

STANDARD ENGINEERING INSTRUCTION

Wire-Thread Inserts

DSP 1.1.2

1. Definition

These inserts are used where the threads are to be subjected to repeat use, typically where parts of the printer are removed and refitted (board clamps etc) The wire-thread insert can either have a locking feature embodied or be free-running; both types are made of stainless steel. The insert is fitted to an oversize thread using a special driver, which winds the insert into the oversized thread.

2. Extra Information:

The following information is required on the drawing:

- Type of insert (free-running or locking)
- Size, pitch (if not standard) and length of insert E.G. 2D (2x diameter of thread) Method of application (dip, spray, brush, etc.)
- ASMP part number Type of protection required (In process, storage or shipping)
- Suppliers E.G. Heli-coil or Boellhoff
- Reference to BS4377, BS3643, and DIN 8140

HELICOIL® Plus Screwlock Thread Inserts DIN 8140
Stainless Steel A2 | Coloured Red | Metric Standard Thread

Size	ASMP Part Number	(Old) ASMP Part Number	BOLLHOFF Number	Pitch (P)	t ₂ min.		(W)	d ₁ Min Max	(D _{1HC}) Min Max	(B)	(t ₃) Max	(D _{HC}) Min
					x d	mm						
M3	03327254-01	88193399	4132 003 0006	0.5	2 d	6	8.7	3.80 4.00	3.11 3.22	3.2	5.7	3.65
M4	03327256-01	88193400	4132 004 0008	0.7	2 d	8	8.4	5.05 5.25	4.15 4.29	4.2	7.6	4.91
M5	03327257-01	88193401	4132 005 0010	0.8	2 d	10	9.7	6.35 6.60	5.17 5.33	5.2	9.6	6.04
M6	03327258-01	88193402	4132 006 0012	1	2 d	12	9.6	7.60 7.85	6.22 6.41	6.3	11.5	7.3

Issue	01	02	03	04	05	06	07	08
Date	31998	32322	40284	17/08/26				

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Wire-Thread Inserts

DSP 1.1.2

Important All New Wire-Thread Inserts Are to Be Added to The Above & Below List

HELICOIL® Plus Free Running Thread Inserts DIN 8140
Stainless Steel A2 | **Coloured Green** | Metric Standard Thread

Size	ASMPT Part Number	(Old) ASMPT Part Number	BOLLHOFF Number	Pitch (P)	t ₂ min.		(W)	d ₁ Min Max	(D _{1HC}) Min Max	(B)	(t ₃) Max	(D _{HC}) Min
					x d	(mm)						
M2	03326870-01	N/A	4130 002 0002	0.4	1 d	2	2.9	2.60 2.80	2.09 2.18	2.1	1.8	2.52
	03168010-01	N/A	4130 002 0003		1.5 d	3	4.9				2.8	
	03326967-01	N/A	4130 002 0004		2 d	4	6.9				3.8	
M2.5	03326970-01	N/A	4130 025 0025	0.45	1 d	2.5	3.5	3.30 3.50	2.60 2.70	2.6	2.3	3.08
	03326971-01	N/A	4130 025 0375		1.5 d	3.75	5.9				3.5	
	03168009-01	N/A	4130 025 0005		2 d	5	8.1				4.8	
M3	03326974-01	N/A	4130 003 0003	0.5	1 d	3	3.9	3.8 4.0	3.11 3.22	3.2	2.7	3.65
	03158550-01	N/A	4130 003 0045		1.5 d	4.5	6.3				4.2	
	03158547-01	88193403	4130 003 0006		2 d	6	8.7				5.7	
M4	03161177-01	N/A	4130 004 0004	0.7	1 d	4	3.7	5.05 5.25	4.15 4.29	4.2	3.6	4.91
	03108506-01	N/A	4130 004 0006		1.5 d	6	6.1				5.6	
	03326975-01	88191805	4130 004 0008		2 d	8	8.4				7.6	
M5	88198357-01	88198357	4130 005 0005	0.8	1 d	5	4.3	6.35 6.60	5.17 5.33	5.2	4.6	6.04
	03108507-01	N/A	4130 005 0075		1.5 d	7.5	6.9				7.1	
	03326977-01	88193404	4130 005 0010		2 d	10	9.7				9.6	
M6	03326980-01	N/A	4130 006 0006	1	1 d	6	4.2	7.60 7.85	6.22 6.41	6.3	5.5	7.3
	03124502-01	N/A	4130 006 0009		1.5 d	9	6.9				8.5	
	03326981-01	88193405	4130 006 0012		2 d	12	9.6				11.5	
	03108508-01	N/A	4130 003 0018		3 d	18	14.6				17.5	
M8	03326982-01	N/A	4130 008 0008	1.25	1 d	8	4.7	9.85 10.10	8.27 8.48	8.4	7.4	9.62
	03326983-01	N/A	4130 008 0012		1.5 d	12	7.4				11.4	
	03326984-01	N/A	4130 008 0016		2 d	16	10.6				15.4	
M10	03326985-01	N/A	4130 010 0010	1.5	1 d	10	5	12.10 12.50	10.32 10.56	11	9.2	12
	03326986-01	N/A	4130 010 0015		1.5 d	15	8.1				14.2	
	03326987-01	N/A	4130 010 0020		2 d	20	11.2				19.2	
M12	03326988-01	N/A	4130 012 0012	1.75	1 d	12	5.2	14.40 14.80	12.38 12.64	13	11.1	14.3
	03326989-01	N/A	4130 012 0018		1.5 d	18	8.4				17.1	
	03326990-01	N/A	4130 012 0024		2 d	24	11.7				23.1	

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