



COMPLETE TOOL KIT

SCREW THREAD SERIES	NOMINAL THREAD SIZE		HELISERT INSERT IDENTIFICATION NUMBER (FOR STAINLESS STEEL NOTCHED)		BASIC LENGTH "Q" MM Equal to length of minimum through hole, or minimum length of full form thread in blind hole. Actual length of assembled insert equal basic length less 1/2 pitch.								DRILLS		TAPS			GAUGES	HELISERT TOOLS		
					1	2	3	4	5	6	7	8	8A	9	9A	10	11	12	13	14	15
	DIA MM	PITCH MM	STANDARD (STD)	SCREW LOCK (SCL)	0.5 DIA	0.75 DIA	1.00 DIA	1.5 DIA	2 DIA	2.5 DIA	RECOMMENDED SIZE	ALTERNATIVE SIZE	ROUGHING TAP	FINISHING PLUG TAP	FINISHING BOTTOMING TAP	GAUGE	PREWINDER TYPE INSERTING TOOL	TANG BREAK OFF TOOL	EXTRACTING TOOL		
METRIC COARSE SERIES	M3	0.5	-C3 CN	-C3 CN			3	4.5	6	7.5	3.1	3.2	MC3 R	MC3 P	MC3 B	MC3-GN	MC3-IPS	MC3-TB	1227-06		
	M4	0.7	-C4 CN	-C4 CN			4	6	8	10	4.1	4.2	MC4 R	MC4 P	MC4 B	MC4-GN	MC4-IPS	MC4-TB	1227-06		
	M5	0.8	-C5 CN	-C5 CN			5	7.5	10	12.5	5.1	5.2	MC5 R	MC5 P	MC5 B	MC5-GN	MC5-IPS	MC5-TB	1227-6		
	M6	1	-C6 CN	-C6 CN			6	9	12	15	6.2	6.3	MC6 R	MC6 P	MC6 B	MC6-GN	MC6-IPS	MC6-TB	1227-6		
	M7	1	-C7 CN	-C7 CN			7	10	14	17.5	7.2	7.3	MC7 R	MC7 P	MC7 B	MC7-GN	MC7-IP	MC7-TB	1227-6		
	M 8	1.25	-C8 CN	-C8 CN			8	12	16	20	8.2	8.3	MC8 R	MC8 P	MC8 B	MC8-GN	MC8-IP	MC8-TB	1227-6		
	M 10	1.5	-C10 CN	-C10 CN			10	15	20	25	10.2	10.3	MC10 R	MC10 P	MC10 B	MC10-GN	MC10-IP	MC10-TB	1227-6		
	M 12	1.75	-C12 CN	-C12 CN			12	18	24	30	12.25	31/64"	MC12 R	MC12 P	MC12 B	MC12-GN	MC12-IP	MC12-TB	1227-16		
	M 14	2	-C14 CN	-C14 CN			14	21	28	35	14.25	14.5	MC14 R	MC14 P	MC14 B	MC14-GN	MC14-IP	MC14-TB	1227-16		
	M 16	2	-C16 CN	-C16 CN	8	12	16	24	32	40	16.25	16.5	MC16 R	MC16 P	MC16 B	MC16-GN	MC16-IP	MC16-TB	1227-16		
	M 18	2.5	-C18 CN	-C18 CN	9	13.5	18	27	36	45	18.5	18.75	MC18 R	MC18 P	MC18 B	MC18-GN	MC18-IP	MC18-TB	1227-16		
	M 20	2.5	-C20 CN	-C20 CN	10	15	20	30	40	50	20.5	20.75	MC20 R	MC20 P	MC20 B	MC20-GN	MC20-IP	MC20-TB	1227-16		
	M 22	2.5	-C22 CN		11	16.5	22	33	44	55	22.5	22.75	MC22 R	MC22 P	MC22 B	MC22-GN	MC22-IP	MC22-TB	1227-16		
	M 24	3	-C24 CN		12	18	24	36	48	60	24.5	24.75	MC24 R	MC24 P	MC24 B	MC24-GN	MC24-IP	MC24-TB	1227-16		
	M 27	3	-C27 CN		13.5	20.25	27	40.5	54		27.5	27.75	MC27 R	MC27 P	MC27 B	MC27-GN	MC27-IP		1227-24		
