

STANLEY[®]
Engineered Fastening



Aftermarket
Products //

Heli-Coil[®]

Did you know...

Indy and NASCAR® racing teams use Heli-Coil® inserts.

A Boeing 747® has 250,000 Heli-Coil® inserts as original equipment.

There are 250,000 Heli-Coil® inserts in every space shuttle.

Why?

All the above use lightweight, exotic materials and need strong threads.

What does this mean to you?

Today's cars are also made of light materials, such as aluminum, and tapped hole damage is a common occurrence. Stripping during removal of seized bolts, cross-threading and wear from constant assembly and disassembly, and corrosion can also cause thread damage. For these reasons, companies like General Motors®, Ford®, Chrysler®, Boeing®, Pratt & Whitney®, McDonnell-Douglas®, NASA®, Harley-Davidson®, Caterpillar®, Cummins®, General Electric®, Rolls-Royce®, BMW®, Porsche® and many more, including the military, all use Heli-Coil® inserts as original equipment in critical threaded areas of parts made of lightweight materials. They have found that the use of Heli-Coil inserts gives them a stronger and more reusable thread that resists the effects of corrosion.

The inserts offered in all of our Heli-Coil® Thread Repair Kits are made of the same high quality stainless steel as the inserts used by these companies. The same technology that took us to the moon is available to fix the damaged threads on your car, truck, motorcycle, boat; anywhere they happen. This repair is virtually better than the original thread. It is quick, easy, permanent and in almost all cases less expensive than replacing the part.

Table of Contents



• Heli-Coil® Introduction - - - - -	4
• Inch Thread Repair Kits - - - - -	5
• Metric Thread Repair Kits - - - - -	6
• Master Thread Repair Kits – Inch & Metric - - - - -	7
• Spark Plug & Sav-A-Thread® Thread Repair Kits - - - - -	8
• Special Applications - - - - -	9
<i>Custom Kits, Motorcycle, Oxygen Sensor, Head Bolt, Pipe Thread</i>	
• Applications Guide - - - - -	10
• Packaged Inserts - - - - -	11



The Heli-Coil® Thread Repair System

Heli-Coil® has the most effective and universally accepted method of thread repair. Heli-Coil inserts quickly and permanently restore stripped, worn or damaged threads to their original size and condition.

The inserts work in just about any part or material; aluminum, magnesium, cast iron, bronze, etc. The use of light weight (and soft) materials in fuel efficient cars means more thread damage...there is a Heli-Coil® insert to repair virtually every application.

Damaged threads can be restored to better than new condition in spark plug ports, carburetor fuel inlets, transmission housings, oil drain plugs, exhaust and intake manifolds, headbolt holes, brake calipers and more!

The Heli-Coil® system makes all other thread repair methods basically obsolete: welding, plugging, oversized fasteners and oversized drilling of mating parts. It's faster – you save time, increase your shop's repair capabilities and restore parts that otherwise would have to be scrapped.

Heli-Coil® repairs are available in the following standard thread series and size ranges: Inch Coarse (#8 thru 1-1/2), Inch Fine (#10 thru 1-1/2), Metric Coarse (M3 thru M20), Metric Fine (M8 thru M18), Spark Plug (M10, M12, M14, M18 & 7/8"), and Pipe Thread (1/8" thru 1").

In addition to the above, custom sizes are available for various repairs.

Installation

Drill

Drill out the damaged threads using the drill size specified on the kit or set. Drill to sufficient depth to accommodate the insert length and bolt or screw being used.



Tap

Use the Heli-Coil® tap supplied in the kit or set. Check the size on the shank to make sure you have the right one.

Tap the hole to sufficient depth to accommodate the insert length and bolt or screw being used.



Install

Use the installation tool supplied in the kit or set. Just wind the insert into the hole until the top coil is 1/4 - 1/2 turn into the tapped thread. Now you're back to the original size and the original size fastener can be used.



