

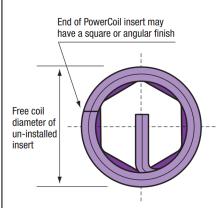
Insert Part Number		3534-1/4X1.0DSL
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		1/4 X 28
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	inch	0.2500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F4-10
National Aerospace Standard	#	NASM21209-F4-10
Federal Stock	#	5340-805-9658
National Stock / NATO	#	5325-00-210-3920

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

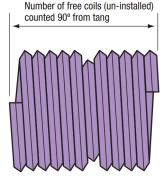
C Pitch Diameter MIN

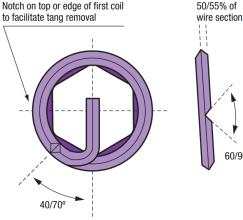
C Pitch Diameter MAX

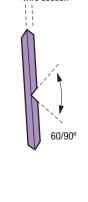
C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number







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 inimum	inch	0.258	
A Minor Diameter maximum	inch	0.265	
S Drilling Depth minimum	inch	0.411	

inch

inch

inch

inch

inch

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

STI

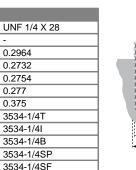
1B

STI

STI

STI





0.2964

0.2732

0.2754

0.277

0.375

3534-1/4T

3534-1/41

3534-1/4B

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.

