

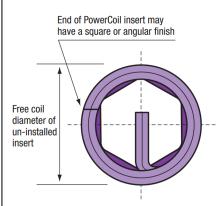
Insert Part Number		3520-4.00X2.0DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M4 X .7
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	mm	8.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-204
National Aerospace Standard	#	
Federal Stock	#	-
National Stock / NATO	#	-

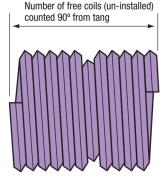
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

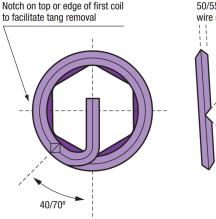
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB6
Removal Tool	3500-RT2
Machine Installation Tool	3520-4.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-4.00HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB5
Pneumatic Front end assembly (FEA)	3520-4.00MIP
FEA Mandrel	3520-4.00MIPM
FEA Nozzle	3520-4.00MIPN
Pneumatic Tool	3500-MIP1

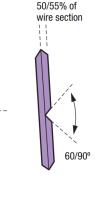
powercoil.com.au

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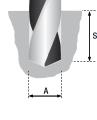


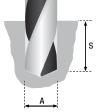


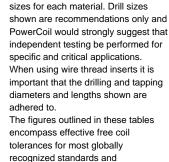




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	4.20	
Drill Part Number		2007-4.20	
Drill Size inch	inch	11/64	
Drill Part Number inch		2006-11/64	
A Minor Diameter minimum	mm	4.152	
A Minor Diameter maximum	mm	4.292	
S Drilling Depth minimum	mm	11.15	



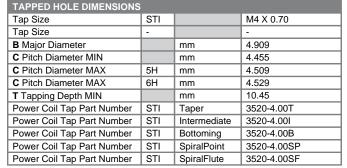


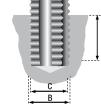


IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed,

coolant, equipment being used - and it

is not possible to give specific drill





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.