Tang Removal

The tang must be removed to allow full passage of the bolt or screw through the insert. Place square (unchamfered) end of a punch on the tang and strike sharply. For inserts over 1/2", M14 and up, and all spark plug sizes, use long nose pliers. Holding the tang with the pliers, bend it alternately in and out until it comes free.

Note: For Spark Plug repairs, NO drilling is necessary. The Heli-Coil® spark plug kit contains a piloted reamer tap. With this tap, the damaged threads are removed and new threads are cut in one continuous operation.

Heli-Coil® Stainless Steel Inserts

Heli-Coil® inserts are precision formed coils of extremely hard stainless steel (18-8) diamond-shaped wire. When installed into a Heli-Coil tapped hole, the insert provides permanent conventional screw threads. The insert has a driving "tang" for installation which is notched for easy removal.

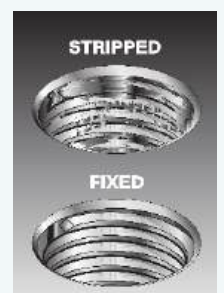


The Retention Principle

Heli-Coil® inserts are larger in diameter before installation than the tapped hole. During installation, the inserting tool reduces the diameter of the leading coil so it can enter the tapped hole. After the installation, each high tensile stainless steel coil expands outward against the tapped hole to permanently anchor the insert.

Stripped & Fixed

When threads become stripped, worn or damaged for any reason, the strength and reliability are greatly reduced. Potentially dangerous situations are eliminated when the damaged thread is repaired with Heli-Coil inserts. The Heli-Coil threaded insert provides stronger, more reliable threads than the original tapped hole and at the same time eliminates the possibility of thread wear, corrosion, galling, seizing and rust.



Inch Thread Repair Kits

Heli-Coil has complete coverage of inch thread repair sizes. Available from stock are Inch Coarse kits in sizes #8 through 1-1/2" and Inch Fine kits in sizes #10 through 1-1/2". Kits up to 3/4" are packaged in durable placon or vinyl pouches, and kits 7/8" and larger are packaged in sturdy metal cases and contain the proper size high speed steel drill. All kits contain a Heli-Coil tap, installation tool, a quantity of inserts and detailed instructions.

INCH COARSE				Kit Contents and Replacement Parts					Drill Size*
Thread Size + Length	Kit Part No.	Kit PKG. Type*	Inserts Per Kit	Tap Part No.	Installation Tool Part No.	Tool Type	Packaged Insert Part No.	Insert Quantity	
8-32 x .246	5521-2	A	12	819-2	2288-2	2	R1185-2	12	11/64
10-24 x .285	5521-3	A	12	819-3	2288-3	2	R1185-3	12	13/64
12-24 x .324	5521-1	A	12	819-1	2288-1	2	R1185-1	12	15/64
1/4-20 x .375	5521-4	A	12	819-4	2288-4	2	R1185-4	12	17/64
5/16-18 x .469	5521-5	A	12	819-5	2288-5	2	R1185-5	12	21/64
3/8-16 x .562	5521-6	A	12	819-6	2288-6	2	R1185-6	12	25/64
7/16-14 x .656	5521-7	A	6	819-7	2288-7	2	R1185-7	6	29/64
1/2-13 x .750	5521-8	A	6	819-8	2288-8	2	R1185-8	6	17/32
9/16-12 x .844	5521-9	B	6	819-9	2288-9	2	R1185-9	6	19/32
5/8-11 x .938	5521-10	B	6	819-10	2288-10	2	R1185-10	6	21/32
3/4-10 x 1.125	5521-12	B	4	819-12	2288-12	2	R1185-12	4	25/32
THE FOLLOWING KITS COME COMPLETE WITH HIGH SPEED STEEL DRILL BIT FOR 1/2" CHUCK.									
7/8-9 x 1.312	5521-14	C	6	8187-14	3724-14	2	K1185-14	1	29/32
1-8 x 1.500	5521-16	C	6	8187-16	3724-16	2	K1185-16	1	1-1/32
1-1/8-7 x 1.688	5521-18	C	5	8187-18	3724-18	2	K1185-18	1	1-5/32
1-1/4-7 x 1.875	5521-20	C	4	8187-20	3724-20	2	K1185-20	1	1-9/32
1-3/8-6 x 2.062	5521-22	C	4	8187-22	3724-22	2	K1185-22	1	1-13/32
1-1/2-6 x 2.250	5521-24	C	4	8187-24	3724-24	2	K1185-24	1	1-17/32

