

Heli-coil, data, tools and inserts—engine

UNIT	Area Affected	Drill Size	Thread Size and Finishing Tap Depth	Roughing Tap No.	Finishing Tap No.	Heli-Coil Insert No.	Inserting Tool No.	Tang Break off Tool No.
Cylinder Block	Cylinder Head Face	$\frac{3}{8}$ "	$\frac{3}{8}$ x UNC x 1.37"	6 CRU	6 CBB	1185-6C x $1\frac{1}{8}$ "	528-6	Do not break off tang
	Sump Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .56"	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
	Clutch Housing Face	$\frac{3}{8}$ "	$\frac{3}{8}$ x 16 UNC-Through	6 CRU	6 CBB	3585-6CN x $\frac{3}{8}$ "	3551-6	3580-6
	Timing Cover Face*	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $\frac{3}{8}$ "	3551-5	3580-5
	Chain Tensioner Bracket Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .68"	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
	Main Bearing Cap Tappings	$\frac{7}{16}$ "	$\frac{7}{16}$ x 14 UNC x 1.16"	7 CRU	7 CBB	3585-7CN x $\frac{7}{8}$ "	3551-7	3580-7
	Oil Filter Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC x .68"	5 CRU	5 CBB	3585-5CN x $\frac{11}{16}$ "	3551-5	3580-5
	Breathing Tapping	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $1\frac{1}{8}$ "	3551-5	3580-5
	Dynamo Bkt. Face	$\frac{3}{8}$ "	$\frac{3}{8}$ x 16 UNC x .72"	6 CRU	6 CBB	3585-6CN x $\frac{9}{16}$ "	3551-6	3580-6
	Water Inlet	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .5"	4 CRU	4 CBB	1185-4CN x $\frac{1}{2}$ "	528-4	1195-4
Timing Cover	Top Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $\frac{11}{16}$ "	3551-5	3580-5
	Distributor Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .5"	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3850-4
	Sump Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .5"	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
	Oil Pump Face**	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC-Through	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
Cambox Cover	Petrol Pump Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $\frac{11}{16}$ "	3551-5	3580-5
	Oil Filler Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $\frac{5}{8}$ "	3551-5	3580-5
Cylinder Head	Cambox Cover Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .4"	4 CRU	4 CBB	1185-4CN x $\frac{1}{2}$ "	528-4	1195-4
	Tappet Block Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC x .6"	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
	Manifold Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC x .75"	5 CRU	5 CBB	3585-5CN x $\frac{11}{16}$ "	3551-5	3580-5
	Thermostat Housing Face	$\frac{5}{16}$ "	$\frac{5}{16}$ x 18 UNC-Through	5 CRU	5 CBB	3585-5CN x $\frac{11}{16}$ "	3551-5	3580-5
	Sparking Plug Tappings	$\frac{9}{16}$ "	14 mm. x 1.25 mm.-Through	525	521	$\frac{3}{8}$ " Reach 644	542	Use Pliers
Tappet Block	Camshaft Bearing Cap Face		NOT RECOMMENDED					
Rear Main Cap	Sump Face	$\frac{1}{4}$ "	$\frac{1}{4}$ x 20 UNC-Through	4 CRU	4 CBB	3585-4CN x $\frac{3}{8}$ "	3551-4	3580-4
Induction Manifold	Petrol Drain Tapping	W	$\frac{1}{8}$ x 28 BSP x .26"	2 PR	2 PB	1325-2CN x $\frac{3}{8}$ "	PIP-2	Use Pliers
Water Pump	Water Inlet Body	$\frac{11}{16}$ "	$\frac{3}{8}$ x 19 BSP-Through	6 PR	6 PB	1325-6CN x $\frac{9}{16}$ "	PIP-6	Use Pliers

* Only to be applied to short stud tappings. ** Only to be applied to one Tapping.
 Insert removal tools are available: For Inserts $\frac{1}{8}$ " to $\frac{3}{8}$ " inclusive Part No. 1227-6. For Inserts $\frac{7}{16}$ " to 1" inclusive Part No. 1227-16