

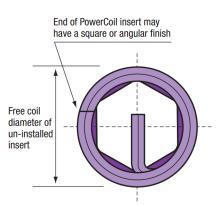
Insert Part Number		3532-3/8X1.0DSL
Insert Thread Form		Unified National Coarse -
		UNC
Nominal Thread Size		3/8 X 16
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	inch	0.3750
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-C6-10
National Aerospace Standard	#	NASM21209-C6-10
Federal Stock	#	5340-812-1892
National Stock / NATO	#	5325-00-210-3935

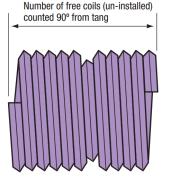
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate 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.

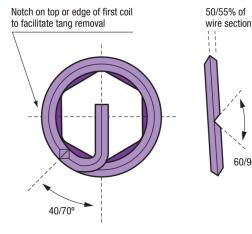
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	3500-TB12			
Removal Tool	3500-RT3			
Machine Installation Tool	3532-3/8MIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3532-3/8HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB10			
Pneumatic Front end assembly (FEA)	3532-3/8MIP			
FEA Mandrel	3532-3/8MIPM			
FEA Nozzle	3532-3/8MIPN			
Pneumatic Tool	3500-MIP2			

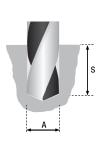
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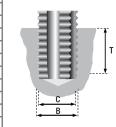
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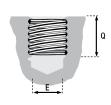




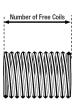
IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and PowerCoil would strongly suggest that independent testing be performed for specific and critical applications. When using wire thread inserts it is important that the drilling and tapping diameters and lengths shown are adhered to.

The figures outlined in these tables encompass effective free coil tolerances for most globally recognized standards and manufacturers, including those of reduced diameter wire thread inserts.

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







DRILLED HOLE DIMENSIONS	RILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	9.90		
Drill Part Number		2007-9.90		
Drill Size inch	inch	25/64		
Drill Part Number inch		2006-25/64		
A Minor Diameter minimum	inch	0.389		
A Minor Diameter maximum	inch	0.399		
S Drilling Depth minimum	inch	0.656		

APPED HOLE DIMENSIONS				
STI		UNC 3/8 X 16		
-		-		
	inch	0.4562		
	inch	0.4156		
2B	inch	0.4189		
1B	inch	0.420		
	inch	0.594		
STI	Taper	3532-3/8T		
STI	Intermediate	3532-3/81		
STI	Bottoming	3532-3/8B		
STI	SpiralPoint	3532-3/8SP		
STI	SpiralFlute	3532-3/8SF		
	STI - 2B 1B STI STI STI STI	STI - inch inch 2B inch 1B inch inch STI Taper STI Intermediate STI Bottoming STI SpiralPoint		

INSERT SPECIFICATIONS	SPECIFICATIONS			
E Fitted Minor Diameter	inch	0.3073		
Q Nominal Length Installed	inch	0.3750		
Free Coil Diameter minimum	inch	0.452		
Free Coil Diameter maximum	inch	0.472		
Free Coils minimum	#	4.10		
Free Coils maximum	#	4.30		