A - Carded B - Pouch C - Metal Case * Kit Pkg. Types A & B, drill bit not included



INCH				Kit Contents and Replacement Parts					Drill Size*
Thread Size + Length	Kit Part No.	Kit PKG. Type*	Inserts Per Kit	Tap Part No.	Installation Tool Part No.	Tool Type	Packaged Insert Part No.	Insert Quantity	
10-32 x .285	5528-3	A	12	821-3	2299-3	3	R1191-3	12	13/64
1/4-28 x .375	5528-4	A	12	821-4	2299-4	3	R1191-4	12	17/64
5/16-24 x .469	5528-5	A	12	821-5	2299-5	3	R1191-5	12	21/64
3/8-24 x .562	5528-6	A	12	821-6	2299-6	3	R1191-6	12	25/64
7/16-20 x .656	5528-7	A	6	821-7	2299-7	3	R1191-7	6	29/64
1/2-20 x .750	5528-8	A	6	821-8	2299-8	3	R1191-8	6	33/64
9/16-18 x .844	5528-9	B	6	821-9	2299-9	3	R1191-9	6	37/64
5/8-18 x .938	5528-10	B	6	821-10	2299-10	3	R1191-10	6	41/64
3/4-16 x 1.125	5528-12	B	4	821-12	2299-12	3	R1191-12	4	49/64
THE FOLLOWING KITS COME COMPLETE WITH HIGH SPEED STEEL DRILL BIT FOR 1/2" CHUCK.									
7/8-14 x 1.312	5528-14	C	6	8193-14	535-14	4	K1191-14	1	57/64
1-14 x 1.500	5528-16	C	6	8193-16	535-16	4	K1191-16	1	1-1/64
1-12 x 1.500	5528-161	C	6	8193-161	535-161	4	K1191-161	1	1-1/64
1-1/8-12 x 1.688	5528-18	C	5	8193-18	535-18	4	K1191-18	1	1-5/32
1-1/4-12 x 1.875	5528-20	C	4	8193-20	535-20	4	K1191-20	1	1-9/32
1-3/8-12 x 2.062	5528-22	C	4	8193-22	535-22	4	K1191-22	1	1-13/32
1-1/2-12 x 2.250	5528-24	C	4	8193-24	535-24	4	K1191-24	1	1-17/32

* Kit Pkg. Types A & B, drill bit not included

Metric Thread Repair Kits

Heli-Coil has all you need in metric thread repair items. Available from stock are Metric Coarse kits in sizes M3 through M20 and Metric Fine kits in sizes M8 through M20. All Metric kits contain a Heli-Coil tap, installation tool, a quantity of inserts and complete instructions.

