

BÖLLHOFF

The aerospace industry meets 360° joining technology



Böllhoff, your expert for the aerospace industry

“Remove before flight” – who doesn’t want to fly safely? We also take a second look and support you when it comes to fulfilling the requirements of the current development trends of the aerospace industry. To increase the energy efficiency and save resources, aeronautical engineers and engine manufacturers also systematically analyse and optimise the production processes. For decades, we have been a partner for the industry and offer special joining solutions. Get on the early plane with us and give your developments the necessary drive.

**We are right where you need us —
by your side.**

Fascination

Infinity

Innovation

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Our InfoPoint provides additional information in the form of further brochures and/or videos at the end of this brochure.

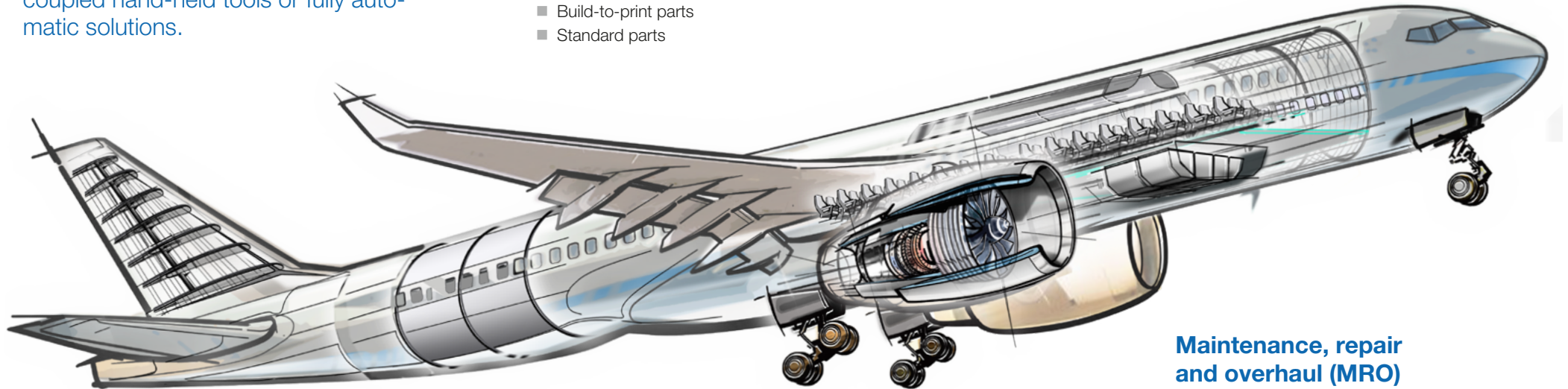
We also supply the assembly solutions for our fasteners. Please do not hesitate to contact us for information about our complete range of processing systems for example: hand-held tools, robot-coupled hand-held tools or fully automatic solutions.

Systems / equipment

- Riveting
- Thread creation
- Thread reinforcement
- Build-to-print parts
- Standard parts

Cabin interior

- Riveting
- Thread creation
- Thread reinforcement
- Adhesive technology
- Decoupling
- Quick-release systems
- Build-to-print parts
- Standard parts



Airframe / aero structure

- Riveting
- Thread creation
- Build-to-print parts
- Standard parts

Engine

- Thread reinforcement
- Build-to-print parts
- Standard parts

Maintenance, repair and overhaul (MRO)

- Riveting
- Thread creation
- Thread reinforcement
- Build-to-print parts
- Standard parts

The HELICOIL® Plus thread insert, which is made from a wire with rhombic profile, is formed into an elastic spiral.

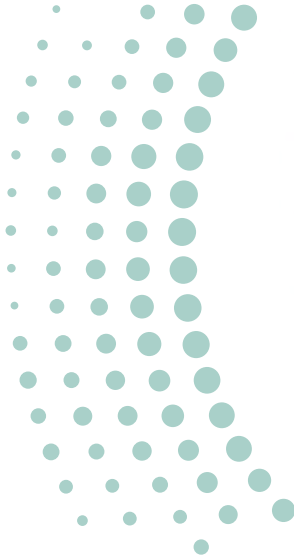
As to the Free Running version, thread by thread it is a completely free running coarse thread.

