

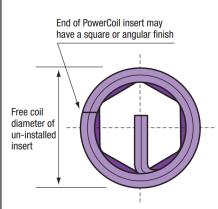
Insert Part Number		3521-24.00X1.5DSL	
Insert Thread Form		Metric Fine	
Nominal Thread Size		M24 X 2.0	
Insert Length Q (installed)	D	1.5D	
Insert Length Q (installed)	mm	36.000	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MA3329-178	
National Aerospace Standard	#		
Federal Stock	#	-	
National Stock / NATO	#	-	

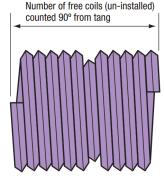
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

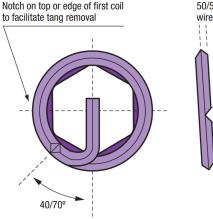
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS	
TOOL TYPE	Part #	
Hand Installation Tool	-	
Tang Break Tool	-	
Removal Tool	3500-RT3	
Machine Installation Tool	-	
Mandrel Installation Tool	-	
Captive Prewinder Tool	-	
Non-Captive Prewinder Tool	-	
Spring Loaded tang Break Tool	-	
Pneumatic Front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

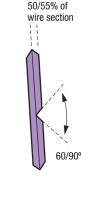
powercoil.com.au

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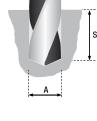


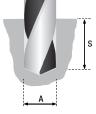


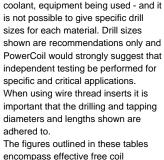




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	24.50		
Drill Part Number		2654-24.50		
Drill Size inch	inch	31/32		
Drill Part Number inch		2651-31/32		
A Minor Diameter minimum	mm	24.433		
A Minor Diameter maximum	mm	24.733		
S Drilling Depth minimum	mm	45.00		

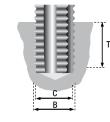






IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed,

TAPPED HOLE DIMENSIONS			
Tap Size	STI		M24 X 2.00
Tap Size	-		-
B Major Diameter		mm	26.598
C Pitch Diameter MIN		mm	25.299
C Pitch Diameter MAX	5H	mm	25.414
C Pitch Diameter MAX	6H	mm	25.454
T Tapping Depth MIN		mm	43.00
Power Coil Tap Part Number	STI	Taper	3521-24.00T
Power Coil Tap Part Number	STI	Intermediate	3521-24.001
Power Coil Tap Part Number	STI	Bottoming	3521-24.00B
Power Coil Tap Part Number	STI	SpiralPoint	-
Power Coil Tap Part Number	STI	SpiralFlute	-



encompass effective free coil tolerances for most globally recognized standards and manufacturers, including those of reduced diameter wire thread inserts.

Number of Free Coils – the number

of coils on an un-installed insert counted along the insert length 90° from the tang.