METRIC COARSE				Kit Contents and Replacement Parts					Drill Size*
Thread Size + Length	Kit Part No.	Kit PKG. Type*	Inserts Per Kit	Tap Part No.	Installation Tool Part No.	Tool Type	Packaged Insert Part No.	Insert Quantity	
M3x0.5 x 4.5mm	5546-3	B	12	2087-3	7751-3	5	R1084-3	12	1/8
M4x0.7 x 6.0mm	5546-4	A	12	2087-4	3747-4	3	R1084-4	12	11/64
M5x0.8 x 7.5mm	5546-5	A	12	570-5	3747-5	3	R1084-5	12	13/64
M6x1 x 9.0mm	5546-6	A	12	570-6	3747-6	3	R1084-6	12	1/4
M7x1 x 10.5mm	5546-7	A	12	570-7	3747-7	2	R1084-7	12	9/32
M8x1.25 x 12.0mm	5546-8	A	12	570-8	3747-8	2	R1084-8	12	21/64
M9x1.25 x 13.5mm	5546-9	A	12	570-9	3747-9	2	R1084-9	12	23/64
M10x1.5 x 15.0mm	5546-10	A	12	570-10	3747-10	2	R1084-10	12	13/32
M11x1.5 x 16.5mm	5546-11	A	6	580-11	3747-11	3	R1084-11	6	29/64
M12x1.75 x 18.0mm	5546-12	A	6	2087-12	3747-12	2	R1084-12	6	31/64
M14x2 x 21.0mm	5546-14	B	6	2087-14	3747-14	2	R1084-14	6	37/64
M16x2 x 24.0mm	5546-16	B	6	2087-16	3747-16	2	R1084-16	6	21/32
M18x2.5 x 27.0mm	5546-18	B	6	2087-18	3747-18	2	R1084-18	6	47/64
M20x2.5 x 30.0mm	5546-20	B	4	2087-20	3747-20	2	R1084-20	4	13/16

A - Carded B - Pouch * Kit Pkg. Types A & B, drill bit not included



METRIC FINE				Kit Contents and Replacement Parts					Drill Size*
Thread Size + Length	Kit Part No.	Kit PKG. Type*	Insert Per Kit	Tap Part No.	Installation Tool Part No.	Tool Type	Packaged Insert Part No.	Insert Quantity	
M8x1 x 12.0mm	5542-8	A	12	573-8	4835-8	3	R4255-8	12	21/64
M10x1 x 15.0mm	5542-10	A	12	573-10	4835-10	3	R4255-10	12	13/32
M11x1 x 16.5mm	5542-11	A	6	573-11	4835-11	3	R4255-11	6	7/16
M10x1.25 x 15.0mm†	5543-10	A	12	575-10	4640-10	3	R4649-10	12	13/32
M11x1.25 x 16.5mm	5543-11	A	6	4944-11	4640-11	3	R4649-11	6	29/64
M12x1.25 x 18.0mm	5543-12	A	6	4944-12	4640-12	3	R4649-12	6	31/64
M12x1.5 x 18.0mm	5544-12	A	6	4976-12	4973-12	3	R3745-12	6	31/64
M14x1.5 x 21.0mm	5544-14	B	6	4976-14	4973-14	3	R3745-14	6	9/16
M16x1.5 x 24.0mm	5544-16	B	6	4976-16	4973-16	3	R3745-16	6	21/32

* Kit Pkg. Types A & B, drill bit not included

Master Thread Repair Sets

These “Shop Sets” are the professional’s choice and are available in inch and metric — coarse and fine. The inch and metric Master Sets contain the most common thread repair sizes. All of these master sets come complete with a drill, tap, installation tool and a quantity of inserts for each size and complete instructions.

Inch Master Thread Repair Sets

There are two master sets for inch sizes. The coarse set contains five sizes: 1/4, 5/16, 3/8, 7/16 and 1/2. The fine set has six sizes: #10, 1/4, 5/16, 3/8, 7/16 and 1/2.



Thread Size + Length	Packaged Insert Part No.	Insert Quantity	Tap Part No.	Installation Tool No.	Drill Size
PART NO. 5621 – INCH COARSE CONTENTS					
1/4-20 x .375	R1185-4	12	819-4	5288-4	17/64
5/16-18 x .469	R1185-5	12	819-5	5288-5	21/64
3/8-16 x .562	R1185-6	12	819-6	5288-6	25/64
7/16-14 x .656	R1185-7	6	819-7	5288-7	29/64
1/2-13 x .750	R1185-8	6	819-8	5288-8	17/32
PART NO. 5625 – INCH FINE CONTENTS					
10-32 x .285	R1191-3	12	821-3	2299-3	13/64
1/4-28 x .375	R1191-4	12	821-4	2299-4	17/64
5/16-24 x .469	R1191-5	12	821-5	2299-5	21/64
3/8-24 x .562	R1191-6	12	821-6	2299-6	25/64
7/16-20 x .656	R1191-7	6	821-7	2299-7	29/64
1/2-20 x .750	R1191-8	6	821-8	2299-8	33/64

