

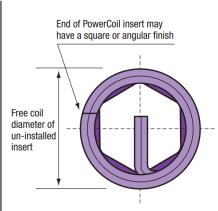
Insert Part Number		3520-22.00X2.5DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M22 X 2.5
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	mm	55.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-277
National Aerospace Standard	#	
Federal Stock	#	-
National Stock / NATO	#	-

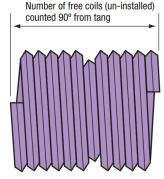
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

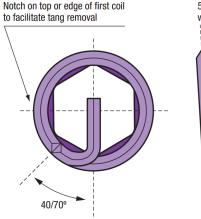
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	-
Removal Tool	3500-RT3
Machine Installation Tool	-
Mandrel Installation Tool	-
Captive Prewinder Tool	-
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	-
Pneumatic Front end assembly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

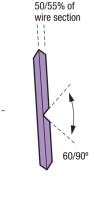
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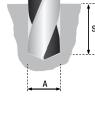


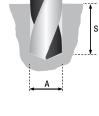


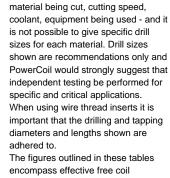




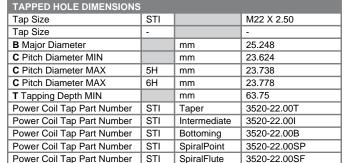
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
mm	22.80			
	-			
inch	57/64			
	2651-57/64			
mm	22.541			
mm	22.896			
mm	66.25			
	inch mm mm			

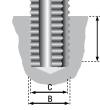






IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of





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.

tolerances for most globally

recognized standards and

INSERT SPECIFICATIONS				
E Fitted Minor Diameter	mm	19.294		
Q Nominal Length Installed	mm	55.000		
Free Coil Diameter minimum	mm	25.900		
Free Coil Diameter maximum	mm	26.900		
Free Coils minimum	#	18.50		
Free Coils maximum	#	20.10		
Free Colls maximum	#	20.10		

