

# HELICOIL® manual taps

Type 0140.2 | UNF

Finishing tap (product type 0140.2)

Manual tap for through holes and blind holes to create holding threads (acc. to NASM33537) for HELICOIL® coil thread inserts. A manual tap, a taper tap (product type 0140.1), is required in addition.



**Properties:**

- 2-pitch chamfer
- Machining of materials with 700 N/mm<sup>2</sup> strength max.

**Note:**

The taper tap (product type 0140.1) must be ordered as a separate item.

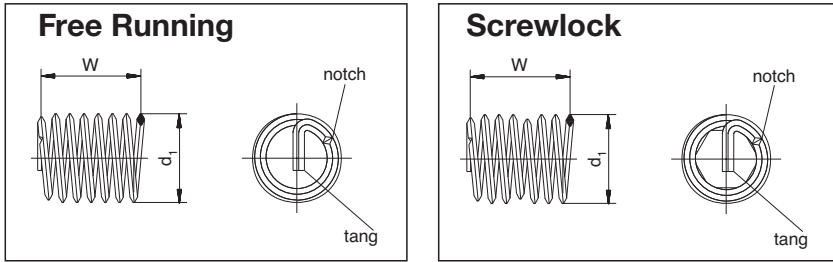
Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)
UNF 1/4"-28	01402747102	0.91
UNF 5/16"-24	01402767102	1.05
UNF 3/8"-24	01402777102	1.05
UNF 7/16"-20	01402787102	1.27
UNF 1/2"-20	01402797102	1.27
UNF 9/16"-18	01402807102	1.41
UNF 5/8"-18	01402817102	1.41
UNF 3/4"-16	01402837102	1.59
UNF 7/8"-14	01402857102	1.81
UNF 1"-12	01402867102	2.12
UNF 1 1/8"-12	01402877102	2.12
UNF 1 1/4"-12	01402887102	2.12
UNF 1 1/2"-12	01402907102	2.12
UNF 4-48	01402657102	0.53
UNF 6-40	01402677102	0.63
UNF 8-36	01402687102	0.71
UNF 10-32	01402697102	0.79

All technical data refer to the measure mm

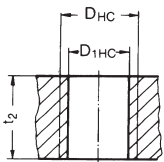


## HELICOIL® Plus thread inserts

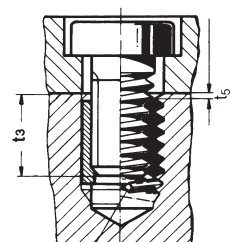
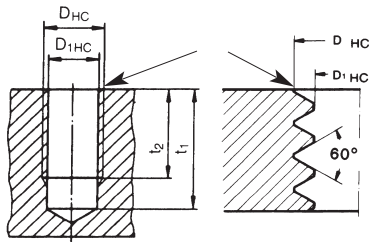
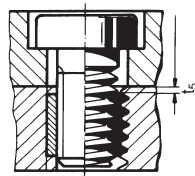


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