Metric Master Thread Repair Sets

Two sets are available in metric sizes. The metric coarse set contains sizes M5, M6, M8 and M10x1.5 and the metric fine set contains sizes M5, M6, M8 and M10x1.25.

Thread Size + Length	Packaged Insert Part No.	Insert Quantity	Tap Part No.	Installation Tool No.	Drill Size
PART NO. 5626-150 – METRIC COARSE CONTENTS					
M5x0.8 x 7.5mm	R1084-5	12	570-5	3747-5	13/64
M6x1 x 9.0mm	R1084-6	12	570-6	3747-6	1/4
M8x1.25 x 12.0mm	R1084-8	12	570-8	3747-8	21/64
M10x1.5 x 15.0mm	R1084-10	12	570-10	3747-10	13/32
PART NO. 5626-125 – METRIC FINE CONTENTS					
M5x0.8 x 7.5mm	R1084-5	12	570-5	3747-5	13/64
M6x1 x 9.0mm	R1084-6	12	570-6	3747-6	1/4
M8x1.25 x 12.0mm	R1084-8	12	570-8	3747-8	21/64
M10x1.5 x 15.0mm	R1084-10	12	570-10	4640-10	13/32



Spark Plug & Sav-A-Thread® Kits



Spark Plug

Heli-Coil® is the original spark plug port thread repair. These kits offer the highest quality and most durable repair available. They are the first choice of professional mechanics and engine rebuilders. Kits are available in sizes M10, M12, M14, M18, and 7/8". Each kit contains a piloted reamer tap (no drilling necessary), an installation tool, and a quantity of inserts. The M12 and M14 kits contain several insert lengths to accommodate all spark plug reaches.

Heli-Coil® Spark Plug Inserts are the preferred method of repair specified by virtually all U.S. and foreign vehicle manufacturers.

NOTE: Do NOT use Heli-Coil® wire inserts to repair taper seat spark plug ports.

Thread Size	Reach	Kit Part No.	Inserts Part Kit.	Kit Contents and Replacement Parts			
				Tap Part No.	Installation Tool Part No.	Insert PKG. Part No.	Insert Quantity
M10x1.0	1/2"	5523-10	24	1030-10	4971-10	R474-4	6
M12x1.25	1/2" 3/4"	5523-12	12	1030-12	4971-12	R482-1	6
			12			R482-2	6
M14x1.25	3/8"	5523-14	6	1030-14	4971-14	R512	6
	7/16"		6			R513	6
	1/2"		6			R513-13	6
	3/4"		6			R513-10	6
	.472"		6			R513-20	6
M18x1.50	1/2"	5523-18	24	1030-18	4971-18	R514-6	6
7/8-18	1/2"-5/8"	550	10	549	548	K518-12	5

Sav-A-Thread® Repair Kits for Taper Seat Spark Plug Ports

Sav-A-Thread® is the easiest way to permanently repair stripped spark plug hole threads. Virtually all engines built today have aluminum cylinder heads. Combining this with the growing number of do-it-yourselfers and the need for quick, easy, on-the-spot repairs makes Sav-A-Thread® a must for every store and shop.

- Three insert lengths are available to accommodate all spark plug reaches.
- Positive mechanical locking feature means the insert will never come out!
- The piloted reamer tap means no drilling is necessary and perfect alignment of the tapped hole.
- Available in kit or set for the do-it-yourselfer and professional engine rebuilder.

