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## All technical data refer to the measure mm

## **HELICOIL®** manual taps

Type 0140.0 | BA

Short machine tap to create a holding thread (acc. to NASM33537) for  $\rm HELICOIL^{\circledR}$  coil thread inserts.

## **Properties:**

- For through holes
- For blind holes (only if sufficient chip space is provided)
- Machining of materials with 700 N/mm<sup>2</sup> strength max.
- Tolerance class 6H mod. corresponds with 5H

### Note:

Only suited for blind holes if sufficient chip space is provided. Minimum requirement: 1 d deeper than the full thread length.

The short machine tap can also be used as a machine tap.

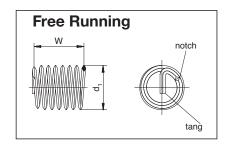
Technical information can be found on the last page.

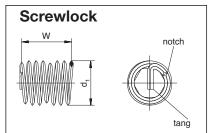
| Diameter | Article number | Pitch | Nominal length |
|----------|----------------|-------|----------------|
| (d)      |                | (P)   | t <sub>2</sub> |
| 3 BA     | 01400952104    | 0.73  | 4.1            |



# 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.

**Assembly** 

tang not broken off

## Holding thread

## ⊢ D<sub>HC</sub> -D1HC-

## DHC D HC D<sub>1HC</sub> 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<sub>1HC</sub>= Crest diameter
- = Suitable twist drill diameter. Please note: D<sub>1HC</sub> 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 t<sub>2</sub> 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  $t_2$ .