	M 30	3.5	-C30 CN		15	22.5	30	45	60		30.5	30.75	MC30 R	MC30 P	MC30 B	MC30-GN	MC30-IP	USE LONG NOSED PLIERS	1227-24		
	M 33	3.5	-C33 CN		16.5	26.75	33	49.5	66		33.5	33.75	MC33 R	MC33 P	MC33 B	MC33-GN	MC33-IP		1227-24		
	M 36	4	-C36 CN		18	27	36	54	72		36.75	37	MC36 R	MC36 P	MC36 B	MC36-GN	MC36-IP		1227-24		
M 39	4	-C39 CN		19.5	29.25	39	58.5	78		39.75	40	MC39 R	MC39 P	MC39 B	MC39-GN	MC39-IP	1227-24				
METRIC FINE SERIES	M 8	1	-F8 CN	-F8 CN			8	12	16	20	8.2	8.3	MF8 R	MF8 P	MF8 B	MF8-GN	MF8-IP	MF8-TB	1227-6		
	M 10	1.25	-F10 CN	-F10 CN			10	15	20	25	10.2	10.3	MF10 R	MF10 P	MF10 B	MF10-GN	MF10-IP	MF10-TB	1227-6		
	M 12	1.25	-F12 CN	-F12 CN			12	18	24	30	12.2	12.3	MF12 R	MF12 P	MF12 B	MF12-GN	MF12-IP	MF12-TB	1227-16		
	M 14	1.5	-F14 CN	-F14 CN			14	21	28	35	14.25	9 / 16"	MF14 R	MF14 P	MF14 B	MF14-GN	MF14-IP	MF14-TB	1227-16		
	M 16	1.5	-F16 CN	-F16 CN	8	12	16	24	32		16.25	41 / 64"	MF16 R	MF16 P	MF16 B	MF16-GN	MF16-IP	MF16-TB	1227-16		
	M 18	1.5	-F18 CN	-F18 CN	9	13.5	18	27	36		18.25		MF18 R	MF18 P	MF18 B	MF18-GN	MF18-IP	MF18-TB	1227-16		
	M 20	1.5	-F20 CN	-F20 CN	10	15	20	30	40		20.25		MF20 R	MF20 P	MF20 B	MF20-GN	MF20-IP	MF20-TB	1227-16		
	M 22	2	-F22 CN		11	16.5	22	33	44		22.25		MF22 R	MF22 P	MF22 B	MF22-GN	MF22-IP	MF22-TB	1227-16		
	M 24	2	-F24 CN		12	18	24	36	48		24.25	24.5	MF24 R	MF24 P	MF24 B	MF24-GN	MF24-IP	MF24-TB	1227-16		
	M 27	2	-F27 CN		13.5	20.25	27	40.5			27.25	27.5	MF27 R	MF27 P	MF27 B	MF27-GN	MF27-IP		1227-24		
	M 30	2	-F30 CN		15	22.5	30	45			30.25	30.5	MF30 R	MF30 P	MF30 B	MF30-GN	MF30-IP	USE LONG NOSED PLIERS	1227-24		
	M 33	2	-F33 CN		16.5	26.75	33	49.5			33.25	33.5	MF33 R	MF33 P	MF33 B	MF33-GN	MF33-IP		1227-24		
M 36	3	-F36 CN		18	27	36	54			36.5	36.75	MF36 R	MF36 P	MF36 B	MF36-GN	MF36-IP	1227-24				
M 39	3	-F39 CN		19.5	29.25	39	58.5			39.5	39.75	MF39 R	MF39 P	MF39 B	MF39-GN	MF39-IP	1227-24				
BASIC LENGTH "Q"																					
SPARK PLUG SERIES	M 14	1.25	SP-14 CN		7.5 (for body reach 9.5)	10.5 (for body reach 12.7)	17 (for body reach 19)				14.25	9 / 16"	SP-14 R	SP-14 P	SP-14 B	SP-14 GN	SP-14 IP	USE PLIERS	1227-16		
	M18	1.5	SP-18 CN		10.7 (for body reach 12.7)	2.0 (for body reach 14)					18.25		SP-18 R	SP-18 P	SP-18 B	SP-18 GN	SP-18 IP		1227-16		