NOTE: Heli-Coil® recommends removing the head before installation to insure chips do not enter cylinder



Complete Kits					Kit Contents and Replacement Parts			
Size	Kit Part No.	Reach	Inserts Per Kit	Tap Part No.	Tool Part No.	Reach	Insert PKG. Part No.	Ins. Qty.
M14 x 1.25	5334-14	Short	1	5329-14	5332-14	Short	R5326-14S	1
		Normal	1			Normal	R5326-14N	1
		Long	1			Long	R5326-14L	1
M14 x 1.25	5408-14	Short	6	5329-14	5332-14	Short	R5326-14S-6	6
		Normal	6			Normal	R5326-14N-6	6
		Long	6			Long	R5326-14L-6	6

*Extended length tool kit 5409-14 is available for spark plug wells up to 6" deep

Sav-A-Thread® Spark Plug Repair Kits

Part No. 5396-14

This M14 Kit is typically used in 4.6 and 5.4 liter Ford® engines. Product offers the highest quality and most durable repair available. Remove the head before installation to ensure chips do not enter the cylinder.

Kit includes:

- Piloted reamer
- Steel installation tool
- Expanding tool
- 12 inserts.

(Refill package R5326-14E is available; includes 6 inserts)



Part No. 5396-16

This M16 kit is specifically designed for Ford® 4.6 and 5.4 liter – 3 Valve engines. For repair on ports containing Autolite® HT and Mororcraft® Platinum PZT spark plugs.

Kit includes:

- Piloted reamer
- Steel installation tool
- Expanding tool
- 12 inserts.

(Refill package R5326-16 is available; includes 6 inserts)



Special Applications

Custom Kits

Custom application kits round out the complete line of Heli-Coil Thread Repair Kits. They are recommended by both domestic and foreign automakers and include kits for various heavy duty applications, and several specially- designed repairs for a number of Volkswagen models.

All kits contain a Heli-Coil tap, installation tool, a quantity of inserts, and detailed instructions.

Motorcycle

Heli-Coil offers a complete range of kits and sets for the repair of damaged threads on motorcycles. The Heli-Coil Motorcycle Thread Repair Set contains M6, M8 and M10 sizes. Two lengths of M10 inserts are available: 15mm for most repairs and 25mm for head bolt repairs.

Oxygen Sensor Thread Repair Kit – Part No. 4833

Quickly and permanently restore damaged M18 x 1.5 oxygen sensor threads in exhaust manifolds with this kit. No drilling is necessary with the piloted reamer tap, resulting in perfect alignment of the new tapped hole. Corrosion resistant stainless steel inserts improve future serviceability.

This application is easy to use, works in minutes, and eliminates exhaust manifold replacement. Perfect for the professional engine rebuilder and the do-it-yourselfer.



Head Bolt Thread Repair Kit – Part No. 1130



The Metric M11x1.5 Head Bolt Kit is typically used in 4.0 and 4.2 liter GM® engines including Cadillac® as well as many other imports such as Honda® and Toyota®. The 1130 product will permanently restore stripped head bolts, has an extended reach for easy installation and a stop collar to control the installation depth.

The Kit contains:

- High speed steel drill bit
- High speed steel tap
- 12 Heli-Coil stainless steel inserts

Pipe Thread Kits

Heli-Coil Pipe Thread Kits are available in a complete range of sizes for the most often occurring taper pipe thread failures, such as exhaust pipes on small engines. Each kit contains a high speed steel drill, tap, installation tool, a quantity of inserts, and complete instructions.

