

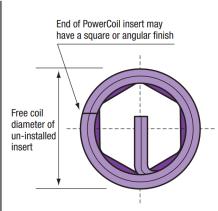
Insert Part Number		3534-1/4X1.0DSL	
Insert Thread Form		Unified National Fine - UNF	
Nominal Thread Size		1/4 X 28	
Insert Length Q (installed)	D	1.0D	
Insert Length Q (installed)	inch	0.2500	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MS21209-F4-10	
National Aerospace Standard	#	NASM21209-F4-10	
Federal Stock	#	5340-805-9658	
National Stock / NATO	#	5325-00-210-3920	

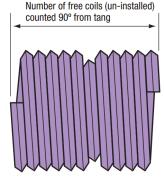
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

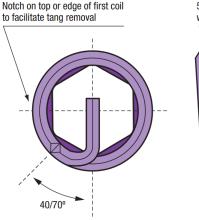
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	3500-TB9			
Removal Tool	3500-RT2			
Machine Installation Tool	3534-1/4MIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3534-1/4HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB8			
Pneumatic Front end assembly (FEA)	3534-1/4MIP			
FEA Mandrel	3534-1/4MIPM			
FEA Nozzle	3534-1/4MIPN			
Pneumatic Tool	3500-MIP1			

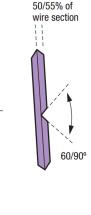
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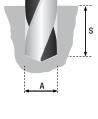






DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	6.60			
Drill Part Number		2007-6.60			
Drill Size inch	inch	17/64			
Drill Part Number inch		2006-17/64			
A Minor Diameter minimum	inch	0.258			
A Minor Diameter maximum	inch	0.265			
S Drilling Depth minimum	inch	0.411			







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

is not possible to give specific drill

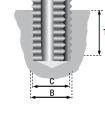
sizes for each material. Drill sizes

coolant, equipment being used - and it

shown are recommendations only and

PowerCoil would strongly suggest that

TAPPED HOLE DIMENSIONS			
Tap Size	STI		UNF 1/4 X 28
Tap Size	-		-
B Major Diameter		inch	0.2964
C Pitch Diameter MIN		inch	0.2732
C Pitch Diameter MAX	2B	inch	0.2754
C Pitch Diameter MAX	1B	inch	0.277
T Tapping Depth MIN		inch	0.375
Power Coil Tap Part Number	STI	Taper	3534-1/4T
Power Coil Tap Part Number	STI	Intermediate	3534-1/41
Power Coil Tap Part Number	STI	Bottoming	3534-1/4B
Power Coil Tap Part Number	STI	SpiralPoint	3534-1/4SP
Power Coil Tap Part Number	STI	SpiralFlute	3534-1/4SF



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

