

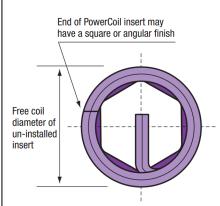
Insert Part Number		3532-1/2X2.5DSL
Insert Thread Form	Unified National Coarse -	
		UNC
Nominal Thread Size		1/2 X 13
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	inch	1.2500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-C8-25
National Aerospace Standard	#	NASM21209-C8-25
Federal Stock	#	-
National Stock / NATO	#	-

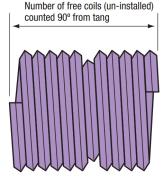
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

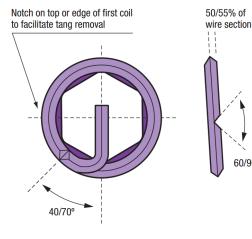
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS			
TOOL TYPE	Part #		
Hand Installation Tool	-		
Tang Break Tool	3500-TB15		
Removal Tool	3500-RT3		
Machine Installation Tool	3532-1/2MIT		
Mandrel Installation Tool	-		
Captive Prewinder Tool	3532-1/2HIP		
Non-Captive Prewinder Tool	-		
Spring Loaded tang Break Tool	3500-STB12		
Pneumatic Front end assembly (FEA)	-		
FEA Mandrel	-		
FEA Nozzle	-		
Pneumatic Tool	-		

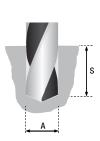
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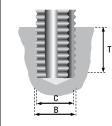
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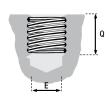




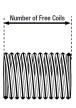
IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and PowerCoil would 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.







DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	13.00		
Drill Part Number		2007-13.00		
Drill Size inch	inch	33/64		
Drill Part Number inch		-		
A Minor Diameter inimum	inch	0.517		
A Minor Diameter maximum	inch	0.528		
S Drilling Depth minimum	inch	1.596		

TAPPED HOLE DIMENSIONS				
STI		UNC 1/2 X 13		
-		-		
	inch	0.5999		
	inch	0.5499		
2B	inch	0.5537		
1B	inch	0.555		
	inch	1.519		
STI	Taper	3532-1/2T		
STI	Intermediate	3532-1/21		
STI	Bottoming	3532-1/2B		
STI	SpiralPoint	3532-1/2SP		
STI	SpiralFlute	3532-1/2SF		
	STI - 2B 1B STI STI STI STI	STI - inch inch 2B inch 1B inch inch STI Taper STI Intermediate STI Bottoming STI SpiralPoint		

INSERT SPECIFICATIONS		
E Fitted Minor Diameter	inch	0.4167
Q Nominal Length Installed	inch	1.2500
Free Coil Diameter minimum	inch	0.594
Free Coil Diameter maximum	inch	0.622
Free Coils minimum	#	13.60
Free Coils maximum	#	14.30