

HELICOIL® Plus Kit - Thread repair

M18 - M36 x 1,5 | 1 dimension in 1 length

Delivery scope:

- 10 HELICOIL® Plus thread inserts of the same size and length
- HELICOIL® manual tap (single tap or two-parts set consisting of pre and final cutter)
- HELICOIL® Plus installation mandrel (M18–M24 normal screw thread)
- HELICOIL® Plus manual installation tool (M27–M33 normal screw thread, M18 x 1.5–M36 x 1.5 fine screw thread)
- Practical case for storage and transport
- Operating instructions



Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D _{HC} min.	D _{1HC}		Nominal length t ₂ (x d)		W	t ₃ max.	B	d ₁	
				min.	max.	t ₂	t ₂				min.	max.
M 18	41851180018	2.5	21.25	18.54	18.90	1.0	18.0	5.6	16.7	18.75	21.5	22.0
	41851180027	2.5				1.5	27.0	9.0	25.7			
	41851180036	2.5				2.0	36.0	12.3	34.7			
M 18x1.5	41851184018	1.5	19.95	18.32	18.56	1.0	18.0	9.5	17.2	18.50	21.5	22.0
	41851184027	1.5				1.5	27.0	14.9	26.2			
	41851184036	1.5				2.0	36.0	20.2	35.2			
M 18x2	41851185027	2.0	20.60	18.43	18.72	1.5	27.0	11.2	26.0	18.50	21.5	22.0
	41851200020	2.5				1.0	20.0	6.3	19.2			
M 20	41851200030	2.5	23.25	20.54	20.90	1.5	30.0	10.0	29.2	20.75	23.7	24.2
	41851200040	2.5				2.0	40.0	13.7	39.2			
	41851204020	1.5				1.0	20.0	10.7	19.2			
M 20x1.5	41851204030	1.5	21.95	20.32	20.56	1.5	30.0	16.7	29.2	20.50	23.7	24.2
	41851204040	1.5				2.0	40.0	22.4	39.2			
	41851205020	2.0				1.0	20.0	8.0	19.0			
M 20x2	41851205030	2.0	22.60	20.43	20.73	1.5	30.0	12.5	29.0	20.50	23.7	24.2
	41851205040	2.0				2.0	40.0	16.8	39.0			
	41851220022	2.5				1.0	22.0	6.9	20.7			
M 22	41851220033	2.5	25.25	22.54	22.90	1.5	33.0	10.9	31.7	22.75	26.3	26.8
	41851220044	2.5				2.0	44.0	15.0	42.7			
	41851224022	1.5				1.0	22.0	11.7	21.2			
M 22x1.5	41851224033	1.5	23.95	22.32	22.56	1.5	33.0	18.1	32.2	22.50	26.3	26.8
	41851224044	1.5				2.0	44.0	24.5	43.2			
	41851225033	2.0				1.5	33.0	13.6	32.0			
M 22x2	41851225044	2.0	24.60	22.43	22.73	2.0	44.0	18.4	43.0	22.50	26.3	26.8
	41851240024	3.0				1.0	24.0	6.2	22.5			
M 24	41851240036	3.0	27.90	24.65	25.05	1.5	36.0	10.0	34.5	24.75	28.6	29.1
	41851240048	3.0				2.0	48.0	14.0	46.5			
	41851244024	1.5				1.0	24.0	12.9	23.2			
M 24x1.5	41851244036	1.5	25.95	24.33	24.56	1.5	36.0	19.8	35.2	24.50	28.6	29.1
	41851244048	1.5				2.0	48.0	26.7	47.2			
	41851245024	2.0				1.0	24.0	9.6	23.0			
M 24x2	41851245036	2.0	26.60	24.43	24.73	1.5	36.0	15.0	35.0	24.50	28.6	29.1
	41851245048	2.0				2.0	48.0	20.2	47.0			
	41851264026	1.5				1.0	26.0	14.0	25.2			
M 26x1.5	41851264039	1.5	27.95	26.33	26.56	1.5	39.0	21.6	38.2	26.50	31.0	31.5
	41851264052	1.5				2.0	52.0	29.1	51.2			

