 012 9024
		2.5 d	30.0	20.0				29.4		4130 012 9030	4132 012 9030
		3 d	36.0	24.3				35.4		4130 012 9036	4132 012 9036
M 12 x 1.5	1.5	1 d	12.0	6.2	14.4 14.8	12.32 12.56	12.50	11.2	13.95	4130 012 4012	4132 012 4012
		1.5 d	18.0	9.8				17.2		4130 012 4018	4132 012 4018
		2 d	24.0	13.5				23.2		4130 012 4024	4132 012 4024
		2.5 d	30.0	17.1				29.2		4130 012 4030	4132 012 4030
		3 d	36.0	20.8				35.2		4130 012 4036	4132 012 4036

* Intermediate lengths also available.

© See flap page 11b.

HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order No [®]	screwlock Order No [®]
		x d	mm								
M 14	2.0	1 d	14.0	5.6	16.8 17.2	14.43 14.73	14.50	13.0	16.60	4130 014 0014	4132 014 0014
		1.5 d	21.0	8.8				20.0		4130 014 0021	4132 014 0021
		2 d	28.0	12.0				27.0		4130 014 0028	4132 014 0028
		2.5 d	35.0	15.2				34.0		4130 014 0035	4132 014 0035
M 14 x 1	1.0	1 d	14.0	11.2	16.8 17.2	14.22 14.41	14.25	13.5	15.30	4130 014 3014	on request
		1.5 d	21.0	17.2				20.5		4130 014 3021	
		2 d	28.0	23.2				27.5		4130 014 3028	
		2.5 d	35.0	29.2				34.5		4130 014 3035	
M 14 x 1.25	1.25	spark plug thread	8.4	4.6	16.8 17.2	14.27 14.48	14.25	7.8	15.62	4130 014 9084	on request
			12.4	7.4				11.8		4130 014 9124	
			14.4	9.1				13.8		4130 014 9144	
			16.4	10.2				15.8		4130 014 9164	
M 14 x 1.5	1.5	1 d	14.0	7.4	16.8 17.2	14.38 14.56	14.50	13.2	15.95	4130 014 4014	4132 014 4014
		1.5 d	21.0	11.6				20.2		4130 014 4021	4132 014 4021
		2 d	28.0	15.7				27.2		4130 014 4028	4132 014 4028
		2.5 d	35.0	19.9				34.2		4130 014 4035	4132 014 4035
M 16	2.0	1 d	16.0	6.5	19.0 19.4	16.43 16.73	16.50	15.0	18.60	4130 016 0016	4132 016 0016
		1.5 d	24.0	10.1				23.0		4130 016 0024	4132 016 0024
		2 d	32.0	13.8				31.0		4130 016 0032	4132 016 0032
		2.5 d	40.0	17.5				39.0		4130 016 0040	4132 016 0040
M 16 x 1.5	1.5	1 d	16.0	8.7	19.0 19.4	16.32 16.56	16.50	15.2	17.95	4130 016 4016	4132 016 4016
		1.5 d	24.0	13.4				23.2		4130 016 4024	4132 016 4024
		2 d	32.0	18.1				31.2		4130 016 4032	4132 016 4032
		2.5 d	40.0	22.9				39.2		4130 016 4040	4132 016 4040
M 18	2.5	0.5 d	9.0	2.3	21.5 22.0	18.54 18.90	18.75	7.7	21.25	4130 018 0009	4132 018 0009
		0.75 d	13.5	3.8				12.2		4130 018 0135	4132 018 0135
		1 d	18.0	5.6				16.7		4130 018 0018	4132 018 0018
		1.5 d	27.0	9.0				25.7		4130 018 0027	4132 018 0027
		2 d	36.0	12.3				34.7		4130 018 0036	4132 018 0036
M 18 x 1.5	1.5	0.5 d	9.0	4.2	21.5 22.0	18.32 18.56	18.50	8.2	19.95	4130 018 4009	4132 018 4009
		0.75 d	13.5	7.0				12.7		4130 018 4135	4132 018 4135
		1 d	18.0	9.5				17.2		4130 018 4018	4132 018 4018
		1.5 d	27.0	14.9				26.2		4130 018 4027	4132 018 4027
		2 d	36.0	20.2				35.2		4130 018 4036	4132 018 4036
M 18 x 2	2.0	0.5 d	9.0	3.1	21.5 22.0	18.43 18.72	18.50	8.0	20.60	4130 018 5009	4132 018 5009
		0.75 d	13.5	5.1				12.5		4130 018 5135	4132 018 5135
		1 d	18.0	7.1				17.0		4130 018 5018	4132 018 5018
		1.5 d	27.0	11.2				26.0		4130 018 5027	4132 018 5027
		2 d	36.0	15.1				35.0		4130 018 5036	4132 018 5036

* Intermediate lengths also available.

