

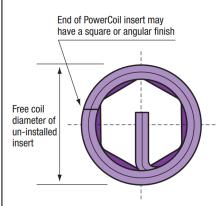
| Insert Part Number          |    | 3521-8.00X2.0DSL    |  |
|-----------------------------|----|---------------------|--|
| Insert Thread Form          |    | Metric Fine         |  |
| Nominal Thread Size         |    | M8 X 1.00           |  |
| Insert Length Q (installed) | D  | 2.0D                |  |
| Insert Length Q (installed) | mm | 16.000              |  |
| Insert Material             |    | 304 Stainless Steel |  |
| Insert Coating/Plating      |    | -                   |  |
| Military Standard           | #  | MA3329-208          |  |
| National Aerospace Standard | #  |                     |  |
| Federal Stock               | #  | -                   |  |
| National Stock / NATO       | #  | -                   |  |

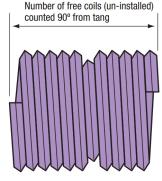
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

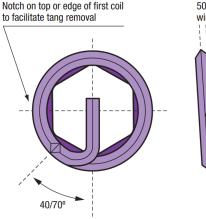
| COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS |               |  |  |  |
|---|---------------|--|--|--|
| TOOL TYPE   | Part #        |  |  |  |
| Hand Installation Tool                              | -             |  |  |  |
| Tang Break Tool                                     | 3500-TB12     |  |  |  |
| Removal Tool  | 3500-RT2      |  |  |  |
| Machine Installation Tool                           | 3521-8.00MIT  |  |  |  |
| Mandrel Installation Tool                           | -             |  |  |  |
| Captive Prewinder Tool                              | 3521-8.00HIP  |  |  |  |
| Non-Captive Prewinder Tool                          | -             |  |  |  |
| Spring Loaded tang Break Tool                       | 3500-STB9     |  |  |  |
| Pneumatic Front end assembly (FEA)                  | 3521-8.00MIP  |  |  |  |
| FEA Mandrel   | 3521-8.00MIPM |  |  |  |
| FEA Nozzle  | 3521-8.00MIPN |  |  |  |
| Pneumatic Tool                                      | 3500-MIP2     |  |  |  |

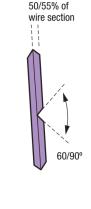
## powercoil.com.au

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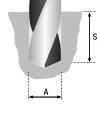


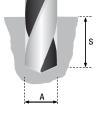


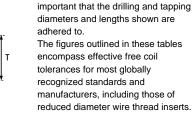




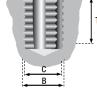
| DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP |      |            |  |  |
|---|------|------------|--|--|
| Drill Size                                    | mm   | 8.30       |  |  |
| Drill Part Number                             |      | 2007-8.30  |  |  |
| Drill Size inch                               | inch | 21/64      |  |  |
| Drill Part Number inch                        |      | 2006-21/64 |  |  |
| A Minor Diameter minimum                      | mm   | 8.406      |  |  |
| A Minor Diameter maximum                      | mm   | 8.216      |  |  |
| S Drilling Depth minimum                      | mm   | 20.50      |  |  |







| TAPPED HOLE DIMENSIONS     |     |              |             |
|----------------------------|-----|--------------|-------------|
| Tap Size                   | STI |              | M8 X 1.00   |
| Tap Size                   | -   |              | -           |
| <b>B</b> Major Diameter    |     | mm           | 9.299       |
| C Pitch Diameter MIN       |     | mm           | 8.650       |
| C Pitch Diameter MAX       | 5H  | mm           | 8.719       |
| C Pitch Diameter MAX       | 6H  | mm           | 8.742       |
| T Tapping Depth MIN        |     | mm           | 19.50       |
| Power Coil Tap Part Number | STI | Taper        | 3521-8.00T  |
| Power Coil Tap Part Number | STI | Intermediate | 3521-8.00I  |
| Power Coil Tap Part Number | STI | Bottoming    | 3521-8.00B  |
| Power Coil Tap Part Number | STI | SpiralPoint  | 3521-8.00SP |
| Power Coil Tap Part Number | STI | SpiralFlute  | 3521-8.00SF |



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,

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







