

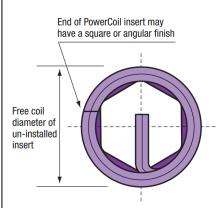
Insert Part Number		3534-1/4X2.0DSLIR
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		1/4 X 28
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	inch	0.5000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F4-20
National Aerospace Standard	#	NASM21209-F4-20
Federal Stock	#	5340-721-7498
National Stock / NATO	#	5325-00-721-7498

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-TB9
Removal Tool	3500-RT2
Machine Installation Tool	3534-1/4MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3534-1/4HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB8
Pneumatic Front end assembly (FEA)	3534-1/4MIP
FEA Mandrel	3534-1/4MIPM
FEA Nozzle	3534-1/4MIPN
Pneumatic Tool	3500-MIP1

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TAPPED HOLE DIMENSIONS

Tap Size

Tap Size

B Major Diameter

C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number

INSERT SPECIFICATIONS

E Fitted Minor Diameter

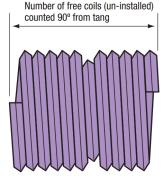
Q Nominal Length Installed

Free Coil Diameter minimum

Free Coil Diameter maximum

Free Coils minimum

Free Coils maximum



UNF 1/4 X 28

0.2964

0.2732

0.2754

0.277

0.625

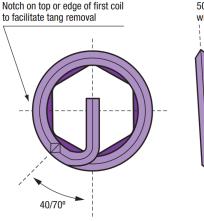
3534-1/4T

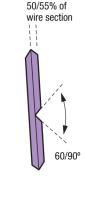
3534-1/41

3534-1/4B

3534-1/4SP

3534-1/4SF





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	6.60	
Drill Part Number		2007-6.60	
Drill Size inch	inch	17/64	
Drill Part Number inch		2006-17/64	
A Minor Diameter minimum	inch	0.258	
A Minor Diameter maximum	inch	0.265	
S Drilling Depth minimum	inch	0.661	

inch

inch

inch

inch

inch

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

0.2113

0.5000

0.299

0.326

10.80

11.90

STI

1B

STI

STI

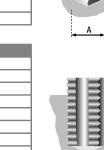
STI

inch

inch

inch

#



S

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.

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

shown are recommendations only and

PowerCoil would strongly suggest that

independent testing be performed for

When using wire thread inserts it is

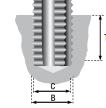
diameters and lengths shown are

important that the drilling and tapping

specific and critical applications.

is not possible to give specific drill

sizes for each material. Drill sizes



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

