## powercoil®

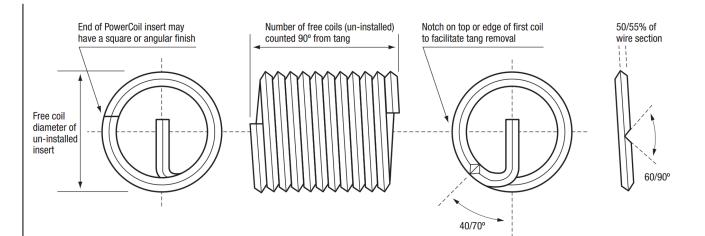
Insert Part Number		3520-20.00X1.5DP
Insert Thread Form		Metric Coarse
Nominal Thread Size		M20 X 2.50
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	mm	30.00
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	
National Aerospace Standard	#	
Federal Stock	#	
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				
Part #				
3500-HIT21				
-				
3500-RT3				
-				
3520-20.00HIP				
-				
-				
-				
-				
-				
-				
-				



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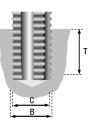


DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	20.80		
Drill Part Number		-		
Drill Size inch	inch	13/16		
Drill Part Number inch		2651-13/16		
A Minor Diameter minimum	mm	20.541		
A Minor Diameter maximum	mm	20.896		
S Drilling Depth minimum	mm	41.25		

TAPPED HOLE DIMENSIONS					
Tap Size	STI		M20 X 2.50		
Tap Size	-		-		
B Major Diameter		mm	23.248		
C Pitch Diameter MIN		mm	21.624		
C Pitch Diameter MAX	5H	mm	21.738		
C Pitch Diameter MAX	6H	mm	21.778		
T Tapping Depth MIN		mm	38.75		
Power Coil Tap Part Number	STI	Taper	3520-2.00T		
Power Coil Tap Part Number	STI	Intermediate	3520-2.001		
Power Coil Tap Part Number	STI	Bottoming	3520-2.00B		
Power Coil Tap Part Number	STI	SpiralPoint	3520-2.00SP		
Power Coil Tap Part Number	STI	SpiralFlute	3520-2.00SF		

INSERT SPECIFICATIONS		
E Fitted Minor Diameter	mm	17.294
Q Nominal Length Installed	mm	30.00
Free Coil Diameter minimum	mm	23.02
Free Coil Diameter maximum	mm	24.40
Free Coils minimum	#	9.60
Free Coils maximum	#	10.20

A S



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**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 sizes for each material. Drill sizes 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 important that the drilling and tapping diameters and lengths shown are adhered to. The figures outlined in these tables

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.