© See flap page 11b.

HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order No [®]	screwlock Order No [®]
		x d	mm								
M 20	2.5	0.5 d	10.0	2.7	23.7 24.2	20.54 20.90	20.75	8.7	23.25	4130 020 0010	4132 020 0010
		0.75 d	15.0	4.5				13.7		4130 020 0015	4132 020 0015
		1 d	20.0	6.3				18.7		4130 020 0020	4132 020 0020
		1.5 d	30.0	10.0				28.7		4130 020 0030	4132 020 0030
		2 d	40.0	13.7				38.7		4130 020 0040	4132 020 0040
M 20 x 1.5	1.5	0.5 d	10.0	4.9	23.7 24.2	20.32 20.56	20.50	9.2	21.95	4130 020 4010	4132 020 4010
		0.75 d	15.0	7.9				14.2		4130 020 4015	4132 020 4015
		1 d	20.0	10.7				19.2		4130 020 4020	4132 020 4020
		1.5 d	30.0	16.7				29.2		4130 020 4030	4132 020 4030
		2 d	40.0	22.4				39.2		4130 020 4040	4132 020 4040
M 20 x 2	2.0	0.5 d	10.0	3.5	23.7 24.2	20.43 20.73	20.50	9.0	22.60	4130 020 5010	4132 020 5010
		0.75 d	15.0	5.8				14.0		4130 020 5015	4132 020 5015
		1 d	20.0	8.0				19.0		4130 020 5020	4132 020 5020
		1.5 d	30.0	12.5				29.0		4130 020 5030	4132 020 5030
		2 d	40.0	16.8				39.0		4130 020 5040	4132 020 5040
M 22	2.5	0.5 d	11.0	3.0	26.3 26.8	22.54 22.90	22.75	9.7	25.25	4130 022 0011	4132 022 0011
		0.75 d	16.5	5.0				15.2		4130 022 0165	4132 022 0165
		1 d	22.0	6.9				20.7		4130 022 0022	4132 022 0022
		1.5 d	33.0	10.9				31.7		4130 022 0033	4132 022 0033
		2 d	44.0	15.0				42.7		4130 022 0044	4132 022 0044
M 22 x 1.5	1.5	0.5 d	11.0	5.5	26.3 26.8	22.32 22.56	22.50	10.2	23.95	4130 022 4011	on request
		0.75 d	16.5	8.6				15.7		4130 022 4165	
		1 d	22.0	11.7				21.2		4130 022 4022	
		1.5 d	33.0	18.1				32.2		4130 022 4033	
		2 d	44.0	24.5				43.2		4130 022 4044	
M 22 x 2	2.0	0.5 d	11.0	3.9	26.3 26.8	22.43 22.73	22.50	10.0	24.60	4130 022 5011	4132 022 5011
		0.75 d	16.5	6.4				15.5		4130 022 5165	4132 022 5165
		1 d	22.0	8.7				21.0		4130 022 5022	4132 022 5022
		1.5 d	33.0	13.6				32.0		4130 022 5033	4132 022 5033
		2 d	44.0	18.4				43.0		4130 022 5044	4132 022 5044
M 24	3.0	0.5 d	12.0	2.6	28.6 29.1	24.65 25.05	24.75	10.5	27.90	4130 024 0012	4132 024 0012
		0.75 d	18.0	4.5				16.5		4130 024 0018	4132 024 0018
		1 d	24.0	6.2				22.5		4130 024 0024	4132 024 0024
		1.5 d	36.0	10.0				34.5		4130 024 0036	4132 024 0036
		2 d	48.0	14.0				46.5		4130 024 0048	on request
M 24 x 1.5	1.5	0.5 d	12.0	6.0	28.6 29.1	24.33 24.56	24.50	11.2	25.95	4130 024 4012	on request
		0.75 d	18.0	9.5				17.2		4130 024 4018	
		1 d	24.0	12.9				23.2		4130 024 4024	
		1.5 d	36.0	19.8				35.2		4130 024 4036	
		2 d	48.0	26.7				47.2		4130 024 4048	
M 24 x 2	2.0	0.5 d	12.0	4.3	28.6 29.1	24.43 24.73	24.50	11.0	26.60	4130 024 5012	4132 024 5012
		0.75 d	18.0	7.0				17.0		4130 024 5018	4132 024 5018
		1 d	24.0	9.6				23.0		4130 024 5024	4132 024 5024
		1.5 d	36.0	15.0				35.0		4130 024 5036	4132 024 5036
		2 d	48.0	20.2				47.0		4130 024 5048	4132 024 5048

* Intermediate lengths also available.