All technical data refer to the measure mm



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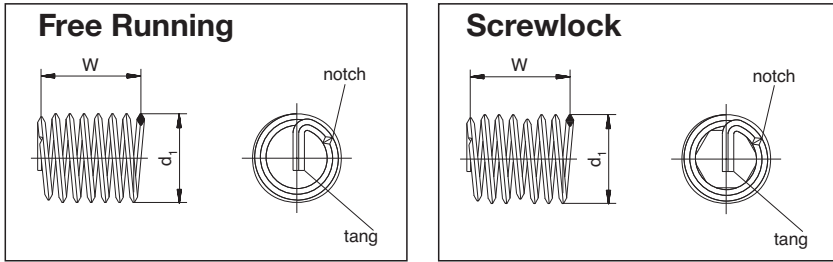
M18 - M36 x 1,5 | 1 dimension in 1 length

Diameter (d)	Article number	Pitch (P)	D _{HC} min.	D _{1HC}		Nominal length		W	t ₃ max.	B	d ₁	
				min.	max.	t ₂ (x d)	t ₂				min.	max.
M 27	41851270027	2.0	30.90	27.65	28.05	1.0	27.0	7.1	25.5	27.75	32.2	32.7
	41851270054	2.0				2.0	54.0	15.4	52.5			
	41851270405	3.0				1.5	40.5	11.4	39.0			
M 27x1.5	41851274027	1.5	28.95	27.33	27.56	1.0	27.0	14.6	26.2	27.50	32.2	32.7
	41851274405	1.5				1.5	40.5	22.6	39.7			
M 27x2	41851275027	2.0	29.60	27.43	27.73	1.0	27.0	10.8	26.0	27.50	32.2	32.7
	41851275054	2.0				2.0	54.0	22.6	53.0			
	41851275405	2.0				1.5	40.5	16.8	39.5			
M 28x1.5	41851284028	1.5	29.95	28.33	28.56	1.0	28.0	15.2	27.2	28.50	33.1	33.6
M 30	41851300030	3.5	34.55	30.76	31.21	1.0	30.0	7.0	28.2	31.00	35.2	35.7
	41851300045	3.5				1.5	45.0	11.0	43.2			
	41851300060	3.5				2.0	60.0	14.9	58.2			
M 30x1.5	41851304030	1.5	31.95	30.33	30.56	1.0	30.0	16.5	29.2	30.50	35.2	35.7
	41851304045	1.5				1.5	45.0	25.3	44.2			
M 30x2	41851305030	2.0	32.60	30.43	30.73	1.0	30.0	12.3	29.0	30.50	35.2	35.7
	41851305045	2.0				1.5	45.0	19.0	44.0			
	41851305060	2.0				2.0	60.0	25.5	59.0			
M 32x1.5	41851324032	1.5	-	-	-	1.0	32.0	-	-	-	-	-
M 33	41851330033	3.5	37.55	33.76	34.21	1.0	33.0	7.8	31.2	34.00	38.3	38.8
	41851330066	3.5				2.0	66.0	16.5	64.2			
	41851330495	3.5				1.5	49.5	12.2	47.7			
M 33x2	41851335033	2.0	35.60	33.43	33.73	1.0	33.0	13.7	32.0	33.50	38.3	38.8
	41851335495	2.0				1.5	49.5	21.2	48.5			
M 35x1.5	41851354035	1.5	-	-	-	1.0	35.0	-	-	-	-	-
M 36x1.5	41851364036	1.5	37.95	36.33	36.56	1.0	36.0	19.9	35.2	36.50	42.1	42.6

All technical data refer to the measure mm

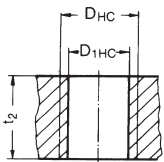


HELICOIL® Plus thread inserts

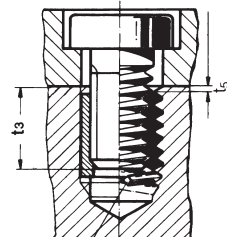
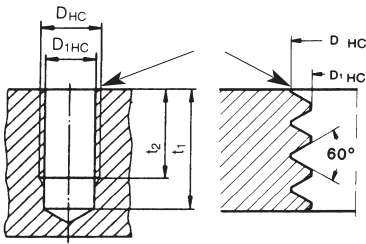
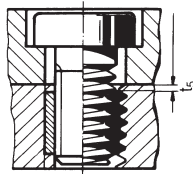


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

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

