



Fasteners West, Inc.

## HeliCoil® Twinserts

### Description

Twinsert assemblies as the name implies consist of two HeliCoil inserts, an Outer insert, always Free-Running and an Inner insert which can be either Free-Running or Screw-Lock. Depending on size a maximum correction of .023" to .081 (2-56 thru 3/8-16) can be achieved. Larger thread sizes are available.

### When to use

Twinserts are used to correct STI, (steel thread insert), or standard tapped holes that are stripped, off-center, damaged or beyond the correction range of Standard HeliCoil inserts or Oversize inserts.

### Sizes available

Twinserts come in inch sizes UNC and UNF, and Metric sizes. When Twinserts are installed; the original internal thread size is re-established allowing installation of the original size bolt.

### How to order

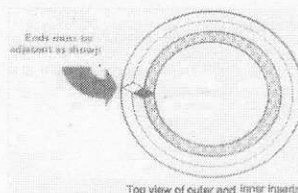
Identify thread size to be repaired, identify if Free-Running or Screw-Lock is required for Internal insert.

Remember a special oversize tap and installation tool for the Outer insert are required.

### How to install

1. Drill hole to minor diameter specified using the drill size specified. Drill hole to original depth.
2. Tap the hole to the original depth using the special bottoming tap.
3. Install outer insert with the proper tool 1/4 to 1/2 pitch below top of surface.
4. Break off the driving tang.
5. Install Inner insert to the position where the end of the last (top) coil is flush with the end of the Outer insert as shown. Use the same installation tool as used for the standard HeliCoil insert of the same thread size.
6. Break off the driving tang.
7. The Inner insert will provide a Class 2B fit.

\*HeliCoil® is a registered trademark of Emhart Teknologies, Inc.



Top view of outer and inner inserts