Applications Guide

TYPICAL AUTOMOTIVE APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
Oil & Transmission Pan Screws	
1/4-20	5521-4
5/16-18	5521-5
Cylinder Head Bolts	
7/16-14	5521-7
1/2-13	5521-8
9/16-12	5521-9
M10x1.5	5546-10
M11x1.25	5543-11
M11x1.5	5546-11
M12x1.75	5546-12
Exhaust Manifold Studs	
1/4-20	5521-4
1/4-28	5528-4
5/16-18	5521-5
5/16-24	5528-5
3/8-16	5521-6
3/8-24	5528-6
7/16-14	5521-7
7/16-20	5528-7
1/2-20	5528-8
9/16-18	5528-9
5/8-18	5528-10
3/4-10	5521-12
M5x0.8	5546-5
M6x1	5546-6
M8x1.25	5546-8
M10x1.5	5546-10
M10x1.25	5543-10
Starter Bolts	
3/8-16	5521-6
M10x1.5	5546-10
Alternator Bolts	
5/16-18	5521-5
3/8-16	5521-6
M10x1.5	5546-10
Drain Plugs	
1/2-20	5528-8
5/8-18	5528-10
3/4-16	5528-12
7/8-14	5528-14
M12x1.75	5546-12
M14x1.5	5544-14
M16x1.5	5544-16
Brake Caliper Bolts	
M9x1.5	5546-9
M11x1.5	5543-11

TYPICAL HEAVY DUTY APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
Aux. Transmission Cases (Fuller)	
5/16-18	5521-5
3/8-16	5521-6
Caterpillar Flywheel Bolts	
3/4-16	5528-12
Cummins Head Bolt	
11/16-16	5559-11
Caterpillar Pre-Combustion Chamber	
3/4-12	4922-12
7/8-12	4922-141
1-12	4922-161
1 1/8-12	4922-18
1 1/4-12	4922-20
Wheel Studs	
3/4-10	5521-12
3/4-16	5528-12
Motor Mounts/Bell Housing	
1/2-13	5521-8
5/8-11	5521-10
Oil Pan	
7/16-14	5521-7
Intake Manifolds	
3/8-16	5521-6
After Coolers	
5/16-18	5521-5
Valve Cover	
3/8-16	5521-6
Detroit Diesel Series "92" Block	
Head Bolt/Main Bearing	
11/16-11	5575-11
Mack-Scania Head Bolt	
M14x1.5	5544-14
American Bosch APE Diesel Fuel Pumps	
1/4-20	5401-4-1-SL
SPARK PLUG HOLE THREADS	
SIZE	HELI-COIL KIT PART NO.
WIRE INSERTS FOR GASKET TYPE SPARK PLUGS ONLY	
M10x1	5523-10
M12x1.25	5523-12
M14x1.25	5523-14
M18x1.5	5523-18
7/8-18	550
SAV-A-THREAD FOR TAPER SEAT OR GASKET TYPE SPARK PLUGS	
M14x1.25	5334-14 or 5408-14 5409-14

TYPICAL MOTORCYCLE APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
Motorcycle Thread Repair Set	
M6x1, M8x1.25 and M10x1.25 (2 lengths)	4650
Cam Screw Cover, Tappet Guide, Oil Pump Stud and Timer Mounting	
1/4-24	5540-4
Front/Rear Brake Drum	
3/8-20	5540-6
Head Bolt	
7/16-16	5540-7
Drain Plug - Engine and Transmission	
1/2-13	5521-8-2
Drain Plug - Chain Case	
1/2-20	5528-8-2
Timing Plug	
5/8-18	5528-10-2
Generator Case Bolt	
5/16-18	5521-5-2
Transmission Cover	
5/16-18	5521-5-3
Japanese Motorcycle Head Bolt	
M10x1.25	4647-10-1
TYPICAL VOLKSWAGEN APPLICATIONS	
SIZE	HELI-COIL KIT PART NO.
VW Electro Magnetic	
M8x1	5542-8
Fuel Cut Off Jet	
M11x1	5542-11
VW Rabbit Head Bolt Threads	
M11x1.25	5546-11
VW Fuel Injection Head Sensor	
M10x1	5542-10-1
PIPE THREAD KITS	
Size	HELI-COIL KIT PART NO.
1/8-27	5407-2
1/4-18	5407-4
3/8-18	5407-6
1/2-14	5407-8
3/4-14	5407-12
1-11 1/2	5407-16

Packaged Inserts

Heli-Coil inserts are packaged according to thread size for easy handling and display. The inserts are contained in a sturdy, clear, plastic display box and marked with part number and thread size. The length of the inserts in inch and metric packages is 1 1/2 times the diameter of the bolt. This provides sufficient strength in most applications. Spark plug hole inserts are packaged in lengths corresponding to the various spark plug reaches.