NOTE

- Drills** - Tapping drills listed in Col.9, are suitable for Aluminium. For Steel the alternative size i.e., Col. 9A should be used.
- Taps** - Metric i.e., Col. 10,11 & 12 will produce 5H & Fine 4H fits. in UNC/UNF i.e., Col. 10,11 & 12 will produce 2B & 3B fits.
- Gauges** - Thread Plug Gauges (Col. 13) 5H fit for Metric and 2B & 3B fit for Inches. These are used to check up tapped holes before installation of inserts.
- Inserting Tools** - Prewinder Type (Col. 14) is recommended for all size of Inserts
- Tang Break off Tools** - Col. 15.
- Extracting Tool** - Col. 16.



SCREW THREAD SERIES		COMPLETE TOOL KIT																
		DRILLS		TAPS			GAUGES	HELISERT TOOLS										
NOMINAL THREAD SIZE	HELISERT INSERT IDENTIFICATION NUMBER (FOR STAINLESS STEEL NOTCHED)	BASIC LENGTH "Q" INCHES Equal to length of minimum through hole, or minimum length of full form thread in blind hole. Actual length of assembled insert equals basic length less 1/2 pitch.																
		1	2	3	4	5	6	7	8	9	9A	10	11	12	13	14	15	16
TPI	STANDARD (STD)	SCREW LOCK (SCL)	1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	RECOMMENDED SIZE	ALTERNATIVE SIZE	ROUGHING TAP	FINISHING PLUG TAP	FINISHING BOTTOMING TAP	GAUGE	REMEMBER TO USE INSERTING TOOL	TANG BREAK OFF TOOL	EXTRACTING TOOL		
UN COARSE SERIES	# 6	32	1185-06 CN	3585-06 CN	0.138	0.207	0.276	0.345	0.414	3.7mm	#26		06 CPB	06 CBB	1440-06	3551-06	3580-06	1227-06
	# 8	32	1185-2 CN	3585-2 CN	0.164	0.246	0.328	0.410	0.492	#17	4.4mm		2 CPB	2 CBB	1440-2	3551-2	3580-2	1227-06
	# 10	24	1185-3 CN	3585-3 CN	0.190	0.285	0.380	0.475	0.570	#7	5.2mm		3 CPB	3 CBB	1440-3	3551-3	3580-3	1227-6
	# 12	24	1185-1 CN	3585-1 CN	0.216	0.324	0.432	0.540	0.648	5.7mm	#1		1 CPB	1 CBB	1440-1	3551-1	3580-1	1227-6
	1/4"	20	1185-4 CN	3585-4 CN	1/4	3/8	1/2	5/8	3/4	G	6.7mm		4 CPB	4 CBB	1440-4	3551-4	3580-4	1227-6
	5/16"	18	1185-5 CN	3585-5 CN	5/16	15/32	5/8	25/32	15/16	21/64	8.4mm		5 CPB	5 CBB	1440-5	3551-5	3580-5	1227-6
	3/8"	16	1185-6 CN	3585-6 CN	3/8	9/16	3/4	15/16	1 1/8	25/64	10mm		6 CPB	6 CBB	1440-6	3551-6	3580-6	1227-6
	7/16"	14	1185-7 CN	3585-7 CN	7/16	21/32	7/8	1 3/32	1 5/16	29/64	11.6mm		7 CPB	7 CBB	1440-7	3551-7	3580-7	1227-16
	1/2"	13	1185-8 CN	3585-7 CN	1/2	3/4	1	1 1/4	1 1/2	33/64	13.2mm	8 CRU	8 CPB	8 CBB	1440-8	3551-8	3580-8	1227-16
	9/16"	12	1185-9 CN	3585-9 CN	9/16	27/32	1 1/8	1 13/32	1 11/16	14.75mm	15mm	9 CRU	9 CPB	9 CBB	1440-9	3551-9	3580-9	1227-16
	5/8"	11	1185-10 CN	3585-10 CN	5/8	15/16	1 1/4	1 3/16	1 7/8	16.5mm	21/32	10 CRU	10 CPB	10 CBB	1440-10	3551-10	3580-10	1227-16