The result is a true-to-gauge internal thread including the last thread which is in every case threadable. It produces high-strength threads transferring forces from flank to flank into the holding thread. The special thread start allows to position it like a screw and screw it in.

To screw in the thread insert, all you need is the respective installation mandrel of similar size as a tap.

All stages in the HELICOIL® evolution are highly reliable and German and international property rights have been applied for.

You receive a complete system solution consisting of wire thread inserts and specially developed installation tools. This ensures the high quality of the screw joint at maximum utilisation of the lightweight construction potential.










Your benefits:

- Ideal power transmission
- Improved quality of the screw joint
- Even load and tension distribution
- Improved preload forces due to low thread friction
- Downsizing and lightweight construction
- Tight fit
- Increased fatigue strength
- Corrosion and temperature resistance
- No FOD problems

Types

- Free Running
- Screwlock

The HELICOIL® has been tried and tested for more than 65 years and has become a renowned structural component.
There is a solution to almost every task related to this thread technology.

Thread types*	Metric coarse thread DIN ISO 13 1	Metric fine thread DIN ISO 13 (T02-T11)	Pipe thread DIN EN ISO 228/1G	UNC thread NASM 21209	UNF thread NASM 21209	BSW BS 84	BSF BS 84	BA BS 93
Designs*								
Materials*	Stainless steel A2 material No 1.4301 material No 1.4310	Stainless steel A4 material No 1.4571	Bronze material No 2.1020.34	Inconel X 750 material No 2.4669	Nimonic 90 material No 2.4632		Aluminium material No 3.4365	
Surfaces*	Bright	Tin-plated G100 / G300	Dry-film lubricated	Cadmium-plated	Silver-plated	Hard-coated	Coloured red, green, blue, yellow	

* Not all combinations are available.

HELICOIL® Plus thread inserts can be easily and economically installed because there are only a few basic rules to observe. There is a broad range of installation tools for efficient installation – for individual applications as well as for large-scale production. Installation phases are as follows:



Drilling

Common twist drills are used. Prior to tapping, counter-bore 90° and deburr. Outside diameter of **countersink = $D_{HC} + 0.1 \text{ mm}$** . On the cut holding thread, the countersink is hardly visible.



Tapping

To tap the HELICOIL® Plus holding thread, system-dependent original HELICOIL® taps must be used. Recommendations for suitable manual and machine taps are given in our catalogue No 0100. The trueness to gauge of the holding thread must be checked with HELICOIL® thread plug limit gauges.



Form tapping

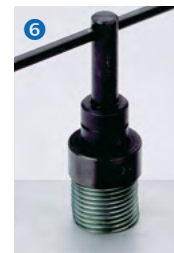
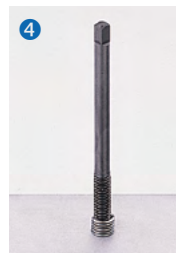
Today, chipless production of internal threads with forming taps is an efficient production method for many materials. This also applies to the HELICOIL® Plus.

D_{HC} = outside Ø of the receiving thread

Insertion of the thread insert

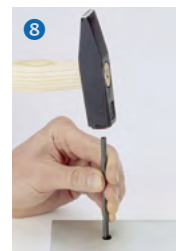
The installation can be done manually, automatically or with machine tools.

The HELICOIL® Plus thread insert is screwed onto the installation mandrel with the tang down **1**, inserted into the leader cartridge **2** or placed on the fly-over tool **3**. Then, the tool is placed over the tapped hole.



Installation

By turning the threaded mandrel **4**, the mandrel **5** or the fly-over tool **6**, respectively, manually or triggering the drive, the thread insert is screwed in. It must be installed at least 0.25 P below the surface.



Breaking off the tang

To produce a through-hole thread, the tang is broken off at the notch. For that, a tang break-off tool is used **7** and **8**. For threads from M14 (fine and normal pitch), the tang can be removed with long nose pliers **9**. For blind-hole threads, the tang does not have to be removed if the maximum screw-in depth t_3 of the screw is observed.

We also supply the assembly solutions for our **HELICOIL®** thread inserts

Your benefit:

You obtain a complete system solution consisting of coil thread inserts and specially developed installation tools. This assures the quality of the joints.

In the following you find one of our systems.



