

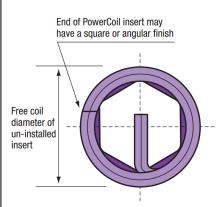
Insert Part Number		3532-7/8X2.0DSL
Insert Thread Form	Unified National Coarse -	
		UNC
Nominal Thread Size		7/8 X 9
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	inch	1.7500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-C1420
National Aerospace Standard	#	NASM21209-C1420
Federal Stock	#	5340-724-1919
National Stock / NATO	#	-

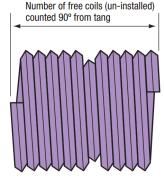
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate taps. When using Bottoming and Spiral Flute Taps these dimensions maybe reduced by an amount equal to 2 thread pitches. Any countersink depths must be added to these dimensions.

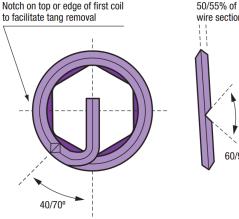
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	-
Removal Tool	3500-RT3
Machine Installation Tool	-
Mandrel Installation Tool	3532-7/8HIP
Captive Prewinder Tool	-
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	-
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

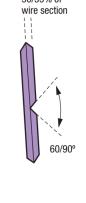
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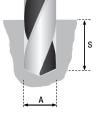


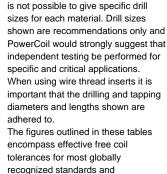




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
mm	23.00			
	2654-23.00			
inch	29/32			
	2651-29/32			
inch	0.899			
inch	0.912			
inch	2.250			
	inch inch			

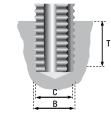






IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it

TAPPED HOLE DIMENSIONS			
Tap Size	STI		UNC 7/8 X 9
Tap Size	-		-
B Major Diameter		inch	1.0193
C Pitch Diameter MIN		inch	0.9471
C Pitch Diameter MAX	2B	inch	0.9522
C Pitch Diameter MAX	1B	inch	0.954
T Tapping Depth MIN		inch	2.139
Power Coil Tap Part Number	STI	Taper	3532-7/8T
Power Coil Tap Part Number	STI	Intermediate	3532-7/81
Power Coil Tap Part Number	STI	Bottoming	3532-7/8B
Power Coil Tap Part Number	STI	SpiralPoint	3532-7/8SP
Power Coil Tap Part Number	STI	SpiralFlute	3532-7/8SF



Number of Free Coils – the number of coils on an un-installed insert counted along the insert length 90° from the tang.

manufacturers, including those of reduced diameter wire thread inserts.

INSERT SPECIFICATIONS			
E Fitted Minor Diameter	inch	0.7547	
Q Nominal Length Installed	inch	1.7500	
Free Coil Diameter minimum	inch	1.009	
Free Coil Diameter maximum	inch	1.052	
Free Coils minimum	#	13.30	
Free Coils maximum	#	13.90	

