

# HELICOIL® Plus pneumatic installation tool

for fast processing of HELICOIL® Plus and Tangfree

P-S 412 pneumatic installation tool to easily and economically install HELICOIL® Plus and Tangfree thread inserts.

**Size range:**

M4 to M12 | UNC 8-32 to UNC 1/2"-13 | UNF 8-36 to UNF 1/2"-20

**Note:**

Installation mandrels are not included in the delivery scope. They must be ordered separately for the specific sizes (HELICOIL® Plus or Tangfree installation mandrels with depth stop).

**Properties:**

- Idle speed: 1,500 rpm at 6.3 bar (adjustable through air pressure)
- Air consumption: 5.5 l/s at 6.3 bar
- Torque ranges between 1.2 Nm and 4.5 Nm
- Continuously adjustable shut-off clutch
- 1/4" hexagon socket with radial bearing
- Weight: 0.8 kg

**Alternative device:**

P-S 1216: for larger sizes

Technical information can be found on the last page.



Diameter (d)	Article number	Weight g
M4 - M12 ; UNC 8-32 - UNC 1/2"-13 ; UNF 8-36 - UNF 1/2"-20	41602700010	800

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

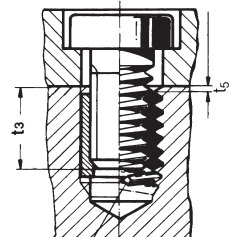
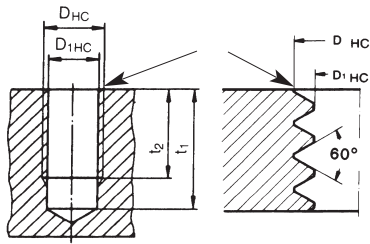


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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<sub>1</sub> = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- D<sub>HC</sub> = Outside diameter of the parent thread
- D<sub>1HC</sub> = Crest diameter
- B = Suitable twist drill diameter. Please note: D<sub>1HC</sub> is critical for selecting the correct twist drill diameter.
- t<sub>1</sub> = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t<sub>2</sub> = 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<sub>3</sub> = Maximum screw-in depth when the tang is not removed
- t<sub>5</sub> = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> 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<sub>1</sub> and t<sub>2</sub>.

All technical data refer to the measure mm