	3/4"	10	1185-12 CN	3585-12 CN	3/4	1 1/8	1 1/2	1 7/8	2 1/4	19.75mm	25/32	12 CRU	12 CPB	12 CBB	1440-12	3551-12	3580-12	1227-16
	1"	9	1185-14 CN		7/8	1 5/16	1 3/4	2 3/16	2 5/8	23mm	29/32	14 CRU	14 CPB	14 CBB	1440-14		3580-14	1227-16
	1 1/8"	8	1185-16 CN		1	1 1/2	2	2 1/2		26.25mm	1 1/32	16 CRU	16 CPB	16 CBB	1440-16		3580-16	1227-16
	1 1/8"	7	1185-18 CN		1 1/8	1 11/16	2 1/4	1 13/16		1 5/32	1 11/64	18 CRU	19 CPB	18 CBB	1440-18			1227-24
	1 1/4"	7	1185-20 CN		1 1/4	1 7/8	2 1/2	3 1/8		1 9/32	1 19/64	20 CRU	20 CPB	20 CBB	1440-20			1227-24
	1 3/8"	6	1185-22 CN		1 3/8	2 1/16	2 3/4			35.75mm	36mm	22 CRU	22 CPB	22 CBB	1440-22			1227-24
	1 1/2"	6	1185-24 CN		1 1/2	2 1/4	3			39.25mm	39.5mm	24 CRU	24 CPB	24 CBB	1440-24			1227-24
UN FINE SERIES	# 10	32	1191-3 CN		0.190	0.285	0.380	0.475	0.570	# 8	05.50 mm		3 FPB	3 FBB	1441-3	3552-3	3581-3	1227-6
	1/4"	28	1191-4 CN	3591-4 CN	1/4	3/8	1/2	5/8	3/4	G	06.70 "		4 FPB	4 FBB	1441-4	3552-4	3581-4	1227-6
	5/16"	24	1191-5 CN	3591-5 CN	5/16	15/32	5/8	25/32	15/16	P	08.20 "		5 FPB	5 FBB	1441-5	3552-5	3581-5	1227-6
	3/8"	24	1191-6 CN	1191-6 CN	3/8	9/16	3/4	15/16	1 1/8	9.8 mm	09.80 "		6 FPB	6 FBB	1441-6	3552-6	3581-6	1227-6
	7/16"	20	1191-7 CN	1191-7 CN	7/16	21/32	7/8	13/16	5/8	29/64	11.50 "		7 FPB	7 FBB	1441-7	3552-7	3581-7	1227-16
	1/2"	20	1191-8 CN	1191-8 CN	1/2	3/4	1	1 1/4	1 1/2	33/64	13.00 "		8 FPB	8 FBB	1441-8	3552-8	3581-8	1227-16
	9/16"	18	1191-9 CN	1191-9 CN	9/16	27/32	1 1/8	13/16	1 11/16	37/64	14.75 "		9 FPB	9 FBB	1441-9	3552-9	3581-9	1227-16
	5/8"	18	1191-10 CN	1191-10 CN	5/8	15/16	1 1/4	1 9/16	1 7/8	41/64	16.25 "		10 FPB	10 FBB	1441-10	3552-10	3581-10	1227-16
	3/4"	16	1191-12 CN	1191-12 CN	3/4	1 1/8	1 1/2	1 7/8	2 1/4	49/64	19.50 "		12 FPB	12 FBB	1441-12	3552-12	3581-12	1227-16
	7/8"	14	1191-14 CN		7/8	5/16	1 3/4	2 3/16	2 5/8	57/64	22.75 "		14 FPB	14 FBB	1441-14	3552-14	3581-14	1227-16
	1"	12	1191-16 CN		1	1 1/2	2	2 1/2		1 1/64	26.00 "		96 FPB	96 FBB	1441-161	3552-161	3581-161	1227-16
	1 1/8"	12	1191-18 CN		1 1/8	1 11/16	2 1/4	1 13/16		1 9/64	29.25 "		18 FPB	18 FBB	1441-18	3552-18		1227-24
	1 1/4"	12	1191-20 CN		1 1/4	1 7/8	2 1/2	3 1/8		1 17/64	32.25 "		20 FPB	20 FBB	1441-20	3552-20		1227-24
	1 3/8"	12	1191-22 CN		1 3/8	2 1/16	2 3/4			1 25/64	35.50 "		22 FPB	22 FBB	1441-22	3552-22		1227-24
1 1/2"	12	1191-24 CN		1 1/2	2 1/4	3			1 33/64	38.75 "		24 FPB	24 FBB	1441-24	3552 -24		1227-24	

To order:
 INSERTS – Select Part No. from Columns 2 or 3 from table and add basic length.
 TOOLS – Simply state part Nos. from the columns.

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