

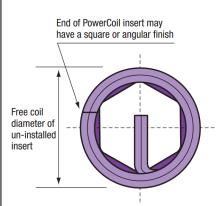
Insert Part Number		3532-1.1/4X2.5DSL
Insert Thread Form		Unified National Coarse -
		UNC
Nominal Thread Size		1-1/4 X 7
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	inch	3.1250
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-C2025
National Aerospace Standard	#	NASM21209-C2025
Federal Stock	#	-
National Stock / NATO	#	-

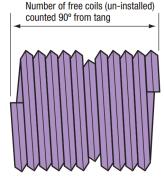
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

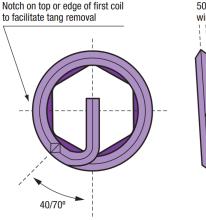
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS		
TOOL TYPE	Part #	
Hand Installation Tool	-	
Tang Break Tool	-	
Removal Tool	3500-RT4	
Machine Installation Tool	-	
Mandrel Installation Tool	-	
Captive Prewinder Tool	-	
Non-Captive Prewinder Tool	-	
Spring Loaded tang Break Tool	-	
Pneumatic Front end assembly (FEA)	-	
FEA Mandrel	-	
FEA Nozzle	-	
Pneumatic Tool	-	

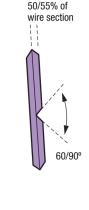
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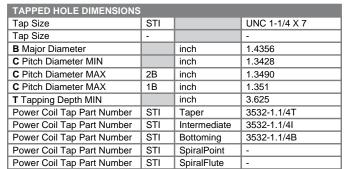




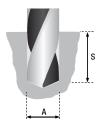


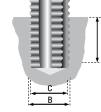


DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	32.50		
Drill Part Number		2608-32.50		
Drill Size inch	inch	1.9/32		
Drill Part Number inch		-		
A Minor Diameter inimum	inch	1.281		
A Minor Diameter maximum	inch	1.296		
S Drilling Depth minimum	inch	3.768		



INSERT SPECIFICATIONS				
E Fitted Minor Diameter	inch	1.0954		
Q Nominal Length Installed	inch	3.1250		
Free Coil Diameter minimum	inch	1.421		
Free Coil Diameter maximum	inch	1.483		
Free Coils minimum	#	19.20		
Free Coils maximum	#	20.10		





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.