HELICOIL®

Type E-PSG electrical straight screwdriver with leader cartridge

Fast and precise processing of all HELICOIL® types.

Your benefits at a glance:

- Automatic reverse upon reaching the insertion depth
- Continuous adjustment: speed/torque
- Existing tool systems can be used (exchange unit)
- Easy handling
- Ergonomic and compact design
- Low-noise operation

Application example – Aircraft seat elements made of high-strength aluminium

The requirements:

- Wear-resistant thread with integrated screw locking feature on safety relevant components used in the aircraft industry
- Frequently repeated screw loosening / tightening
- Meeting aerospace standard LN 9499

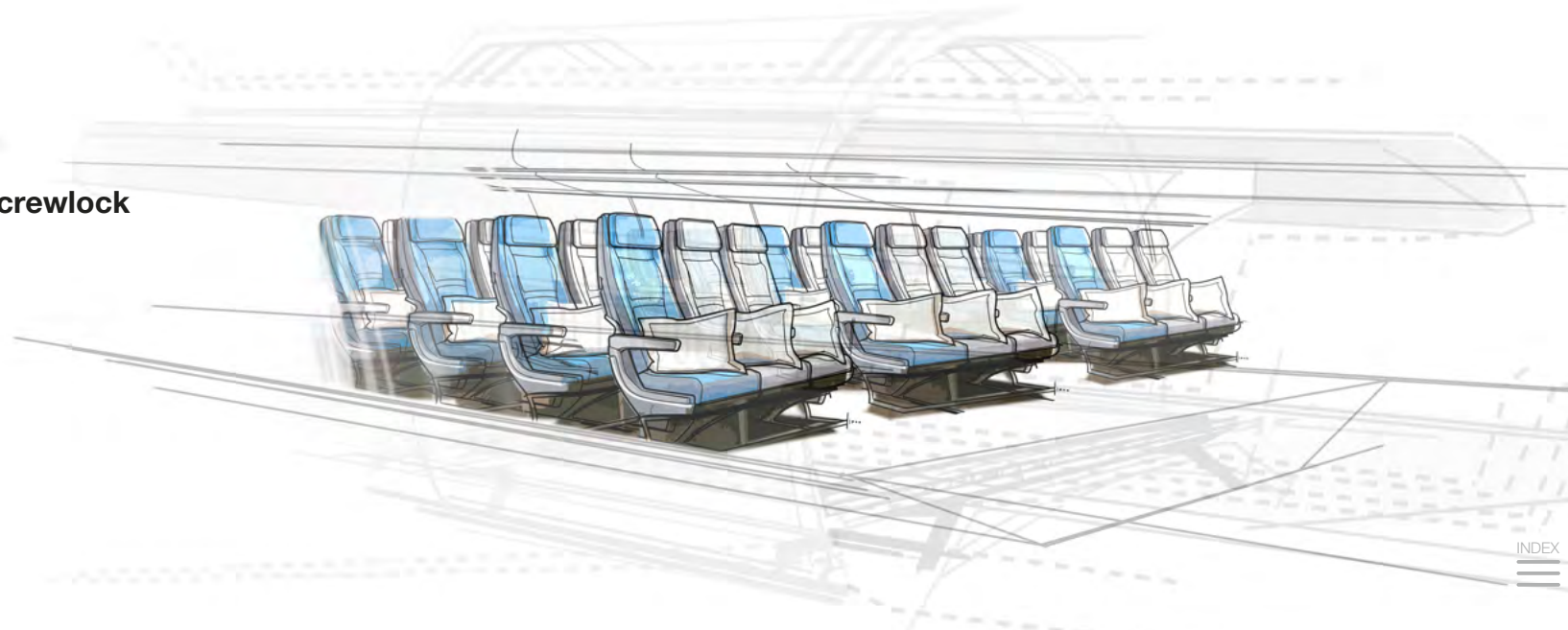
The benefits:

- High-strength and wear-resistant coil thread inserts
- Resistant to corrosion and temperature
- Assembly systems, tools and products from a single source
- Available with imperial and metric dimensions and in special versions

Our solution:



HELICOIL® Plus Screwlock





The technology:

Adhesive bonding, when welding is not an option. Fastening elements with a socket made of transparent plastic are bonded to the customer component using light-curing adhesive. The most important aspects are the short cycle times, the material-friendly process and the flexibility regarding the fastening elements.