© See flap page 11b.

HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order No [®]	screwlock Order No [®]
		x d	mm								
M 26 x 1.5	1.5	0.5 d	13.0	6.5	31.0 31.5	26.33 26.56	26.50	12.2	27.95	4130 026 4013	on request
		0.75 d	19.5	10.3				18.7		4130 026 4195	
		1 d	26.0	14.0				25.2		4130 026 4026	
		1.5 d	39.0	21.6				38.2		4130 026 4039	
		2 d	52.0	29.1				51.2		4130 026 4052	
M 27	3.0	0.5 d	13.5	3.2	32.2 32.7	27.65 28.05	27.75	12.0	30.90	4130 027 0135	4132 027 0135
		0.75 d	20.3	5.0				18.8		4130 027 0203	4132 027 0203
		1 d	27.0	7.1				25.5		4130 027 0027	4132 027 0027
		1.5 d	40.5	11.4				39.0		4130 027 0405	4132 027 0405
		2 d	54.0	15.4				52.5		4130 027 0054	4132 027 0054
M 27 x 1.5	1.5	0.5 d	13.5	6.7	32.2 32.7	27.33 27.56	27.50	12.7	28.95	4130 027 4135	on request
		0.75 d	20.3	10.7				19.5		4130 027 4203	
		1 d	27.0	14.6				26.2		4130 027 4027	
		1.5 d	40.5	22.6				39.7		4130 027 4405	
		2 d	54.0	30.0				53.2		4130 027 4054	
M 27 x 2	2.0	0.5 d	13.5	5.1	32.2 32.7	27.43 27.73	27.50	12.5	29.60	4130 027 5135	on request
		0.75 d	20.3	7.9				19.3		4130 027 5203	
		1 d	27.0	10.8				26.0		4130 027 5027	
		1.5 d	40.5	16.8				39.5		4130 027 5405	
		2 d	54.0	22.6				53.0		4130 027 5054	
M 28 x 1.5	1.5	0.5 d	14.0	7.1	33.1 33.6	28.33 28.56	28.50	13.2	29.95	4130 028 4014	on request
		0.75 d	21.0	11.1				20.2		4130 028 4021	
		1 d	28.0	15.2				27.2		4130 028 4028	
		1.5 d	42.0	23.3				41.2		4130 028 4042	
		2 d	56.0	31.4				55.2		4130 028 4056	
M 30	3.5	0.5 d	15.0	3.0	35.2 35.7	30.76 31.21	31.00	13.2	34.55	4130 030 0015	4132 030 0015
		0.75 d	22.5	4.9				20.7		4130 030 0225	4132 030 0225
		1 d	30.0	7.0				28.2		4130 030 0030	4132 030 0030
		1.5 d	45.0	11.0				43.2		4130 030 0045	4132 030 0045
		2 d	60.0	14.9				58.2		4130 030 0060	4132 030 0060
M 30 x 1.5	1.5	0.5 d	15.0	7.8	35.2 35.7	30.33 30.56	30.50	14.2	31.95	4130 030 4015	on request
		0.75 d	22.5	12.2				21.7		4130 030 4225	
		1 d	30.0	16.5				29.2		4130 030 4030	
		1.5 d	45.0	25.3				44.2		4130 030 4045	
		2 d	60.0	34.0				59.2		4130 030 4060	
M 30 x 2	2.0	0.5 d	15.0	5.7	35.2 35.7	30.43 30.73	30.50	14.0	32.60	4130 030 5015	on request
		0.75 d	22.5	9.0				21.5		4130 030 5225	
		1 d	30.0	12.3				29.0		4130 030 5030	
		1.5 d	45.0	19.0				44.0		4130 030 5045	
		2 d	60.0	25.5				59.0		4130 030 5060	
M 33	3.5	0.5 d	16.5	3.4	38.3 38.8	33.76 34.21	34.00	14.7	37.55	4130 033 0165	on request
		0.75 d	24.8	5.6				23.0		4130 033 0248	on request
		1 d	33.0	7.8				31.2		4130 033 0033	4132 033 0033
		1.5 d	49.5	12.2				47.7		4130 033 0495	4132 033 0495
		2 d	66.0	16.5				64.2		4130 033 0066	4132 033 0066

* Intermediate lengths also available.

