

Emhart 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 better than the original thread. It is quick, easy, permanent and in almost all cases less expensive than replacing the part.

POP

POP Blind Rivets are available in a variety of sizes, types and materials combined with dome, countersunk or large-flange head styles. This makes POP blind rivets ideal for a wide range of riveting applications. They are the most popular rivets for automotive use. Also available from POP are Sheet Metal Inserts, a general purpose threaded insert with exceptionally strong torque-out and pull-out characteristics, POP Plastic Rivets, a one-piece, all-plastic expansion rivet, POP WELL-NUT Threaded Inserts, a flanged rubber bushing with brass threads molded into one end, and a variety of manual and power tools.

Drill-Out

Drill-Out is a drill bit and extractor in one. The drill bit is made from high quality tool steel that has been hardened and tempered giving it the ability to even drill into Grade 8 and stainless steel bolts. The extractor is made from hard, flexible die steel which allows it to bite into any bolt or stud without slipping or stripping.

Chase 'em Back™

The unique, patented hinge design of Chase 'em Back allows for the repair of damaged or corroded threads on most studs by attaching to the undamaged threads and working back through the damaged areas. Made from heat-treated steel, sets are available for the most common inch and metric thread sizes. Other sets include the 8-piece Sav-A-Stud Plus™ set for wheel stud repair and the 20-piece Spindle-Saver™ set for front wheel drive spindle repair.

HELI-COIL

POP

DRILL-OUT

CHASE 'EM BACK

Spark Plug & Sav-A-Thread



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 PER KIT	Kit Contents and Replacement Parts			
				TAP PART NO.	INSTALLATION TOOL PART NO.	INSERT PKG. PART NO.	INSERT QUANTITY
10-1.0mm	1/2"	5523-10	24	1030-10	4971-10	R474-4	6
12-1.25mm	1/2"	5523-12	12	1030-12	4971-12	R482-1	6
	3/4"		R482-2			6	
14-1.25mm	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
18-1.50mm	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

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.

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

- 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.



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.
M14x1.25	5334-14	Short	1	5329-14	5332-14	Short	R5326-14S	1
		Normal	1			Normal	R5326-14N	1
		Long	1			Long	R5326-14L	1
M14x1.25	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
M14x1.25	5409-14	Extended	–	5329-14-1	5332-14-1	Extended Reach		

Packaged Inserts & Tooling



Heli-Coil inserts are packaged according to thread size for easy handling and display. The inserts are con-

tained 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. For shorter or longer lengths and volume applications, see page 13.

Thread 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

Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
METRIC FINE			
M8x1	8.0	R4255-8-10	12
M10x1	15.0	R4255-10	12
M10x1.25	15.0	R4649-10	12
M11x1	11.0	R4255-11-10	6
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 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

SAV-A-THREAD PRO SET

M14x1.25	Short	R5326-14S-6	6
M14X1.25	Normal	R5326-14N-6	6
M14X1.25	Long	R5326-14L-6	6

Spark Plug – Wire Inserts

Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
10-1.0mm	1/2"	R474-4	6
12-1.25mm	1/2"	R482-1	6
	3/4"	R482-2	6
14-1.25mm	3/8"	R512	6
	7/16"	R513	6
	1/2"	R513-13	6
	3/4"	R513-10	6
	.472	R513-20	6
	18-1.5mm	1/2"	R514-6
7/8"	1/2"-5/8"	R518-12	5

There are two types of industrial installation tools available:

1. **Steel kit tools** for 1/4, 5/16, 3/8, 7/16, 1/2 and 5/8 coarse thread sizes which can be used for medium production quantities.
2. **Prewinder type** installation tools for higher production quantities.



Prewinder Type Tools

Size	Part No.	Size	Part No.
INCH COARSE		INCH FINE	
8-32	7551-2	10-32	7552-3
10-24	7551-3	1/4-28	7552-4
12-24	7551-1	5/16-24	7552-5
1/4-20	7551-4	3/8-24	7552-6
5/16-18	7551-5	7/16-20	7552-7
3/8-16	7551-6	1/2-20	7552-8
7/16-14	7551-7	9/16-18	535-9
1/2-13	7551-8	5/8-18	535-10
9/16-12*	3724-9	3/4-16	535-12
5/8-11*	3724-10		
3/4-10*	3724-12		

Size	Part No.	Size	Part No.
METRIC COARSE		METRIC FINE	
M3x0.5	7751-3	M8x1	7755-8
M4x0.7	7751-4	M10x1	7755-10
M5x0.8	7751-5	M10x1.25	7756-10
M6x1	7751-6	M12x1.25	7756-12
M7x1	7751-7	M12x1.5	7753-12
M8x1.25	7751-8	M14x1.5	7753-14
M10x1.5	7751-10	M16x1.5	7753-16
M12x1.75	7751-12	M18x1.5	7753-18
M14x2	7751-14		
M16x2	7751-16		
M18x2.5	7751-18		
M20x2.5	7751-20		

Note: These industrial tools do not require a prewinder to facilitate installation. They are "T"-Type threaded mandrel tools.

One Piece Steel Kit Tools

Size	Part No.
1/4-20	2288-4
5/16-18	2288-5
3/8-16	2288-6
7/16-14	2288-7
1/2-13	2288-8
5/8-11	2288-10