



Helicoil®

Tangless® Inserts

Tangless® screw lock inserts provide a positive, self-locking torque complying with the requirements of NASM8846.

Tapped threads are strengthened because of the balanced distribution of static and dynamic loads throughout the engagement length resulting in stronger assemblies.

Tangless inserts require a smaller boss than solid inserts and minimize total in-place cost.

Features & Benefits:

- Eliminates tang break-off and retrieval
- Symmetrical design eliminates the need for orientation during installation
- Adjusted or removed easily
- Eliminates stress in the parent material
- Conforms to NAS1130 and NASM8846



Tangless inserts are designed to eliminate any loose tangs, foreign objects or debris in electronic components.

Emhart®
Teknologies
HELI-COIL®



Tangless® Inserts



Side View



Top View

| Nominal Thread Size | Type | | Size Designation | "A" Normal Length | | | "B" Free Outer Dia. | | Number of Coils Nominal Length | | | |
|------------------------------------|--------------|------------|------------------|-------------------|------------|--------|---------------------|------|--------------------------------|------------|--------|--|
| | Free Running | Screw-Lock | | 1 Dia. | 1 1/2 Dia. | 2 Dia. | Min. | Max. | 1 Dia. | 1 1/2 Dia. | 2 Dia. | |
| Unified Coarse Thread (UNC) | | | | | | | | | | | | |
| 2 (.086)-56 | T1185 | T3585 | 02C | .086 | .129 | .172 | .110 | .119 | 3 | 5-1/4 | 7-3/8 | |
| 4 (.112)-40 | T1185 | T3585 | 04C | .112 | .168 | .224 | .144 | .159 | 2-3/4 | 4-3/4 | 6-3/4 | |
| 6 (.138)-32 | T1185 | T3585 | 06C | .138 | .207 | .276 | .178 | .193 | 2-3/4 | 4-3/4 | 6-7/8 | |
| 8 (.164)-32 | T1185 | T3585 | 2C | .164 | .246 | .328 | .205 | .220 | 3-1/2 | 6 | 8-3/8 | |
| 10 (.190)-24 | T1185 | T3585 | 3C | .190 | .285 | .380 | .244 | .259 | 2-7/8 | 5 | 7-1/8 | |
| 1/4(.250)-20 | T1185 | T3585 | 4C | .250 | .375 | .500 | .310 | .330 | 3-3/8 | 5-3/4 | 8 | |
| Unified Fine Thread (UNF) | | | | | | | | | | | | |
| 10(.190)-32 | T1191 | T3591 | 3C | .190 | .285 | .380 | .236 | .256 | 4-1/8 | 6-7/8 | 9-1/2 | |
| 1/4(.250)-28 | T1191 | T3591 | 4C | .250 | .375 | .500 | .326 | .306 | 5 | 8-1/4 | 11-3/8 | |

T3585-04CW112S

TYPE ← SIZE ← MATERIAL ← FINISH ← LENGTH → PACKAGING

| | | | | | |
|-------------------------|--------------------|---------------------|-------------------|-----------|----------------|
| T1185 Free Running, UNC | See Chart | C - Stainless Steel | W - Dry Film Lube | See Chart | Blank - Bulk |
| T1191 Free Running, UNF | See Chart | E - Gall Resistant | Y - Cadmium | | S - Strip Feed |
| T3585 Screw-Lock, UNC | (Size Designation) | | PF - Primer Free | | |
| T3591 Screw-Lock, UNF | | | Blank - No Finish | | |

Complete Part Number Example: Screw-Locking Insert; #4-40; Stainless Steel; Dry Film Lube, 1 dia.; On Strip

Heli-Coil Tangless® Hand Installation Tooling

| Nominal Thread Size | Hand Installation Tool | | Replacement Installation Blade Kit** | | Removal Tool (with handles) | Electronic Driver* |
|---------------------|------------------------|-------------|--------------------------------------|-------------|-----------------------------|--------------------|
| | Crank Style | Gauge Style | Crank Style | Gauge Style | | |
| 2-56 | 17551-02 | 7571-02 | 17551-02-5 | 7571-02-5 | 7570-02 | 8050-400C |
| 4-40 | 17551-04 | 7571-04 | 17551-04-5 | 7571-04-5 | 7570-04 | 8050-400C |
| 6-32 | 17551-06 | 7571-06 | 17551-06-5 | 7571-06-5 | 7570-06 | 8050-400C |
| 8-32 | 17551-2 | 7571-2 | 17551-2-5 | 7571-2-5 | 7570-2 | 8050-400C |
| 10-24 | 17551-3 | 7571-3 | 17551-3-5 | 7571-3-5 | 7570-3 | 8050-650C |
| 1/4-20 | 17551-4 | 7571-4 | 17551-4-5 | 7571-4-5 | 7570-4 | 8050-650C |
| 10-32 | 17552-3 | 7572-3 | 17552-3-5 | 7572-3-5 | 7570-3 | 8050-650C |
| 1/4-28 | 17552-4 | | 17552-4-5 | 7572-4-5 | 7570-4 | 8050-650C |

* An electronic driver requires a power supply, part number 8050-50.

** Includes blade, spring and pin.

Heli-Coil Tangless® Power Installation Tooling**

| Nominal Thread Size | Front End Assembly | Replacement Mandrel Assembly | Replacement Blade | Installation Kit |
|---------------------|--------------------|------------------------------|-------------------|------------------|
| 2-56 | 18551-02-15 | 18551-02-30 | 18551-02-2 | 8522 |
| 4-40 | 18551-04-15 | 18551-04-30 | 18551-04-2 | 8522 |
| 6-32 | 18551-06-15 | 18551-06-30 | 18551-06-2 | 8522 |
| 8-32 | 18551-2-15 | 18551-2-30 | 18551-2-2 | 8522 |
| 10-24 | 18551-3-15 | 18551-3-30 | 18551-3-2 | 8522 |
| 1/4-20 | 18551-4-15 | 18551-4-30 | 18551-4-2 | 8522 |
| 10-32 | 18552-3-15 | 18552-3-30 | 18552-3-2 | 8522 |
| 1/4-28 | 18552-4-15 | 18552-4-30 | 18552-4-2 | 8522 |

***For use with Heli-Coil® Pneumatic Installation Tools & Adapters.

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