

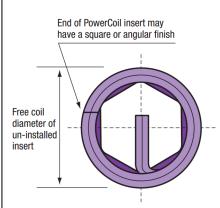
Insert Part Number		3520-3.00X1.5DSLIR		
Insert Thread Form		Metric Coarse		
Nominal Thread Size		M3 X .5		
Insert Length Q (installed)	D	1.5D		
Insert Length Q (installed)	mm	4.500		
Insert Material		304 Stainless Steel		
Insert Coating/Plating		-		
Military Standard	#	MA3329-152		
National Aerospace 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-TB4			
Removal Tool	3500-RT2			
Machine Installation Tool	3520-3.00MIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3520-3.00HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB4			
Pneumatic Front end assembly (FEA)	3520-3.00MIP			
FEA Mandrel	3520-3.00MIPM			
FEA Nozzle	3520-3.00MIPN			
Pneumatic Tool	3500-MIP1			

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INSERT SPECIFICATIONS E Fitted Minor Diameter

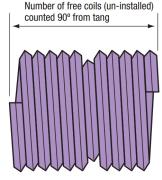
Q Nominal Length Installed

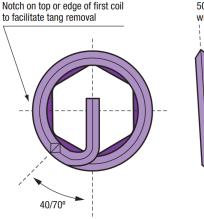
Free Coil Diameter minimum

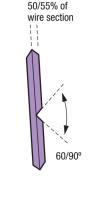
Free Coil Diameter maximum

Free Coils minimum

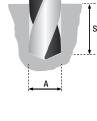
Free Coils maximum

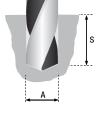


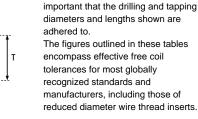




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	3.20		
Drill Part Number		2007-3.20		
Drill Size inch	inch	1/8		
Drill Part Number inch		2006-1/8		
A Minor Diameter minimum	mm	3.108		
A Minor Diameter maximum	mm	3.220		
S Drilling Depth minimum	mm	6.75		







TAPPED HOLE DIMENSIONS			
Tap Size	STI		M3 X 0.50
Tap Size	-		-
B Major Diameter		mm	3.650
C Pitch Diameter MIN		mm	3.325
C Pitch Diameter MAX	5H	mm	3.367
C Pitch Diameter MAX	6H	mm	3.384
T Tapping Depth MIN		mm	6.25
Power Coil Tap Part Number	STI	Taper	3520-3.00T
Power Coil Tap Part Number	STI	Intermediate	3520-3.00I
Power Coil Tap Part Number	STI	Bottoming	3520-3.00B
Power Coil Tap Part Number	STI	SpiralPoint	3520-3.00SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-3 00SF

mm

mm

mm

mm

#

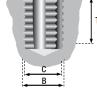
2.459

4.500

3.614

4.350 5.80

7.20



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

