

HeliCoil

MIN SUGGESTED BOSS DIAM	NOMINAL THREAD SIZE	SUGGESTED DRILL SIZE		DEPTH OF POINT	MIN DRILLING DEPTH FOR EACH INSERT LENGTH								COUNTERSINK DIAMETER		MIN TAP FULL THREAD DEPTH			
		Aluminum	Steel		Plug Taps				Bottoming Taps				Min	Max	FULL THREAD DEPTH			
					1D	1-1/2D	2D	2-1/2D	1D	1-1/2D	2D	2-1/2D			1D	1-1/2D	2D	2-1/2D
.223	2(.086)-56	3/32(.0938)	#41(.0960)	.029	.236	.279	.322	.365	.157	.200	.243	.286	.09	.11	.100	.150	.190	.230
.257	3(.099)-48	#36(.1065)	7/64(.1094)	.032	.273	.323	.372	.422	.182	.232	.281	.331	.11	.14	.120	.170	.220	.270
.294	4(.112)-40	#31(.1200)	#31(.1200)	.036	.318	.374	.430	.486	.212	.268	.324	.380	.14	.17	.140	.190	.250	.310
.320	5(.125)-40	3.4mm(.1339)	#29(.1360)	.041	.338	.400	.462	.525	.225	.288	.350	.412	.16	.19	.150	.210	.280	.340
.363	6(.138)-32	#26(.1470)	#25(.1495)	.045	.394	.484	.532	.602	.263	.332	.401	.470	.18	.21	.170	.240	.310	.380
.415	8(.164)-32	#17(.1730)	#16(.1770)	.053	.434	.516	.598	.680	.289	.371	.453	.535	.20	.23	.200	.280	.360	.440
.495	10(.190)-24	13/64(.2031)	#5(.2055)	.062	.535	.630	.725	.820	.357	.452	.547	.642	.24	.27	.230	.330	.420	.520
.547	12(.216)-24	#1(.2280)	#1(.2280)	.068	.574	.682	.790	.898	.383	.491	.599	.707	.26	.29	.260	.370	.470	.580
.637	1/4(.250)-20	H(.2660)	H(.2660)	.080	.675	.800	.925	1.050	.450	.575	.700	.825	.31	.34	.300	.430	.550	.680
.776	5/16(-.3125)-18	Q(.3320)	Q(.3220)	.100	.801	.957	1.113	1.269	.534	.690	.846	1.002	.38	.41	.370	.530	.680	.840

Note: Total drill depth equals depth of point plus drill depth.

Note: Locking thread located central to helicoil body. Installation of inserts shall be in accordance with NASM33537.

SUGGESTED SCREW LENGTH SELECTION DETERMINATION

Min. screw depth penetration= 75% of Full Thread Tap Depth

Max. screw depth penetration= 90% of Drill Depth For Particular Insert

