

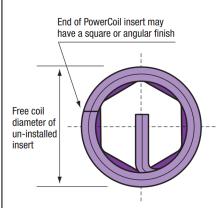
Insert Part Number		3534-4GX1.5DSLIR
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		4 X 48
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	inch	0.1680
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F0415
National Aerospace Standard	#	NASM21209-F0415
Federal Stock	#	-
National Stock / NATO	#	5325-01-008-7715

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	3534-4GMIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3534-4GHIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB3
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

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TAPPED HOLE DIMENSIONS

Tap Size

Tap Size

B Major Diameter

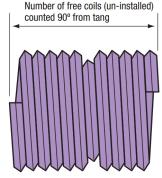
C Pitch Diameter MIN

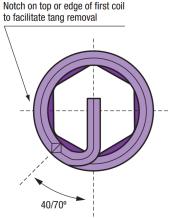
C Pitch Diameter MAX

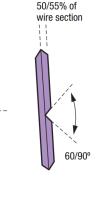
C Pitch Diameter MAX

T Tapping Depth MIN

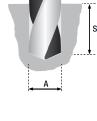
Power Coil Tap Part Number

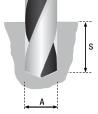


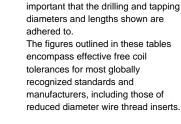


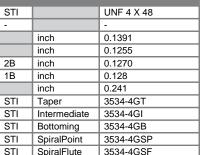


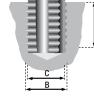
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	3.00	
Drill Part Number		2007-3.00	
Drill Size inch	inch	#31	
Drill Part Number inch		2013-31	
A Minor Diameter minimum	inch	0.117	
A Minor Diameter maximum	inch	0.121	
S Drilling Depth minimum	inch	0.262	











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,

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

specific and critical applications.

is not possible to give specific drill

sizes for each material. Drill sizes