Generally, all geometries which can be produced through injection moulding can be realised. Screwed connections on plastic mouldings, detachable and non-detachable snap connections, adhesive SNAPLOC® fasteners, etc. can be applied to materials such as CFRP, FRP, glass, lacquer, cathodic dip coating, plastic such as PC-ABS, PA and blends.

Your benefits:

- Full mechanical load capacity immediately after irradiation
- Short curing times (< 4 seconds)
- Fastening elements cannot be seen on the visible side on plastic or thin-walled components (design)
- Flexible use also after surface treatment

Types:

- Studs and standoffs
- Insulation attachment
- Wiring management

The ONSERT® Portable Mini is a battery-operated manual installation tool. Due to its modular design, it is suitable for applications with limited access.

Your benefits:

- Ergonomic two-component housing: safe-grip and anti-slip
- Optimised curing due to adapted lamp geometry
- Process monitoring via USB port



Included in the delivery scope:

- ONSERT® Portable Mini setting tool
- Battery
- Recharger
- Adhesive metering gun
- Accessories

The requirements:

- Weight reduction of the seat structure
- Development of a more efficient bonding process
- Non-visible bonding of the fastening elements

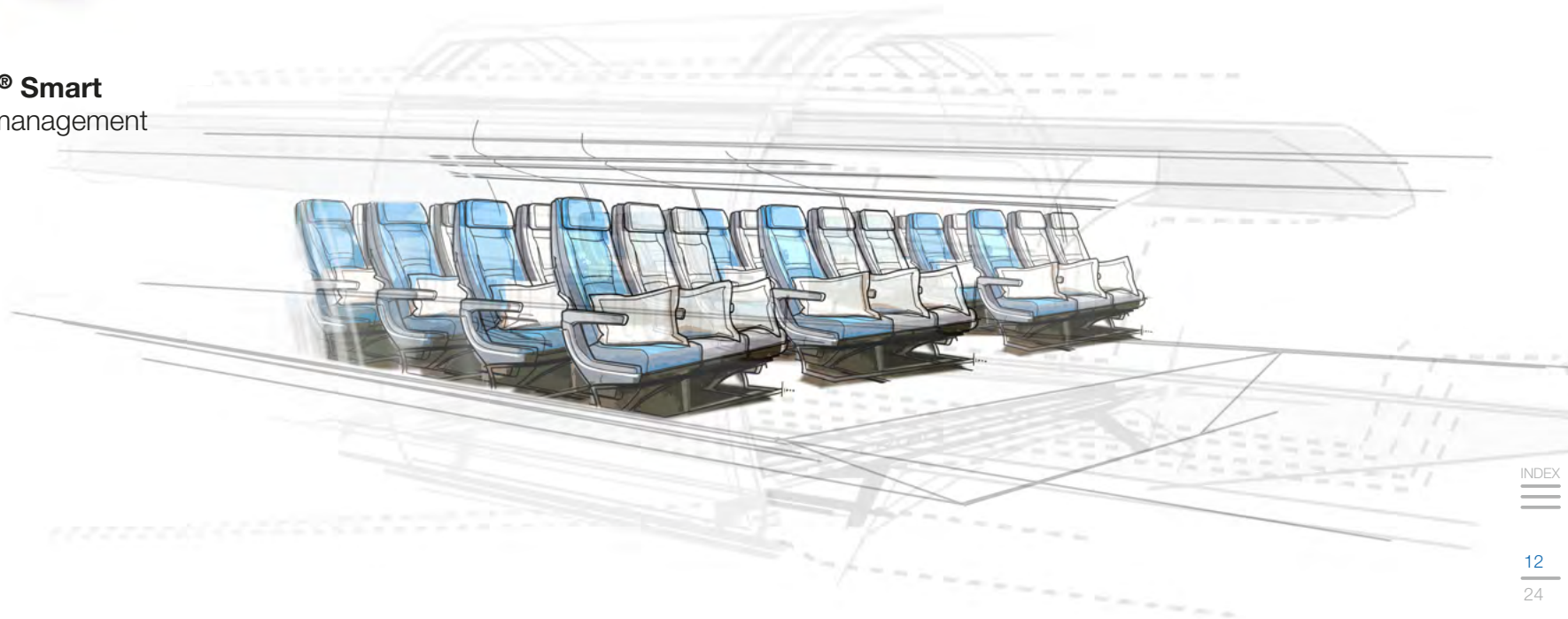
Our solution:



