

STANLEY[®]
Engineered Fastening

HELI-COIL[®]
Tool And Tap
Selection Guide
For Tanged Inserts

Technical Bulletin HC1045

HeliCoil[®]

TANGED INSERTS, TOOL & TAP SELECTION GUIDE

					Straight Flute				Spiral Point		High Spiral Flute	
Nominal Thread Size	Hand Installation Tool	Pneumatic Installation Tool	Tang Break Off Tool	Removal Tool	Plug		Bottoming		Plug		Bottoming	
					3B	2B	3B	2B	3B	2B	3B	2B
UNIFIED COARSE THREAD (UNC) ; (FREE RUNNING & SCREW-LOCKING)												
2-56	551-02	8551-02	3695-02	1227-02	02CPB	02CPA	02CBB	02CBA	02CSB	02CSA	5905-02	6905-02
4-40	7551-04	8551-04	3695-04	1227-06	04CPB	04CPA	04CBB	04CBA	04CSB	04CSA	5905-04	6905-04
6-32	7551-06	8551-06	3695-06	1227-06	06CPB	06CPA	06CBB	06CBA	06CSB	06CSA	5905-06	6905-06
8-32	7551-2	8551-2	3695-2	1227-06	2CPB	2CPA	2CBB	2CBA	2CSB	2CSA	5905-2	6905-2
10-24	7551-3	8551-3	3695-3	1227-6	3CPB	3CPA	3CBB	3CBA	3CSB	3CSA	5905-3	6905-3
1/4-20	7551-4	8551-4	3695-4	1227-6	4CPB	4CPA	4CBB	4CBA	4CSB	4CSA	5905-4	6905-4
5/16-18	7551-5	8251-5	3695-5	1227-6	5CPB	5CPA	5CBB	5CBA	5CSB	5CSA	5905-5	6905-5
3/8-16	7551-6	8251-6	3695-6	1227-16	6CPB	6CPA	6CBB	6CBA	6CSB	6CSA	5905-6	6905-6
7/16-14	7551-7	8251-7	3695-7	1227-16	7CPB	7CPA	7CBB	7CBA	7CSB	7CSA	5905-7	6905-7
1/2-20	7552-8	8252-8	3692-8	1227-16	8FPB	8FPA	8FBB	8FBA	8FSB	8FSA	5906-8	6906-8
9/16-12	3724-9		Pliers	1227-16	187-9	38187-9	4187-9	43187-9				
5/8-11	3724-10		Pliers	1227-16	8187-10	18187-10	10187-10	20187-10				
3/4-10	3724-12		Pliers	1227-16	8187-12	18187-12	10187-12	20187-12				
7/8-9	3724-14		Pliers	1227-16	8187-14	18187-14	10187-14	20187-14				
1-8	3724-16		Pliers	1227-16	8187-16	18187-16	10187-16	20187-16				
1-1/8-7	3724-18		Pliers	1227-24	8187-18	18187-18	10187-18	20187-18				
1-1/4-7	3724-20		Pliers	1227-24	8187-20	18187-20	10187-20	20187-20				
1-3/8-6	3724-22		Pliers	1227-24	8187-22	18187-22	10187-22	20187-22				
1-1/2-6	3724-24		Pliers	1227-24	8187-24	18187-24	10187-24	20187-24				
UNIFIED FINE THREAD (UNF) ; (FREE RUNNING & SCREW-LOCKING)												
2-64	7552-02		3695-02	1227-02	02FPB	02FPA	02FBB	02FBA	02FSB	02FSA	5906-02	6906-02
3-56	7552-03		3695-02	1227-06	03FPB	03FPA	03FBB	03FBA	03FSB	03FSA	5906-03	6906-03
4-48	7552-04		3695-04	1227-06	04FPB	04FPA	04FBB	04FBA	04FSB	04FSA	5906-04	6906-04
6-40	7552-06	8552-06	3695-06	1227-06	06FPB	06FPA	06FBB	06FBA	06FSB	06FSA	5906-06	6906-06
8-36	7552-2		3695-2	1227-06	2FPB	2FPA	2FBB	2FBA	2FSB	2FSA	5906-2	6906-2
10-32	7552-3	8552-3	3695-3	1227-6	3FPB	3FPA	3FBB	3FBA	3FSB	3FSA	5906-3	6906-3
1/4-28	7552-4	8552-4	3695-4	1227-6	4FPB	4FPA	4FBB	4FBA	4FSB	4FSA	5906-4	6906-4
5/16-24	7552-5	8251-5	3692-5	1227-6	5FPB	5FPA	5FBB	5FBA	5FSB	5FSA	5906-5	6906-5
3/8-24	7552-6	8251-6	3692-6	1227-6	6FPB	6FPA	6FBB	6FBA	6FSB	6FSA	5906-6	6906-6
7/16-20	7552-7	8251-7	3692-7	1227-16	7FPB	7FPA	7FBB	7FBA	7FSB	7FSA	5906-7	6906-7
1/2-20	7552-8	8252-8	3692-8	1227-16	8FPB	8FPA	8FBB	8FBA	8FSB	8FSA	5906-8	6906-8
9/16-18	535-9		Pliers	1227-16	38193-9	18193-9	43193-9	20193-9				
5/8-18	535-10		Pliers	1227-16	8193-10	18193-10	10193-10	20193-10				
3/4-16	535-12		Pliers	1227-16	8193-12	18193-12	10193-12	20193-12				
7/8-14	535-14		Pliers	1227-16	8193-14	18193-14	10193-14	20193-14				
1-14	535-16		Pliers	1227-16	8193-16	18193-16	10193-16	20193-16				
1-12	535-161		Pliers	1227-16	8193-161	18193-161	10193-161	20193-161				
1-1/8-12	535-18		Pliers	1227-24	8193-18	18193-18	10193-18	20193-18				
1-1/4-12	535-20		Pliers	1227-24	8193-20	18193-20	10193-20	20193-20				

