

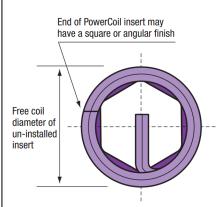
Insert Part Number		3520-2.50X1.5DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M2.5 X 0.45
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	mm	3.750
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-151
National Aerospace Standard	#	
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-TB3
Removal Tool	3500-RT1
Machine Installation Tool	3520-2.50MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-2.50HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB2
Pneumatic Front end assembly (FEA)	3520-2.50MIP
FEA Mandrel	3520-2.50MIPM
FEA Nozzle	3520-2.50MIPN
Pneumatic Tool	3500-MIP1

## powercoil.com.au

PowerCoil is a registered trademark of Bordo International Ptv Ltd Australia



**TAPPED HOLE DIMENSIONS** 

Tap Size

Tap Size

**B** Major Diameter

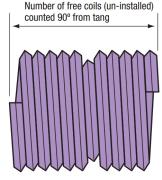
C Pitch Diameter MIN

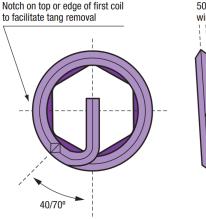
C Pitch Diameter MAX

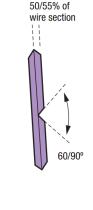
C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number







DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	2.60	
Drill Part Number		2007-2.60	
Drill Size inch	inch	#37	
Drill Part Number inch		2013-37	
A Minor Diameter minimum	mm	2.597	
A Minor Diameter maximum	mm	2.697	
S Drilling Depth minimum	mm	5.78	

mm

mm

mm

mm

mm

Taper

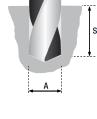
STI

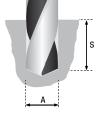
6H

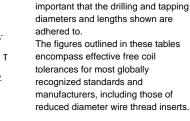
STI

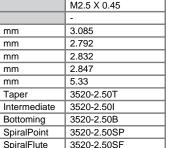
STI

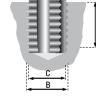
STI











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

**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

shown are recommendations only and

PowerCoil would strongly suggest that

independent testing be performed for

When using wire thread inserts it is

specific and critical applications.

is not possible to give specific drill

sizes for each material. Drill sizes

