## powercoil®

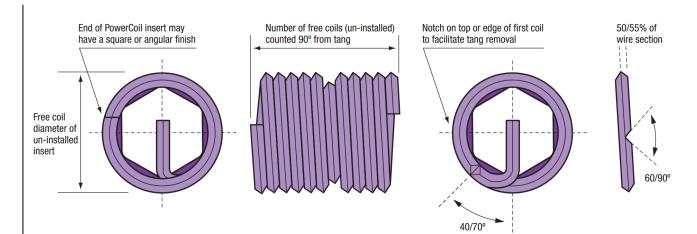
Insert Part Number		3521-8.00X1.5DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M8 X 1.00
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	mm	12.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-158
National Aerospace Standard	#	
Federal Stock	#	-
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				
Part #				
-				
3500-TB12				
3500-RT2				
3521-8.00MIT				
-				
3521-8.00HIP				
-				
3500-STB9				
3521-8.00MIP				
3521-8.00MIPM				
3521-8.00MIPN				
3500-MIP2				

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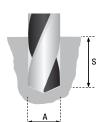
PowerCoil is a registered trademark of Bordo International Pty Ltd Australia

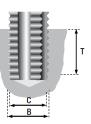


DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	8.30		
Drill Part Number		2007-8.30		
Drill Size inch	inch	21/64		
Drill Part Number inch		2006-21/64		
A Minor Diameter minimum	mm	8.406		
A Minor Diameter maximum	mm	8.216		
S Drilling Depth minimum	mm	16.50		

Tap Size	STI		M8 X 1.00
Tap Size	-		-
B Major Diameter		mm	9.299
C Pitch Diameter MIN		mm	8.650
C Pitch Diameter MAX	5H	mm	8.719
C Pitch Diameter MAX	6H	mm	8.742
T Tapping Depth MIN		mm	15.50
Power Coil Tap Part Number	STI	Taper	3521-8.00T
Power Coil Tap Part Number	STI	Intermediate	3521-8.001
Power Coil Tap Part Number	STI	Bottoming	3521-8.00B
Power Coil Tap Part Number	STI	SpiralPoint	3521-8.00SP
Power Coil Tap Part Number	STI	SpiralFlute	3521-8.00SF

INSERT SPECIFICATIONS			
E Fitted Minor Diameter	mm	6.917	
Q Nominal Length Installed	mm	12.000	
Free Coil Diameter minimum	mm	11.412	
Free Coil Diameter maximum	mm	12.500	
Free Coils minimum	#	9.10	
Free Coils maximum	#	10.00	





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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.

