

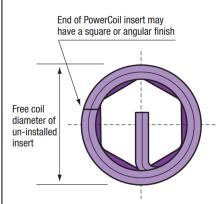
Insert Part Number		3532-4GX1.0DSLIR
Insert Thread Form		Unified National Coarse -
		UNC
Nominal Thread Size		4 X 40
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	inch	0.1120
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-C0410
National Aerospace Standard	#	NASM21209-C0410
Federal Stock	#	5340-631-7897
National Stock / NATO	#	5325-00-263-8728

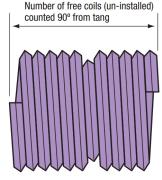
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

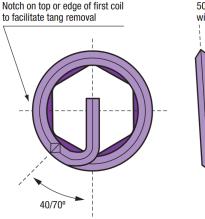
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB4
Removal Tool	3500-RT1
Machine Installation Tool	3532-4GMIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3532-4GHIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB3
Pneumatic Front end assembly (FEA)	3532-4GMIP
FEA Mandrel	3532-4GMIPM
FEA Nozzle	3532-4GMIPN
Pneumatic Tool	3500-MIP1

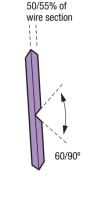
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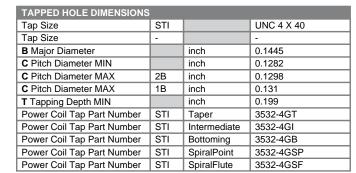


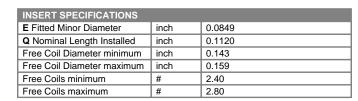


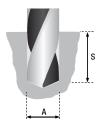


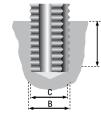


DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	3.00	
Drill Part Number		2007-3.00	
Drill Size inch	inch	#31	
Drill Part Number inch		2013-31	
A Minor Diameter minimum	inch	0.117	
A Minor Diameter maximum	inch	0.122	
S Drilling Depth minimum	inch	0.224	









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.