ONSERT® Smart
for cable management

The benefits:

- Short cycle times
- Material-friendly process
- Design freedom of the fastening elements
- Suitable for different heights and cable diameters
- Flexible
- Weight-saving
- The plastic and the adhesive meet the requirements of FAR Part 25, § 25.583 (60 seconds vertical burn)



Noise- and vibration-decoupling

SITEC®

Example SITEC® Rivet
Blind rivet nuts

Blind rivet nuts for noise- and vibration-decoupling.

Your benefits at a glance:

- High-strength thread body on thin-walled components
- Noise- and vibration-decoupling
- Thermal and electrical insulation
- Easy installation



SNAPLOC®

Decoupling plug-in connections

Fasteners and fastening systems for noise- and vibration-decoupling.

Your benefits at a glance:

- Fast and easy installation/removal
- Noise- and vibration-decoupling
- Tolerance compensation in the centre distances
- Variable fastening options
- Easy integration



Tolerance compensation

FLEXITOL®

Tolerance compensation systems

An economic engineering solution for continuous tolerance compensation.

Your benefits at a glance:

- High performance reliability
- Only one-sided accessibility required
- Easy integration into different applications
- High-end product quality
- Fast and easy installation
- No warpage during installation



Customer-specific development parts

TEPRO®

Customer-specific thermoplastic development parts and assemblies

Solutions for almost every application. We are just the right point of contact for customised solutions that also fulfil high requirements. We develop and produce these products for the aviation industry, the automotive industry and many more.

Your benefits at a glance:

- Focus on individual customer benefit
- Customised products
- In-house development, design and prototyping
- Modern tool manufacture
- Modern injection moulding machines



Not to forget:
As always, we also
support you with our
know-how for many
other joining solutions
– **just talk to us.**

Thread creation

RIVKLE®

Blind rivet nuts and studs

Blind rivet nuts and studs to fasten high-strength nut and stud threads on thin-walled components.

Your benefits at a glance:

- Stable thread on thin-walled components
- Installation in case of one-sided accessibility (blind installation)
- Flexible use in every production step
- No thermal stress on the workpiece – and therefore no warpage



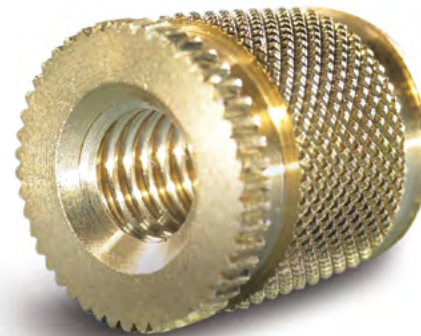
AMTEC®

Thread inserts

High-strength brass thread inserts for plastic components – after moulding.

Your benefits at a glance:

- Shorter moulding cycles
- Reduced manufacturing costs for plastic components
- Secure, stress-free anchorage
- High pull-out and torsion values
- Unrestricted number of reuses as opposed to self-tapping screws



Precision thread insert for plastic components with screw-locking



The technology:

The HITCERT® Screwlock combines the advantages of an aluminium HITCERT® 2 and a stainless steel HELICOIL® Screwlock (according to NASM21209) thread insert for demanding screwed connections.

These two elements match perfectly to provide considerable benefits for screwed connections with high requirements.

The screw is locked through the polygonal-shaped thread of the HELICOIL® Screwlock. These coils have a locking effect on the flanks of the screw or bolt to be screwed in*. The result is an elastically resilient frictional locking mechanism with the bolt or screw resisting self-loosening and unscrewing.

Your benefits:

- High pull-out values
- Very good mechanical properties in thermoplastics
- Lightweight design
- HELICOIL® resists up to 15 screw cycles as specified in NASM8846 and can be replaced for repair
- Compliant with different aerospace standards
 - Locking torque values according to NASM8846 and EN ISO 2320
 - Test load values according to NASM25027

The HITCERT® Screwlock can be used for several applications in the aerospace industry, e.g. in armrests, seats, folding tables, overhead compartments or in-flight entertainment.



