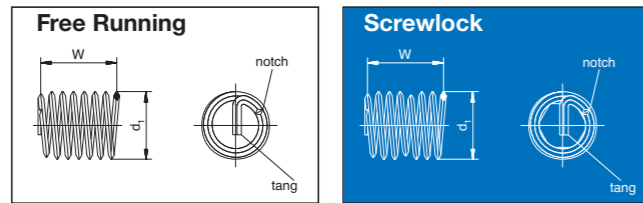




HELICOIL® Plus

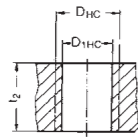
Thread technology for
high-strength fastenings
– metric threads

BÖLLHOFF

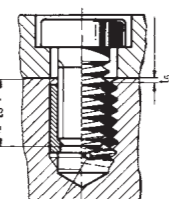
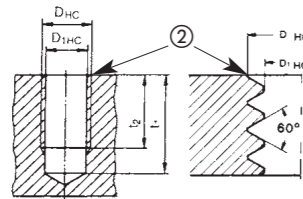
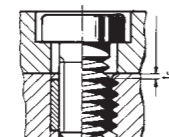


W and d₁ are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



tang not broken off

- 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

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

■ When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values t₁ and t₂.

① Materials and surface finishes must be indicated with the 5th digit of the item no:

Example:

↓
0 = Stainless steel A 2, X 5 CrNi 18 10 4130 002 0005
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, bright
6 = Stainless steel A 2, X 5 CrNi 18 10, cadmium-plated
7 = Stainless steel A 2, X 5 CrNi 18 10, magazined**
8 = Bronze, CuSn 6, magazined**
 Other materials on request

* Use special tools for HELICOIL® Screwlock
 **See page 24

All measures in mm. Technical changes reserved.

d	P	t ₂ min.*		W	d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	Free Running Item No [®]	Screwlock Item No [®]
		x d	mm								
M 2	0.40	1 d	2.0	2.9	2.60 2.80	2.09 2.18	2.10	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	3.30 3.50	2.60 2.70	2.60	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	3.80 4.00	3.11 3.22	3.20	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	3.70	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	4.20	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 6.60	5.17 5.33	5.20	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	7.60 7.85	6.22 6.41	6.30	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 8.90	7.22 7.41	7.30	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 10.10	8.27 8.48	8.40	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 10.10	8.22 8.41	8.30	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 17 b

Lead time of items: approx. 3 weeks (10,000 pieces max.).

We have items with blue order numbers in stock – subject to being unsold.

HELICOIL® Plus thread inserts

d	P	t ₂ min.*			d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	Free Running Item No [®]	Screwlock Item No [®]
		x d	mm	W							
M 9	1.25	1 d	9.0	5.3	10.85	9.27	9.40	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	12.10	10.32	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	12.10	10.22	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	12.10	10.27	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	13.10	11.33	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	14.40	12.38	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	14.40	12.22	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	14.40	12.27	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	14.40	12.32	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 17 b

Lead time of items: approx. 3 weeks (10,000 pieces max.).
We have items with blue order numbers in stock – subject to being unsold.

HELICOIL® Plus thread inserts

d	P	t ₂ min.*			d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	Free Running Item No [®]	Screwlock Item No [®]
		x d	mm	W							
M 14	2.0	1 d	14.0	5.6	16.80	14.43	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	16.80	14.22	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	16.80	14.27	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	16.80	14.38	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	19.00	16.43	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	19.00	16.32	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	21.50	18.54	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	21.50	18.32	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	21.50	18.43	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 17 b

Lead time of items: approx. 3 weeks (10,000 pieces max.).
We have items with blue order numbers in stock – subject to being unsold.

