Twist drill for HELICOIL® Plus and HELICOIL® Classic

Type 0149.9 for HELICOIL® Plus and HELICOIL® Classic (short type)

Twist drill type 0149.9 for tap drilling for HELICOIL® Plus and HELICOIL® Classic.

Properties:

- Short version as per DIN 1897
- Ideal for small drilling depths (approx. 2 d–4 d)

Technical information can be found on the last page.

Diameter (d)	Article number	Length (l) nominal size
8.2	01499082001	79
8.3	01499083001	79
8.4	01499084001	79
9.8	01499098001	89
10	01499100001	89
10.5	01499105001	89
11.5	01499115001	95
11.6	01499116001	95
12.5	01499125000	102
13.1	01499131001	102
13.2	01499132001	102

All technical data refer to the measure mm

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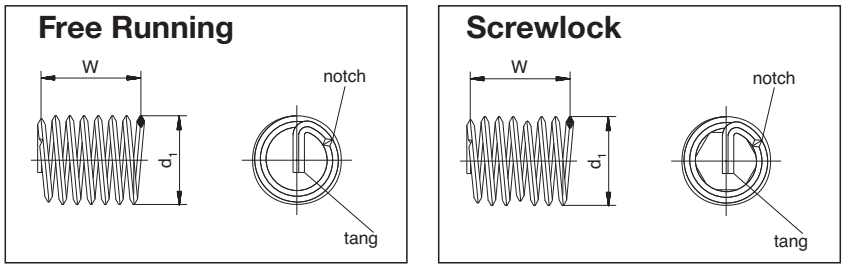
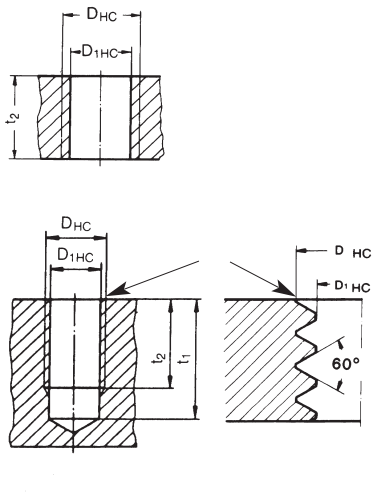
HELICOIL® Plus thread inserts

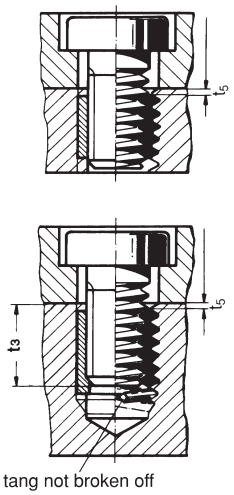


W and d_1 are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

Holding thread



Assembly



Prior to tapping, counter-bore 90° and deburr.
Outside diameter of **countersink = D_{HC} + 0.1 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 x P to values t_1 and t_2.

All technical data refer to the measure mm