

TANGED INSERTS, TOOL & TAP SELECTION GUIDE

					Straight Flute				Spiral Point		High Spiral Flute	
					Plug		Bottoming		Plug		Bottoming	
Nominal Thread Size	Hand Installation Tool	Pneumatic Installation Tool	Tang Break Off Tool	Removal Tool	3B	2B	3B	2B	3B	2B	3B	2B
METRIC COARSE (FREE RUNNING & SCREW LOCKING)												
M2x0.4	7751-2		4238-2	1227-01	4687-2	2087-2	4693-2	2093-2	4863-2	4763-2	5081-2	4681-2
M2.5x0.45	7751-2.5	8751-2.5	4238-2.2	1227-06	4687-2.5	2087-2.5	4693-2.5	2093-2.5	4863-2.5	4763-2.5	5081-2.5	4681-2.5
M3x0.5	7751-3	8751-3	4238-3	1227-06	4687-3	2087-3	4693-3	2093-3	4863-3	4763-3	5081-3	4681-3
M3.5x0.6	7751-3.5	8751-3.5	4238-3	1227-06	4687-3.5	2087-3.5	4693-3.5	2093-3.5	4863-3.5	4763-3.5	5081-3.5	4681-3.5
M4x0.7	7751-4	8751-4	4238-4	1227-06	4687-4	2087-4	4693-4	2093-4	4863-4	4763-4	5081-4	4681-4
M5x0.8	7751-5	8751-5	4238-5	1227-6	4687-5	2087-5	4693-5	2093-5	4863-5	4763-5	5081-5	4681-5
M6x1	7751-6	8751-6	4238-6	1227-6	4687-6	2087-6	4693-6	2093-6	4863-6	4763-6	5081-6	4681-6
M7x1	7751-7	8751-7	4238-7	1227-6	4687-7	2087-7	4693-7	2093-7	4863-7	4763-7	5081-7	4681-7
M8x1.25	7751-8	8751-8	4238-8	1227-6	4687-8	2087-8	4693-8	2093-8	4863-8	4763-8	5081-8	4681-8
M10x1.5	7751-10	8751-10	4238-10	1227-6	4687-10	2087-10	4693-10	2093-10	4863-10	4763-10	5081-10	4681-10
M12x1.75	7751-12	8751-12	4238-12	1227-16	4687-12	2087-12	4693-12	2093-12	4863-12	4763-12	5081-12	4681-12
M14x2	7751-14		Pliers	1227-16	4687-14	2087-14	4693-14	2093-14				
M16x2	7751-16		Pliers	1227-16	4687-16	2087-16	4693-16	2093-16				
M18x2.5	7751-18		Pliers	1227-16	4687-18	2087-18	4693-18	2093-18				
M20x2.5	7751-20		Pliers	1227-16	4687-20	2087-20	4693-20	2093-20				
M22x2.5	7751-22		Pliers	1227-16	4687-22	2087-22	4693-22	2093-22				
M24x3	7751-24		Pliers	1227-16	4687-24	2087-24	4693-24	2093-24				
M27x3	7751-27		Pliers	1227-24	4687-27	2087-27	4693-27	2093-27				
M30x3.5	7751-30		Pliers	1227-24	4687-30	2087-30	4693-30	2093-30				
M33x3.5	7751-33		Pliers	1227-24	4687-33	2087-33	4693-33	2093-33				
M36x4	7751-36		Pliers	1227-24	4687-36	2087-36	4693-36	2093-36				
M39x4	7751-39		Pliers	1227-24	4687-39	2087-39	4693-39	2093-39				
METRIC FINE (FREE RUNNING & SCREW LOCKING)												
M8x1	7755-8	8755-8	4238-8	1227-6	5484-8	4984-8	5486-8	4986-8	4864-8	4764-8	5066-8	4666-8
M10x1	7755-10	8755-10	4238-10	1227-6	5484-10	4984-10	5486-10	4986-10	4864-10	4764-10	5066-10	4666-10
M10x1.25	7756-10	8756-10	4238-10	1227-6	5444-10	4944-10	5445-10	4945-10	4865-10	4765-10	5067-10	4667-10
M12x1.25	7756-12	8756-12	4238-12	1227-16	5444-12	4944-12	5445-12	4945-12	4865-12	4765-12	5067-12	4667-12
M14x1.5	7753-14		Pliers	1227-16	5476-14	4976-14	5477-14	4977-14				
M16x1.5	7753-16		Pliers	1227-16	5476-16	4976-16	5477-16	4977-16				
M18x1.5	7753-18		Pliers	1227-16	5476-18	4976-18	5477-18	4977-18				
M20x1.5	7753-20		Pliers	1227-16	5476-20	4976-20	5477-20	4977-20				
M22x1.5	7753-22		Pliers	1227-16	5476-22	4976-22	5477-22	4977-22				
M18x2	7754-18		Pliers	1227-16	5490-18	4990-18	5492-18	4992-18				
M20x2	7754-20		Pliers	1227-16	5490-20	4990-20	5492-20	4992-20				
M22x2	7754-22		Pliers	1227-16	5490-22	4990-22	5492-22	4992-22				
M18x2	7754-18		Pliers	1227-16	5490-18	4990-18	5492-18	4992-18				
M20x2	7754-20		Pliers	1227-16	5490-20	4990-20	5492-20	4992-20				
M22x2	7754-22		Pliers	1227-16	5490-22	4990-22	5492-22	4992-22				
M24x2	7754-24		Pliers	1227-16	5490-24	4990-24	5492-24	4992-24				
M27x2	7754-27		Pliers	1227-24	5490-27	4990-27	5492-27	4992-27				
M30x2	7754-30		Pliers	1227-24	5490-30	4990-30	5492-30	4992-30				
M33x2	7754-33		Pliers	1227-24	5490-33	4990-33	5492-33	4992-33				
M36x2	7754-36		Pliers	1227-24	5490-36	4990-36	5492-36	4992-36				
M39x2	7754-39		Pliers	1227-24	5490-39	4990-39	5492-39	4992-39				
M36x3	7752-36		Pliers	1227-24	5496-36	4996-36	5497-36	4997-36				
M39x3	7752-39		Pliers	1227-24	5496-39	4996-39	5497-39	4997-39				

