

Hand taps HELICOIL® plus and HELICOIL®



Type 0140.0

HELICOIL® cutting taps

- for coarse threads up to $P = 2$ mm
- for fine threads up to $P = 3$ mm
- For cutting operations of materials with strengths up to 700 N/mm²
- For through holes
- For blind holes only if there is sufficient tapping space. The core holes to be cut at least 1 d deeper than the fully cut thread length.

① Standard HELICOIL® hand taps produce a holding thread of tolerance class 5H (6H mod). The HELICOIL® installation results in an ISO thread of tolerance class 6H. For HELICOIL® holding threads of tolerance class 4H (5H mod) the ninth digit of the product code changes from 1 to 2. The HELICOIL® installation results in an ISO thread of tolerance class 5H.

② The prices of HELICOIL® hand taps depend on the price of the relevant alloy on the supply date.

TiN coated taps can be supplied on request.

The cutting taps can also be supplied as machine taps.

Taps for special requirements, such as hard or tough materials, can be supplied on request.

For more detailed information, please ask for our catalogue 0100.

Thread size	Short machine taps for tolerance class 6H ①	
	Type 0140.0	
d (x P)	Order no.	€ ②
M 2	0140 002 0104	on request
M 2.5	0140 025 0104	on request
M 3	0140 003 0104	on request
M 3.5	0140 035 0104	on request
M 4	0140 004 0104	on request
M 5	0140 005 0104	on request
M 6	0140 006 0104	on request
M 7	0140 007 0104	on request
M 8	0140 008 0104	on request
M 8 x 1	0140 008 3104	on request
M 9	0140 009 0104	on request
M 10	0140 010 0104	on request
M 10 x 1	0140 010 3104	on request
M 10 x 1.25	0140 010 9104	on request
M 11	0140 011 0104	on request
M 12	0140 012 0104	on request
M 12 x 1	0140 012 3104	on request
M 12 x 1.25	0140 012 9104	on request
M 12 x 1.5	0140 012 4104	on request
M 14	0140 014 0104	on request
M 14 x 1	0140 014 3104	on request
M 14 x 1.25	0140 014 9104	on request
M 14 x 1.5	0140 014 4104	on request
M 16	0140 016 0104	on request
M 16 x 1.5	0140 016 4104	on request
M 18 x 1.5	0140 018 4104	on request
M 18 x 2	0140 018 5104	on request
M 20 x 1.5	0140 020 4104	on request
M 20 x 2	0140 020 5104	on request
M 22 x 1.5	0140 022 4104	on request
M 22 x 2	0140 022 5104	on request
M 24 x 1.5	0140 024 4104	on request
M 24 x 2	0140 024 5104	on request
M 26 x 1.5	0140 026 4104	on request
M 27 x 1.5	0140 027 4104	on request
M 27 x 2	0140 027 5104	on request
M 28 x 1.5	0140 028 4104	on request
M 30 x 1.5	0140 030 4104	on request
M 30 x 2	0140 030 5104	on request
M 33 x 2	0140 033 5104	on request
M 36 x 1.5	0140 036 4104	on request
M 36 x 2	0140 036 5104	on request
M 36 x 3	0140 036 6104	on request

Combined drilling and tapping tools for HELICOIL® plus and HELICOIL®



For tapping HELICOIL® holding threads in damaged metric standard and fine threads.

Pre-drilling of the HELICOIL® holding thread is not necessary. For blind holes the tool is only usable under certain conditions due to the guiding unit d 3 x L 5.

Thread size d (x P)	Order no.	€
M 6	0142 006 0102	on request
M 8	0142 008 0102	on request
M 10	0142 010 0102	on request
M 10 x 1	0142 910 3450	on request
M 12	0142 912 0450	on request
M 12 x 1.25	0142 912 9450	on request
M 12 x 1.5	0142 912 4450	on request
M 14	0142 914 0450	on request
M 14 x 1.25*	0142 914 9450	on request
M 14 x 1.25**	0142 014 9102	on request
M 14 x 1.5	0142 914 4450	on request
M 16	0142 916 0450	on request
M 16 x 1.5	0142 916 4450	on request

* L1 = 92

** L1 = 153

Machine tap former for HELICOIL® plus and HELICOIL®



Non-cutting forming of inner threads for through hole and blind holes

With lubrication grooves

Perfect lubrication even at larger depths

Speeds corresponding to thread tap

Lubrication:

Lubricant containing oils or emulsions containing grease

Material range:

Mouldable materials such as aluminium, copper and zinc alloys, steel up to 700 N/mm², stainless steels.

Thread size d (x P)	Standard value formed hole Ø d _F	Order no. ①	€
M 3	3.4	0144 103 0004	on request
M 3.5	4.0	0144 135 0004	on request
M 4	4.6	0144 104 0004	on request
M 5	5.6	0144 105 0004	on request
M 6	6.8	0144 106 0004	on request
M 8	9.0	0144 108 0004	on request
M 10	11.2	0144 110 0004	on request
M 12	13.4	0144 112 0004	on request

Other dimensions upon request.

We also provide TiN-coated thread former.

① For tolerance class 4H the ninth digit in the ordering ref. no. changes from 5 to 4. Details refer to catalogue 0100.

Installation mandrel for HELICOIL® plus



Only for HELICOIL® plus thread inserts type free running.

Not to be used for type SCREWLOCK®!

Thread size	Installation mandrel for HELICOIL® plus	
d (x P)	Order no.	€
M 2.5	4150 012 5000	on request
M 3	4150 010 3000	on request
M 3.5	4150 013 5000	on request
M 4	4150 010 4000	on request
M 5	4150 010 5000	on request
M 6	4150 010 6000	on request
M 7	4150 010 7000	on request
M 8	4150 010 8000	on request
M 8 x 1	4150 010 8300	on request
M 9	4150 010 9000	on request
M 10	4150 011 0000	on request
M 10 x 1	4150 011 0300	on request
M 10 x 1.25	4150 011 4900	on request
M 11	4150 011 1000	on request
M 12	4150 011 2000	on request
M 12 x 1.25	4150 011 2900	on request
M 12 x 1.5	4150 011 2400	on request
M 14	4150 011 4000	on request
M 14 x 1.25	4150 011 4900	on request
M 14 x 1.5	4150 011 4400	on request
M 16	4150 011 6000	on request
M 16 x 1.5	4150 011 6400	on request
M 18	4150 011 8000	on request
M 20	4150 012 0000	on request
M 22	4150 012 2000	on request
M 24	4150 012 4000	on request

Fly-over tool for HELICOIL® plus and HELICOIL®



Fly-over tool for HELICOIL® and HELICOIL® plus

Type **H-M**

with bit gauge

Order no. 0150 **07**. ...*

Thread size	Fly-over tool for HELICOIL® plus Type H-M	
d	Order no.	€
M 18	0150 071 8000	on request
M 20	0150 072 0000	on request
M 22	0150 072 2000	on request
M 24	0150 072 4000	on request
M 27	0150 072 7000	on request
M 30	0150 073 0000	on request
M 33	0150 073 3000	on request
M 36	0150 073 6000	on request

* For thread inserts made from NiCr 15 Fe 7 Ti Al, NiCr 20 Co 18 Ti, AlZn Mg Cu 1,5 adapted tools upon request.

Suitable both for types free running and SCREWLOCK®.

The tool finish depends on the thread size and the pitch.