HELICOIL® Plus thread inserts

d	P	t ₂ min.*		d ₁ min. max.	D _{1HC} min. max.	B	t ₃ max.	D _{HC} min.	Free Running Item No [®]	Screwlock Item No [®]
		x d	mm							
M 20	2.5	0.5 d	10.0	2.7	23.70 24.20	20.54 20.90	20.75	8.7 13.7 18.7 23.25	4130 020 0010 4130 020 0015 4130 020 0020 4130 020 0030 4130 020 0040	4132 020 0010 4132 020 0015 4132 020 0020 4132 020 0030 4132 020 0040
		0.75 d	15.0	4.5						
		1 d	20.0	6.3						
		1.5 d	30.0	10.0						
		2 d	40.0	13.7						
M 20 x 1.5	1.5	0.5 d	10.0	4.9	23.70 24.20	20.32 20.56	20.50	9.2 14.2 19.2 21.95	4130 020 4010 4130 020 4015 4130 020 4020 4130 020 4030 4130 020 4040	4132 020 4010 4132 020 4015 4132 020 4020 4132 020 4030 4132 020 4040
		0.75 d	15.0	7.9						
		1 d	20.0	10.7						
		1.5 d	30.0	16.7						
		2 d	40.0	22.4						
M 20 x 2	2.0	0.5 d	10.0	3.5	23.70 24.20	20.43 20.73	20.50	9.0 14.0 19.0 22.60	4130 020 5010 4130 020 5015 4130 020 5020 4130 020 5030 4130 020 5040	4132 020 5010 4132 020 5015 4132 020 5020 4132 020 5030 4132 020 5040
		0.75 d	15.0	5.8						
		1 d	20.0	8.0						
		1.5 d	30.0	12.5						
		2 d	40.0	16.8						
M 22	2.5	0.5 d	11.0	3.0	26.30 26.80	22.54 22.90	22.75	9.7 15.2 20.7 25.25	4130 022 0011 4130 022 0165 4130 022 0022 4130 022 0033 4130 022 0044	4132 022 0011 4132 022 0165 4132 022 0022 4132 022 0033 4132 022 0044
		0.75 d	16.5	5.0						
		1 d	22.0	6.9						
		1.5 d	33.0	10.9						
		2 d	44.0	15.0						
M 22 x 1.5	1.5	0.5 d	11.0	5.5	26.30 26.80	22.32 22.56	22.50	10.2 15.7 21.2 23.95	4130 022 4011 4130 022 4165 4130 022 4022 4130 022 4033 4130 022 4044	on request
		0.75 d	16.5	8.6						
		1 d	22.0	11.7						
		1.5 d	33.0	18.1						
		2 d	44.0	24.5						
M 22 x 2	2.0	0.5 d	11.0	3.9	26.30 26.80	22.43 22.73	22.50	10.0 15.5 21.0 24.60	4130 022 5011 4130 022 5165 4130 022 5022 4130 022 5033 4130 022 5044	4132 022 5011 4132 022 5165 4132 022 5022 4132 022 5033 4132 022 5044
		0.75 d	16.5	6.4						
		1 d	22.0	8.7						
		1.5 d	33.0	13.6						
		2 d	44.0	18.4						
M 24	3.0	0.5 d	12.0	2.6	28.60 29.10	24.65 25.05	24.75	10.5 16.5 22.5 27.90	4130 024 0012 4130 024 0018 4130 024 0024 4130 024 0036 4130 024 0048	4132 024 0012 4132 024 0018 4132 024 0024 4132 024 0036 on request
		0.75 d	18.0	4.5						
		1 d	24.0	6.2						
		1.5 d	36.0	10.0						
		2 d	48.0	14.0						
M 24 x 1.5	1.5	0.5 d	12.0	6.0	28.60 29.10	24.33 24.56	24.50	11.2 17.2 23.2 25.95	4130 024 4012 4130 024 4018 4130 024 4024 4130 024 4036 4130 024 4048	on request
		0.75 d	18.0	9.5						
		1 d	24.0	12.9						
		1.5 d	36.0	19.8						
		2 d	48.0	26.7						
M 24 x 2	2.0	0.5 d	12.0	4.3	28.60 29.10	24.43 24.73	24.50	11.0 17.0 23.0 26.60	4130 024 5012 4130 024 5018 4130 024 5024 4130 024 5036 4130 024 5048	4132 024 5012 4132 024 5018 4132 024 5024 4132 024 5036 4132 024 5048
		0.75 d	18.0	7.0						
		1 d	24.0	9.6						
		1.5 d	36.0	15.0						
		2 d	48.0	20.2						

*Intermediate lengths also available.

® See flap page 17 b

Lead time of items: approx. 3 weeks (10,000 pieces max.).

We have items with blue order numbers in stock – subject to being unsold.

