

HeliCoil® Thread repair kits & Master sets

Heli-Coil inserts are available in thread repair kits and sets for repairing tapped holes which have been stripped or damaged due to wear, corrosion and over-torque. They are available in inch, metric, spark plug and pipe thread series. All kits have a quantity of inserts, the proper size drill, high speed steel Heli-Coil tap and an installation tool.



The Professional Kits* (shown in **bold** type) also includes a tang removal tool and quantities of three lengths of inserts.

PROFESSIONAL KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
INCH COARSE THREAD (UNC)		
4-40	5401-04	36*
5-40	5401-05	36*
6-32	5401-06	36*
8-32	5401-2	36*
10-24	5401-3	36*
12-24	5401-1	36*
1/4-20	5401-4	36*
5/16-18	5401-5	36*
3/8-16	5401-6	18*
7/16-14	5401-7	18*
1/2-13	5401-8	18*
9/16-12	5401-9	6
5/8-11	5401-10	6
3/4-10	5401-12	4
7/8-9	5521-14	6
1-8	5521-16	6
1-1/8-7	5521-18	5
1-1/4-7	5521-20	4
1-3/8-6	5521-22	4
1-1/2-6	5521-24	4
INCH FINE THREAD (UNF)		
6-40	5402-06	36*
8-36	5402-2	36*
10-32	5402-3	36*
1/4-28	5402-4	36*
5/16-24	5402-5	36*
3/8-24	5402-6	18*
7/16-20	5402-7	18*
1/2-20	5402-8	18*
9/16-18	5402-9	6
5/8-18	5402-10	6
3/4-16	5402-12	4
7/8-14	5528-14	6
1-14	5528-16	6
1-12	5528-161	6
1-1/8-12	5528-18	5
1-1/4-12	5528-20	4
1-3/8-12	5528-22	4
1-1/2-12	5528-24	4

* The total quantity of inserts in the Professional Kits represents 3 lengths.

PROFESSIONAL KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
METRIC COARSE		
M3x0.5	5403-3	36*
M3.5x0.6	5403-3.5	36*
M4x0.7	5403-4	18*
M5x0.8	5403-5	18*
M6x1	5403-6	18*
M7x1	5403-7	18*
M8x1.25	5403-8	18*
M9x1.25	5403-9	12
M10x1.5	5403-10	18*
M11x1.5	5403-11	6
M12x1.75	5403-12	18*
M14x2	5403-14	12
M16x2	5403-16	6
M18x2.5	5403-18	6
M20x2.5	5403-20	4
METRIC FINE		
M8x1	5404-8	18*
M10x1	5404-10	18*
M10x1.25	5405-10	18*
M12x1.25	5405-12	18*
M12x1.5	5406-12	18*
M14x1.5	5406-14	6
M16x1.5	5406-16	6
M18x1.5	5406-18	6

* The total quantity of inserts in the Professional Kits represents 3 lengths.



MASTER THREAD REPAIR SETS

Type	Part No.	Insert sizes included in set
Inch Coarse	4934	1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13, 5/8-11
Inch Fine	4936	10-32, 1/4-28, 5/16-24, 3/8-24, 7/16-20, 1/2-20
Metric	4937-125	M5x0.8, M6x1, M8x1.25, M10x1.25
Metric	4937-150	M5x0.8, M6x1, M8x1.25, M10x1.5

All sets contain a drill, tap, tool and inserts for each size listed above.

SPARK PLUG KITS

Nominal Thread Size	Kit Part No.	Reach	Inserts Per Kit
10-1.0mm	5523-10	1/2	24
12-1.25mm	5523-12	1/2	12
		3/4	12
14-1.25mm	5523-14	3/8	6
		7/16	6
		1/2	6
		3/4	6
18-1.50mm	5523-18	1/2	24
		550	10
M14x1.25*	5408-14	Short	6
		Normal	6
		Long	6

Note: Do not use Heli-Coil wire inserts to repair taper seat plug ports.



PIPE THREAD KITS

Nominal Thread Size	Kit Part No.	Inserts Per Kit
1/8-27	5407-2	12
1/4-18	5407-4	12
3/8-18	5407-6	10
1/2-14	5407-8	10
3/4-14	5407-12	10
1-11-1/2	5407-16	6