

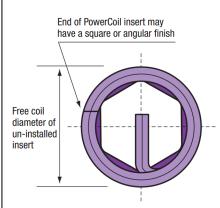
Insert Part Number		3520-6.00X2.5DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M6 X 1.00
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	mm	15.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-256
National Aerospace Standard	#	
Federal Stock	#	-
National Stock / NATO	#	-

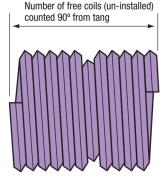
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

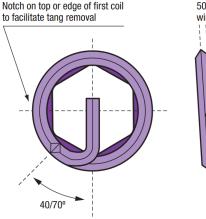
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB9
Removal Tool	3500-RT2
Machine Installation Tool	3520-6.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-6.00HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB8
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

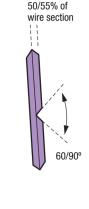
## powercoil.com.au

PowerCoil is a registered trademark of Bordo International Ptv Ltd Australia

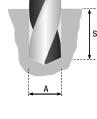


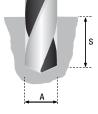


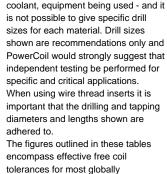




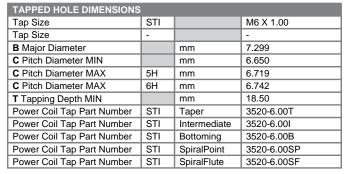
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	6.30	
Drill Part Number		2007-6.30	
Drill Size inch	inch	1/4	
Drill Part Number inch		2006-1/4	
A Minor Diameter minimum	mm	6.216	
A Minor Diameter maximum	mm	6.406	
S Drilling Depth minimum	mm	19.50	

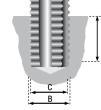






**IMPORTANT** The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed,

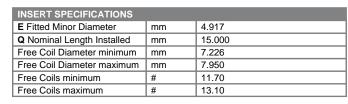


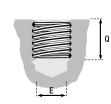


reduced diameter wire thread inserts. Number of Free Coils – the number of coils on an un-installed insert counted along the insert length 90°

manufacturers, including those of

recognized standards and







from the tang.

