

Insert Part Number		3546-1/4X1.0D		
Insert Thread Form		British Standard Pipe - BSP		
Nominal Thread Size		1/4 X 19		
Insert Length Q (installed)	D	1.0D		
Insert Length Q (installed)	inch	0.250		
Insert Material		304 Stainless Steel		
Insert Coating/Plating		-		
Military Standard	#			
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	3500-HIT16			
Tang Break Tool	-			
Removal Tool	3500-RT3			
Machine Installation Tool	-			
Mandrel Installation Tool	-			
Captive Prewinder Tool	-			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	-			
Pneumatic Front end assembly (FEA)	-			
FEA Mandrel	-			
FEA Nozzle	-			
Pneumatic Tool	-			

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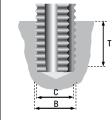
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DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	13.60			
Drill Part Number		-			
Drill Size inch	inch	17/32			
Drill Part Number inch		2651-17/32			
A Minor Diameter inimum	inch	0.530			
A Minor Diameter maximum	inch	0.540			
S Drilling Depth minimum	inch	0.487			

TAPPED HOLE DIMENSIONS						
Tap Size	STI			BSP 1/4 X 19		
Tap Size	-			-		
B Major Diameter		inch		0.580		
C Pitch Diameter MIN		inch		0.5517		
C Pitch Diameter MAX	Clos	inch		0.5539		
	е					
C Pitch Diameter MAX	Medi	inch		0.5556		
	um					
T Tapping Depth MIN		inc	h	0.434		
Power Coil Tap Part Number	STI	Ta	per	3546-1/4T		
Power Coil Tap Part Number	STI	Inte	ermediate	3546-1/4		
Power Coil Tap Part Number	STI	Bottoming		3546-1/4B		
Power Coil Tap Part Number	STI	SpiralPoint		-		
Power Coil Tap Part Number	STI	SpiralFlute		-		
E Fitted Minor Diameter	inch		0.4506			
Q Nominal Length Installed	inch		0.250			
Free Coil Diameter minimum	inch		0.59			
Free Coil Diameter maximum	inch		0.64			
Free Coils minimum	#		2.80			
Free Coils maximum	#		3.10			





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.

