

Inch Thread Repairs Kits **HeliCoil**

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.	PACKAGED INSERT QTY.	
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					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.	PACKAGED INSERT QTY.	
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 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. For shorter or longer lengths and volume applications, see page 8.

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
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

Sav-A-Thread® Spark Plug 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
	7/16"	R513	6
14-1.25mm	1/2"	R513-13	6
	3/4"	R513-10	6
	.472	R513-20	6
18-1.5mm	1/2"	R514-6	6
7/8"	1/2"-5/8"	R518-12	5