Thread Insert Size + Length	Packaged Insert Part No.	Insert Qty.
INCH COARSE		
8-32x.246	R1185-2	12
10-24x.285	R1185-3	12
12-24x.324	R1185-1	12
1/4-20x.375	R1185-4	12
5/16-18x.469	R1185-5	12
3/8-16x.562	R1185-6	12
7/16-14x.656	R1185-7	6
1/2-13x.750	R1185-8	6
9/16-12x.844	R1185-9	6
5/8-11x.938	R1185-10	6
3/4-10x1.125	R1185-12	4
7/8-9x1.312	K1185-14	1
1-8x1.500	K1185-16	1
1-1/8-7x1.688	K1185-18	1
1-1/4-7x1.875	K1185-20	1
1-3/8-6x2.062	K1185-22	1
1-1/2-6x2.250	K1185-24	1
INCH FINE		
10-32x.285	R1191-3	12
1/4-28x.375	R1191-4	12
5/16-24x.469	R1191-5	12
3/8-24x.562	R1191-6	12
7/16-20x.656	R1191-7	6
1/2-20x.750	R1191-8	6
9/16-18x.844	R1191-9	6
5/8-18x.938	R1191-10	6
3/4-16x1.125	R1191-12	4
7/8-14x1.312	K1191-14	1
1-14x1.500	K1191-16	1
1-12x1.500	K1191-161	1
1-1/8-12x1.688	K1191-18	1
1-1/4-12x1.875	K1191-20	1
1-3/8-12x2.062	K1191-22	1
1-1/2-12x2.250	K1191-24	1

Thread Size	Length	Packaged Insert Part No.	Insert Qty.
METRIC COARSE			
M3x0.5	4.5	R1084-3	12
M4x0.7	6.0	R1084-4	12
M5x0.8	7.5	R1084-5	12
M6x1	9.0	R1084-6	12
M7x1	10.5	R1084-7	12
M8x1.25	12.0	R1084-8	12
M9x1.25	13.5	R1084-9	12
M10x1.5	15.0	R1084-10	12
M12x1.75	18.0	R1084-12	6
M14x2	21.0	R1084-14	6
M16x2	24.0	R1084-16	6
M18x2.5	27.0	R1084-18	6
M20x2.5	30.0	R1084-20	4
METRIC FINE			
M8x1	8.0	R4255-8-10	12
M10x1	15.0	R4255-10	12
M11x1	11.0	R4255-11-10	6
M10x1.25	15.0	R4649-10	12
M11x1.25	16.5	R4649-11	6
M12x1.25	18.0	R4649-12	6
M12x1.5	18.0	R3745-12	6
M14x1.5	21.0	R3745-14	6
M16x1.5	24.0	R3745-16	6
Spark Plug - Wire Inserts			
Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
M10x1	1/2"	R474-4	6
M12x1.25	1/2"	R482-1	6
	3/4"	R482-2	6
M14x1.25	3/8"	R512	6
	7/16"	R513	6
	1/2"	R513-13	6
	3/4"	R513-10	6
	.472"	R513-20	6
M18x1.5	1/2"	R514-6	6
7/8-18	1/2"-5/8"	R518-12	5
Spark Plug - Sav-A-Thread® Inserts			
Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
M14x1.25	Short	R5326-14S	1
M14x1.25	Normal	R5326-14N	1
M14x1.25	Long	R5326-14L	1
M14x1.25	Short	R5326-14S-6	6
M14x1.25	Normal	R5326-14N-6	6
M14x1.25	Long	R5326-14L-6	6

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