* We recommend the use of coated screws.

The technology:

The RIVNUT® Aero is a high-strength, self-locking blind rivet nut for blind installation in aerospace applications. Concentrated technology, designed to meet the high requirements of the aerospace industry.

The body is made of AISI 316L stainless steel to ensure corrosion resistance and optimum mechanical characteristics. The wire thread insert prevents thread disengagement thanks to its screw locking function and permits maximum mechanical performance of the joint. The silver-plated thread prevents binding. The electrophoretic coating applied to the body prevents galvanic corrosion, when used on aluminium parent material.

Your benefits:

- High-strength fastening point: equivalent to class 12 steel nut
- Blind setting – no need for access from both sides
- No maintenance, screw locking, easy to replace
- No need to provide for a maintenance hole during the design phase





Fasteners and mechanical parts

From a drawing to series production

- Serial production for mid-size batches
- Prototyping
- Customer co-design parts for cost optimisation
- Assembly

Our competencies:

- Raw material processing: aluminium, steel, stainless steel, titanium, nickel-based, ...
- Turning bars up to Ø 70 mm or in mandrill up to Ø 390 mm
- Milling parts up to 800 x 600 x 500 mm
- Part length up to 1,000 mm
- Forging
- Established subcontracting management for heat and surface treatment

- Non-threaded fasteners: **washers / bushes / spacers**
- Threaded fasteners: **nuts / self-locking nuts / fittings / screws / bolts**
- Surface treatment: **cadmium plating / passivation / silver plating**

Qualified standard parts lists:

- Airbus QPL (ABS, AS, ASNA, MS, NAS, NFL, NSA, ...)
- Airbus Helicopters (ASNA, DHS, EN, ECS, ...)

Additional standards:

- EN
- ISO
- NFL
- ...

New standard parts:

- Development competence for new standard parts including qualification process





Your aerospace expert

Your partner to succeed in joining – and what that means for you:

Development and design competencies

- Dedicated experts for innovation, product, project and design management
- Trend scouting
- Design thinking
- FMEA
- Feasibility studies
- R & D activities (FEM, moldflow analysis)
- Multiple CAD software, e.g. Catia V5, Ansys, Creo Parametric
- Customer-tailored developments
- Application engineering and technical consulting
- Prototyping and additive manufacturing
- Value stream analysis, e.g. cost optimisation
- In-house laboratory accredited according to DIN EN ISO/IEC 17025

Production

- Technical production know-how
- Thirteen modern production facilities worldwide
- Major production technologies
 - Injection moulding
 - Cold- and hot-forming
 - Turning and milling processes
 - Thread rolling
 - Wire profiling and winding
 - Surface treatment (passivation, cadmium, silver coating)
 - Mechanical and plant engineering
- Zero-defect philosophy
- Qualified production staff and continuous internal training
- Company training centre

Qualification

- Quality management systems – requirements for
 - EN 9100 Aviation, Space and Defence Organizations and
 - IATF 16949 Automotive Industries
- DIN EN 9145 requirements for Advanced Product Quality Planning (APQP) and Production Part Approval Process (PPAP)
- FAIR EN 9102
- In-house laboratory accredited according to DIN EN ISO/IEC 17025
- Environmental management DIN EN ISO 14001
- Energy management systems DIN EN ISO 50001
- Occupational health and safety management systems DIN ISO 45001 (replaces OHSAS 18001)
- Product qualification for customers and third parties

Supply

- Supply chain solutions
- Worldwide network within the group
- Large warehouses in France, Germany and the United Kingdom
- Proximity to customers thanks to global presence
- Supporting sales and after sales services
- Repair kits
- Customised packaging

Catalogues

Product catalogues



HELICOIL® Plus

Thread technology for high-strength fastenings – metric threads
Catalogue No 0100

<https://www.boellhoff.com/en/pdf/helicoil-plus>



HELICOIL® Plus

Thread technology for high-strength fastenings – imperial threads UNC, UNF, BSW, BSF, BSP/G, BA
Catalogue No 0101