HeliCoil® Thread repair kits & Master sets

Heli-Coil inserts are available in thread repair kits and sets for repairing tapped holes which have been stripped or damaged due to wear, corrosion and over-torque. They are available in inch, metric, spark plug and pipe thread series. All kits have a quantity of inserts, the proper size drill, high speed steel Heli-Coil tap and an installation tool.



The Professional Kits* (shown in **bold** type) also includes a tang removal tool and quantities of three lengths of inserts.



PROFESSIONAL KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
INCH COARSE THREAD (UNC)		
4-40	5401-04	36*
5-40	5401-05	36*
6-32	5401-06	36*
8-32	5401-2	36*
10-24	5401-3	36*
12-24	5401-1	36*
1/4-20	5401-4	36*
5/16-18	5401-5	36*
3/8-16	5401-6	18*
7/16-14	5401-7	18*
1/2-13	5401-8	18*
9/16-12	5401-9	6
5/8-11	5401-10	6
3/4-10	5401-12	4
7/8-9	5521-14	6
1-8	5521-16	6
1-1/8-7	5521-18	5
1-1/4-7	5521-20	4
1-3/8-6	5521-22	4
1-1/2-6	5521-24	4
INCH FINE THREAD (UNF)		
6-40	5402-06	36*
8-36	5402-2	36*
10-32	5402-3	36*
1/4-28	5402-4	36*
5/16-24	5402-5	36*
3/8-24	5402-6	18*
7/16-20	5402-7	18*
1/2-20	5402-8	18*
9/16-18	5402-9	6
5/8-18	5402-10	6
3/4-16	5402-12	4
7/8-14	5528-14	6
1-14	5528-16	6
1-12	5528-161	6
1-1/8-12	5528-18	5
1-1/4-12	5528-20	4
1-3/8-12	5528-22	4
1-1/2-12	5528-24	4

* The total quantity of inserts in the Professional Kits represents 3 lengths.

PROFESSIONAL KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
METRIC COARSE		
M3x0.5	5403-3	36*
M3.5x0.6	5403-3.5	36*
M4x0.7	5403-4	18*
M5x0.8	5403-5	18*
M6x1	5403-6	18*
M7x1	5403-7	18*
M8x1.25	5403-8	18*
M9x1.25	5403-9	12
M10x1.5	5403-10	18*
M11x1.5	5403-11	6
M12x1.75	5403-12	18*
M14x2	5403-14	12
M16x2	5403-16	6
M18x2.5	5403-18	6
M20x2.5	5403-20	4
METRIC FINE		
M8x1	5404-8	18*
M10x1	5404-10	18*
M10x1.25	5405-10	18*
M12x1.25	5405-12	18*
M12x1.5	5406-12	18*
M14x1.5	5406-14	6
M16x1.5	5406-16	6
M18x1.5	5406-18	6

* The total quantity of inserts in the Professional Kits represents 3 lengths.



MASTER THREAD REPAIR SETS

Type	Part No.	Insert sizes included in set
Inch Coarse	4934	1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13, 5/8-11
Inch Fine	4936	10-32, 1/4-28, 5/16-24, 3/8-24, 7/16-20, 1/2-20
Metric	4937-125	M5x0.8, M6x1, M8x1.25, M10x1.25
Metric	4937-150	M5x0.8, M6x1, M8x1.25, M10x1.5

All sets contain a drill, tap, tool and inserts for each size listed above.

SPARK PLUG KITS

Nominal Thread Size	Kit Part No.	Reach	Inserts Per Kit
10-1.0mm	5523-10	1/2	24
12-1.25mm	5523-12	1/2	12
		3/4	12
14-1.25mm	5523-14	3/8	6
		7/16	6
		1/2	6
		3/4	6
		.472	6
18-1.50mm	5523-18	1/2	24
7/8-18	550	1/2-5/8	10
M14x1.25*	5408-14	Short	6
		Normal	6
		Long	6

Note: Do not use Heli-Coil wire inserts to repair taper seat plug ports.



PIPE THREAD KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
1/8-27	5407-2	12
1/4-18	5407-4	12
3/8-18	5407-6	10
1/2-14	5407-8	10
3/4-14	5407-12	10
1-11-1/2	5407-16	6