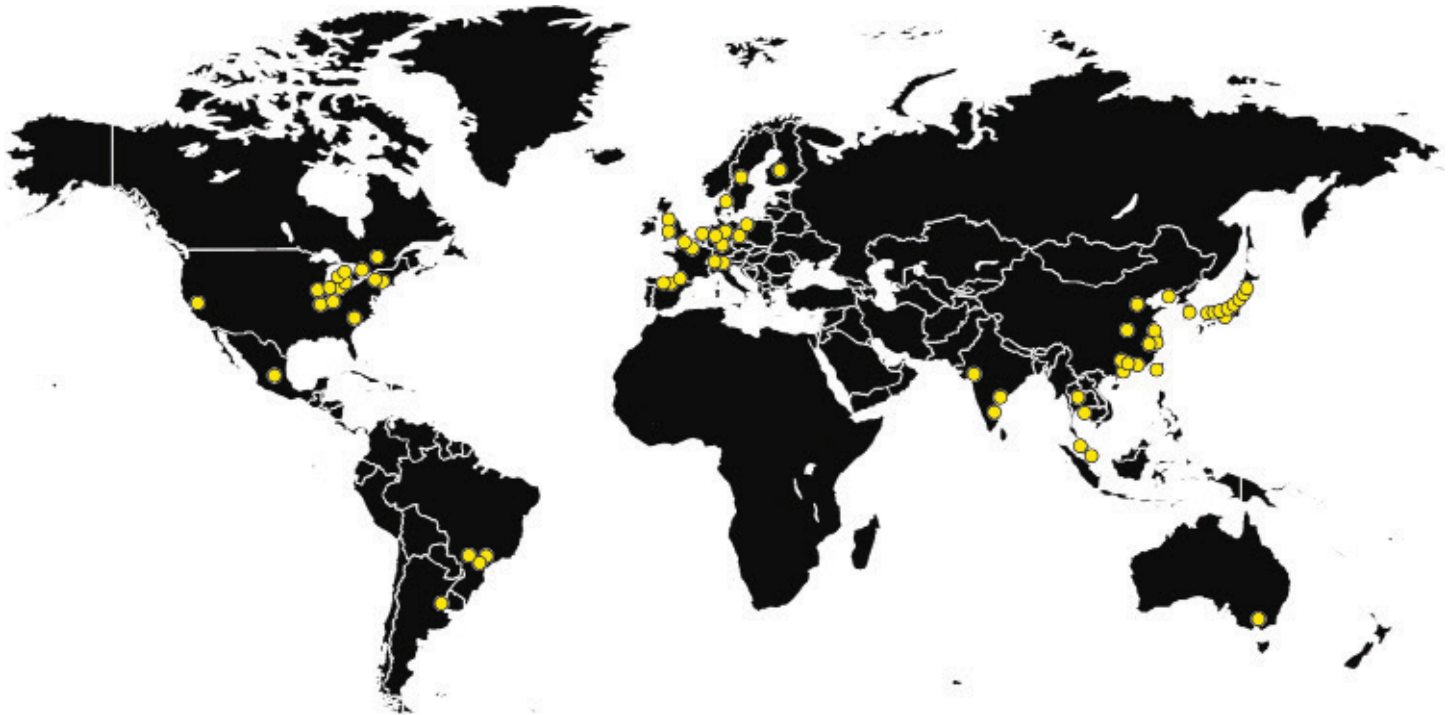
TANGED INSERTS, TOOL & TAP SELECTION GUIDE

Nominal Thread Size	Hand Installation Tool	Pneumatic Installation Tool	Tang Break Off Tool	Removal Tool	Straight Flute				Spiral Point		High Spiral Flute	
					Plug		Bottoming		Plug		Bottoming	
					4H5H	5H	4H5H	5H	4H5H	5H	4H5H	5H
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				

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