<https://www.boellhoff.com/en/pdf/helicoil-plus-imperial>



HELICOIL® Tangfree

The tangfree coil thread insert for high-strength threads
– metric threads
– imperial threads: UNC and UNF
Catalogue No 0150

<https://www.boellhoff.com/en/pdf/helicoil-tangfree>



HELICOIL® E-PSG 256 Quick Exchange

Quick and process-reliable switch of different dimensions
Catalogue No 0114

<https://www.boellhoff.com/en/pdf/helicoil-quick-exchange>



HITSERT® Screwlock

Precision thread insert for plastic components with screw-locking
Catalogue No 0205

<https://www.boellhoff.com/en/pdf/hitsert-screwlock>



RIVNUT® Aero

Blind rivet nuts for aerospace
Catalogue No 2317

<https://www.boellhoff.com/en/pdf/rivnut-aero>



ONSERT®

Quick and process-reliable bonding of fastening elements with light-curing adhesives
Catalogue No 0250

<https://www.boellhoff.com/en/pdf/onsert>

Catalogues

Product catalogues



SITEC®

Fastening elements for vibration and noise decoupling
Catalogue No 2500

<https://www.boellhoff.com/en/pdf/sitec>



SNAPLOC®

Vibration and noise decoupling plug-in connections
Catalogue No 4350

<https://www.boellhoff.com/en/pdf/snaploc>



FLEXITOL®

Systems for stepless tolerance compensation
Catalogue No 0590

<https://www.boellhoff.com/en/pdf/flexitol>



TEPRO®

Engineering plastic products and subassemblies
Catalogue No 4720

<https://www.boellhoff.com/en/pdf/tepro>

Product catalogues / Aerospace-specific catalogue



RIVKLE®

Blind rivet nuts and studs
Catalogue No 2307

<https://www.boellhoff.com/en/pdf/rivkle>



AMTEC®

Precision thread inserts for after-moulding joining in plastic components
Catalogue No 0200

<https://www.boellhoff.com/en/pdf/amtec>



Aerospace

The aerospace industry meets 360° joining technology
Catalogue No 0951

<https://www.boellhoff.com/en/pdf/aerospace>

Videos

Fastener videos



HELICOIL® Plus Free Running

Thread inserts for metal

<https://www.boellhoff.com/video/helicoil-plus>



HELICOIL® Plus Screwlock

Thread inserts for metal with screw-locking

<https://www.boellhoff.com/video/helicoil-plus-screwlock>



HELICOIL® Tangfree Free Running

Thread inserts for metal without a tang

<https://www.boellhoff.com/video/helicoil-tangfree>



HELICOIL® Tangfree Screwlock

Screw-locking thread insert without a tang for metals

<https://www.boellhoff.com/video/helicoil-tangfree-screwlock>



HITSERT® Screwlock

Intelligent combination of fastening functions

<https://www.boellhoff.com/video/hitsert-screwlock>



ONCERT®

Quick and process-reliable bonding of fastening elements with light-curing adhesives

<https://www.boellhoff.com/video/onsert>



SITEC®

Fastening elements for vibration- and noise-decoupling

<https://www.boellhoff.com/video/sitec-rivet>



SNAPLOC®

Vibration- and noise-decoupling plug-in connections

<https://www.boellhoff.com/video/snaploc>

Videos

Fastener videos



FLEXITOL®

Systems for stepless tolerance compensation

<https://www.boellhoff.com/video/flexitol-metal>



RIVKLE®

Blind rivet nuts - Riveting process

<https://www.boellhoff.com/video/rivkle-riveting-process>



AMTEC®

Thread technology for plastics

<https://www.boellhoff.com/video/hitsert2-with-sealing-ring>

Installation videos / Aerospace-specific video



HELICOIL® Plus

Installation with electronical tool
HELICOIL® E-PSG 256 Quick
Exchange

<https://www.boellhoff.com/video/helicoil-installation-with-e-psg-256>



ONCERT® Portable Mini

Quick and process-reliable bonding
of fastening elements with light-curing
adhesives

<https://www.boellhoff.com/video/onsert-portable-mini>



The aerospace industry meets
360° joining technology

<https://www.boellhoff.com/video/aerospace>

BÖLLHOFF



Böllhoff Group

Innovative partner for joining technology with assembly and logistics solutions.

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Passion for successful joining.

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