All technical data refer to the measure mm

HELICOIL® machine taps

straight fluted | For through holes

Type 0141.1 HELICOIL® machine tap to create holding threads for HELICOIL® thread inserts with British Standard Pipe Threads (BSP/G) as per NASM33537. The tap is suited for through holes and blind holes with a deeper tap hole.



Properties:

- Straight-fluted
- With spiral point
- 2-pitch chamfer
- 10 % cutting angle
- For materials with 850 N/mm² strength max.
- Tolerance class 2B

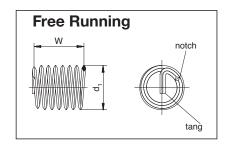
Technical information can be found on the last page.

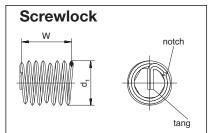
Diameter	Article number	Pitch	Nominal length
(d)		(P)	t ₂
G 1/8"-28	01410714102	0.91	4.8
G 1/4"-19	01410744102	1.34	9.5
G 3/8"-19	01410774102	1.34	14.3
G 1/2"-14	01410794102	1.81	19.1
G 5/8"-14	01410814102	1.81	23.8
G 3/4"-14	01410834102	1.81	28.6
G 7/8"-14	01410854102	1.81	33.3
G 1"-11	01410864102	2.31	38.1
G 1 1/4"-11	01410884102	2.31	47.6
G 1 1/2"-11	01410904102	2.31	57.2



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.

Assembly

tang not broken off

Holding thread

⊢ D_{HC} -D1HC-

DHC D HC D_{1HC} 60

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

- d = Nominal thread diameter
- = Thread pitch
- = Outside diameter of thread insert prior to installa-
- = Number of threads prior to installation
- D_{HC} = Outside diameter of the parent thread
- D_{1HC}= Crest diameter
- = Suitable twist drill diameter. Please note: D_{1HC} is critical for selecting the correct twist drill diameter.
- = Minimum depth of tapped hole according to DIN 76 - Part 1 (guide value)
- = The nominal length of the thread insert corre t_2 sponds to the minimum length of the full parent thread for blind holes or the minimum plate thickness for a through hole.
- = Maximum screw-in depth when the tang is not
- = Distance of the thread insert from the joint face = t_5 0.25 to 0.5 P, if t₂ corresponds to the abovementioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values t_1 and t_2 .

