

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					
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.	PACKAGED INSERT QTY.	DRILL SIZE
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

*Sizes included in Master Thread Repair Set - Part No. 5621

A - Carded B - Pouch C - Metal Case



INCH FINE				Kit Contents and Replacement Parts					
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.	PACKAGED INSERT QTY.	DRILL SIZE
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

**Sizes included in Master Thread Repair Set - Part No. 5625

Heli-Coil® Applications Guide

Typical Heavy Duty 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
M11x1.5	5546-11
M11x1.25	5543-11
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	
M9x1.25	5546-9
M11x1.25	5543-11

Typical Heavy Duty Applications

SIZE	HELI-COIL KIT PART NO.
Aux. Transmission Cases (Fuller)	
3/8-16	5521-6
5/16-18	5521-5
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 Insert*	
10-1.0mm	5523-10
12-1.25mm	5523-12
14-1.25mm	5523-14
18-1.5mm	5523-18
7/8-18	550
Sav-A-Thread**	
M14x1.25	5334-14 or 5408-14 5409-14

*For gasket type spark plug assemblies only.

**For Taper seat or gasket type spark plug assemblies.

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