

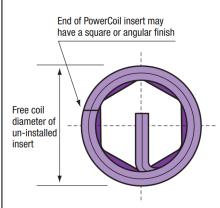
Insert Part Number		3520-2.50X1.5DSLIR
Insert Thread Form		Metric Coarse
Nominal Thread Size		M2.5 X 0.45
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	mm	3.750
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-151
National Aerospace Standard	#	
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	

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INSERT SPECIFICATIONS

E Fitted Minor Diameter

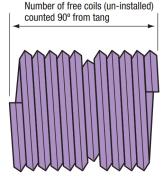
Q Nominal Length Installed

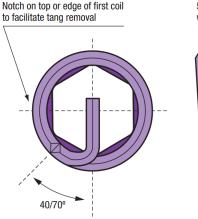
Free Coil Diameter minimum

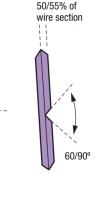
Free Coil Diameter maximum

Free Coils minimum

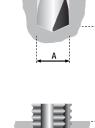
Free Coils maximum

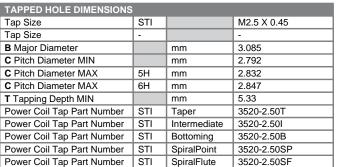






DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	2.60	
Drill Part Number		2007-2.60	
Drill Size inch	inch	#37	
Drill Part Number inch		2013-37	
A Minor Diameter minimum	mm	2.597	
A Minor Diameter maximum	mm	2.697	
S Drilling Depth minimum	mm	5.78	





mm

mm

mm

mm

#

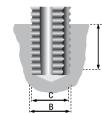
2.013

3.750

3.054

3.700 5.20

6.50



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.



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

The figures outlined in these tables