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HELICOIL® plus thread inserts

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	free running Order No [Ⓞ]	screwlock Order No [Ⓞ]
		x d	mm								
M 33 x 2	2.0	0.5 d	16.5	6.4	38.3 38.8	33.43 33.73	33.50	15.5	35.60	4130 033 5165	on request
		0.75 d	24.8	10.1				23.8		4130 033 5248	
		1 d	33.0	13.7				32.0		4130 033 5033	
		1.5 d	49.5	21.2				48.5		4130 033 5495	
		2 d	66.0	28.4				65.0		4130 033 5066	
M 36	4.0	0.5 d	18.0	3.2	42.1 42.6	36.87 37.34	37.00	16.0	41.20	4130 036 0018	on request
		0.75 d	27.0	5.0				25.0		4130 036 0027	on request
		1 d	36.0	7.0				34.0		4130 036 0036	4132 036 0036
		1.5 d	54.0	11.1				52.0		4130 036 0054	4132 036 0054
		2 d	72.0	15.2				70.0		4130 036 0072	4132 036 0072
M 36 x 1.5	1.5	0.5 d	18.0	9.5	42.1 42.6	36.33 36.56	36.50	17.2	37.95	4130 036 4018	on request
		0.75 d	27.0	14.7				26.2		4130 036 4027	
		1 d	36.0	19.9				35.2		4130 036 4036	
		1.5 d	54.0	30.5				53.2		4130 036 4054	
		2 d	72.0	41.0				71.2		4130 036 4072	
M 36 x 2	2.0	0.5 d	18.0	6.8	42.1 42.6	36.43 36.73	36.50	17.0	38.60	4130 036 5018	on request
		0.75 d	27.0	10.3				26.0		4130 036 5027	
		1 d	36.0	14.1				35.0		4130 036 5036	
		1.5 d	54.0	21.9				53.0		4130 036 5054	
		2 d	72.0	31.1				71.0		4130 036 5072	
M 36 x 3**	3.0	0.5 d	18.0	4.4	42.1 42.6	36.65 37.05	37.00	16.5	39.90	4130 036 6018	4132 036 6018
		0.75 d	27.0	7.2				25.5		4130 036 6027	4132 036 6027
		1 d	36.0	9.9				34.5		4130 036 6036	4132 036 6036
		1.5 d	54.0	15.3				52.5		4130 036 6054	4132 036 6054
		2 d	72.0	20.5				70.5		4130 036 6072	4132 036 6072
M 39	4.0	0.75 d	29.3	5.5	45.1 45.6	39.87 40.34	40.00	23.4	44.20	4130 039 0293	4132 039 0293
		1 d	39.0	7.7				33.1		4130 039 0039	4132 039 0039
		1.25 d	48.8	9.9				42.9		4130 039 0488	4132 039 0488
		1.5 d	58.5	12.3				52.6		4130 039 0585	4132 039 0585
		2 d	78.0	16.6				72.1		4130 039 0078	4132 039 0078
M 39 x 2	2.0	0.5 d	19.5	7.5	45.1 45.6	39.43 39.73	39.50	16.6	41.60	4130 039 5195	4132 039 5195
		0.75 d	29.3	11.9				26.3		4130 039 5293	4132 039 5293
		1 d	39.0	16.3				36.1		4130 039 5039	4132 039 5039
		1.25 d	48.8	20.6				45.8		4130 039 5488	4132 039 5488
		1.5 d	58.5	25.0				55.6		4130 039 5585	4132 039 5585
M 39 x 3	3.0	0.5 d	19.5	4.9	45.1 45.6	39.65 40.05	40.00	15.1	42.90	4130 039 6195	4132 039 6195
		0.75 d	29.3	7.8				24.8		4130 039 6293	4132 039 6293
		1 d	39.0	10.8				34.6		4130 039 6039	4132 039 6039
		1.25 d	48.8	13.7				44.3		4130 039 6488	4132 039 6488
		1.5 d	58.5	16.8				54.1		4130 039 6585	4132 039 6585
M 42	4.5	0.5 d	21.0	3.3	48.5 49.0	42.98 43.05	43.00	18.7	47.85	4130 042 0021	on request
		0.75 d	35.0	6.2				32.7		4130 042 0035	
		1 d	42.0	7.3				39.7		4130 042 0042	
		1.25 d	52.5	9.5				50.2		4130 042 0525	
		1.5 d	63.0	11.6				60.7		4130 042 0063	
		2 d	84.0	15.6				81.7		4130 042 0084	

* Intermediate lengths also available. HELICOIL® plus > M 24 on request.

** Further nominal thread diameters available. See "Thread types" table on page 10.

Ⓞ See flap page 11b.