

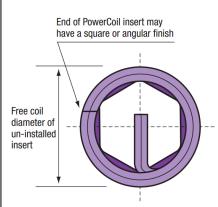
Insert Part Number		3520-2.20X3.0DSL	
Insert Thread Form		Metric Coarse	
Nominal Thread Size		M2.2 X 0.45	
Insert Length Q (installed)	D	3.0D	
Insert Length Q (installed)	mm	6.600	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MA3329-300	
National Aerospace Standard	#		
Federal Stock	#	-	
National Stock / NATO	#	-	

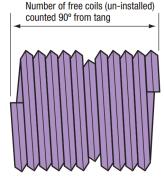
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

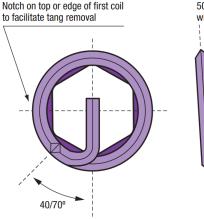
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	3500-TB2			
Removal Tool	3500-RT1			
Machine Installation Tool	3520-2.20MIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3520-2.20HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB1			
Pneumatic Front end assembly (FEA)	-			
FEA Mandrel	-			
FEA Nozzle	-			
Pneumatic Tool	-			

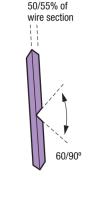
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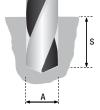


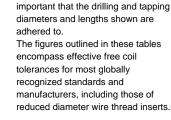




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	2.30		
Drill Part Number		2007-2.30		
Drill Size inch	inch	#42		
Drill Part Number inch		2013-42		
A Minor Diameter minimum	mm	2.297		
A Minor Diameter maximum	mm	2.397		
S Drilling Depth minimum	mm	8.63		







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

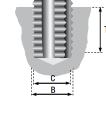
shown are recommendations only and

PowerCoil would strongly suggest that

independent testing be performed for

specific and critical applications. When using wire thread inserts it is

TAPPED HOLE DIMENSIONS					
Tap Size	STI		M2.2 X 0.45		
Tap Size	-		-		
B Major Diameter		mm	2.785		
C Pitch Diameter MIN		mm	2.492		
C Pitch Diameter MAX	5H	mm	2.532		
C Pitch Diameter MAX	6H	mm	2.547		
T Tapping Depth MIN		mm	8.18		
Power Coil Tap Part Number	STI	Taper	3520-2.20T		
Power Coil Tap Part Number	STI	Intermediate	3520-2.201		
Power Coil Tap Part Number	STI	Bottoming	3520-2.20B		
Power Coil Tap Part Number	STI	SpiralPoint	3520-2.20SP		
Power Coil Tap Part Number	STI	SpiralFlute	3520-2.20SF		



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