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 Item No [®]	Screwlock Item No [®]
		x d	mm								
M 26 x 1.5	1.5	0.5 d	13.0	6.5	31.00 31.50	26.33 26.56	26.50	12.2 18.7 25.2 38.2 51.2	27.95	4130 026 4013 4130 026 4195 4130 026 4026 4130 026 4039 4130 026 4052	on request
		0.75 d	19.5	10.3							
		1 d	26.0	14.0							
		1.5 d	39.0	21.6							
		2 d	52.0	29.1							
M 27	3.0	0.5 d	13.5	3.2	32.20 32.70	27.65 28.05	27.75	12.0 18.8 25.5 39.0 52.5	30.90	4130 027 0135 4130 027 0203 4130 027 0027 4130 027 0405 4130 027 0054	4132 027 0135 4132 027 0203 4132 027 0027 4132 027 0405 4132 027 0054
		0.75 d	20.3	5.0							
		1 d	27.0	7.1							
		1.5 d	40.5	11.4							
		2 d	54.0	15.4							
M 27 x 1.5	1.5	0.5 d	13.5	6.7	32.20 32.70	27.33 27.56	27.50	12.7 19.5 26.2 39.7 53.2	28.95	4130 027 4135 4130 027 4203 4130 027 4027 4130 027 4405 4130 027 4054	on request
		0.75 d	20.3	10.7							
		1 d	27.0	14.6							
		1.5 d	40.5	22.6							
		2 d	54.0	30.0							
M 27 x 2	2.0	0.5 d	13.5	5.1	32.20 32.70	27.43 27.73	27.50	12.5 19.3 26.0 39.5 53.0	29.60	4130 027 5135 4130 027 5203 4130 027 5027 4130 027 5405 4130 027 5054	on request
		0.75 d	20.3	7.9							
		1 d	27.0	10.8							
		1.5 d	40.5	16.8							
		2 d	54.0	22.6							
M 28 x 1.5	1.5	0.5 d	14.0	7.1	33.10 33.60	28.33 28.56	28.50	13.2 20.2 27.2 41.2 55.2	29.95	4130 028 4014 4130 028 4021 4130 028 4028 4130 028 4042 4130 028 4056	on request
		0.75 d	21.0	11.1							
		1 d	28.0	15.2							
		1.5 d	42.0	23.3							
		2 d	56.0	31.4							
M 30	3.5	0.5 d	15.0	3.0	35.20 35.70	30.76 31.21	31.00	13.2 20.7 28.2 43.2 58.2	34.55	4130 030 0015 4130 030 0225 4130 030 0030 4130 030 0045 4130 030 0060	4132 030 0015 4132 030 0225 4132 030 0030 4132 030 0045 4132 030 0060
		0.75 d	22.5	4.9							
		1 d	30.0	7.0							
		1.5 d	45.0	11.0							
		2 d	60.0	14.9							
M 30 x 1.5	1.5	0.5 d	15.0	7.8	35.20 35.70	30.33 30.56	30.50	14.2 21.7 29.2 44.2 59.2	31.95	4130 030 4015 4130 030 4225 4130 030 4030 4130 030 4045 4130 030 4060	on request
		0.75 d	22.5	12.2							
		1 d	30.0	16.5							
		1.5 d	45.0	25.3							
		2 d	60.0	34.0							
M 30 x 2	2.0	0.5 d	15.0	5.7	35.20 35.70	30.43 30.73	30.50	14.0 21.5 29.0 44.0 59.0	32.60	4130 030 5015 4130 030 5225 4130 030 5030 4130 030 5045 4130 030 5060	on request
		0.75 d	22.5	9.0							
		1 d	30.0	12.3							
		1.5 d	45.0	19.0							
		2 d	60.0	25.5							
M 33	3.5	0.5 d	16.5	3.4	38.30 38.80	33.76 34.21	34.00	14.7 23.0 31.2 47.7 64.2	37.55	4130 033 0165 4130 033 0248 4130 033 0033 4130 033 0495 4130 033 0066	on request on request 4132 033 0033 4132 033 0495 4132 033 0066
		0.75 d	24.8	5.6							
		1 d	33.0	7.8							
		1.5 d	49.5	12.2							
		2 d	66.0	16.5							

*Intermediate lengths also available.

® See flap page 17 b

Lead time of items: approx. 3 weeks (10,000 pieces max.).

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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 Item No [®]	Screwlock Item No [®]
		x d	mm								
M 33 x 2	2.0	0.5 d	16.5	6.4	38.30 38.80	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	42.10 42.60	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	42.10 42.60	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	42.10 42.60	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	42.10 42.60	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	45.10 45.60	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	45.10 45.60	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	45.10 45.60	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	48.50 49.00	42.98 43.50	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 42 on request.

** Further nominal thread diameters available. See "Thread types" table on page 12.

® See page 17b

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