powercoil®

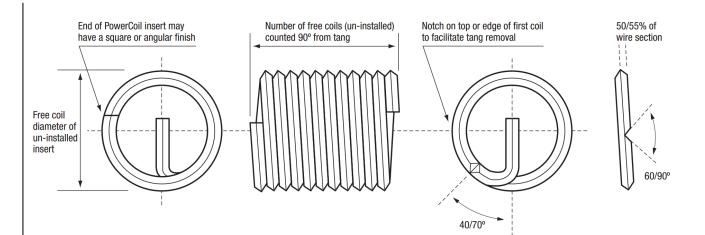
Insert Part Number		3552-1/8X.273
Insert Thread Form		NPT
Nominal Thread Size		1/8 X 27
Insert Length Q (installed)	D	0.273 inch
Insert Length Q (installed)	inch	0.273
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	
National Aerospace Standard	#	
Federal Stock	#	
National 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				
Part #				
3500-HIT13				
-				
-				
-				
-				
-				
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-				
-				
-				
-				



PowerCoil is a registered trademark of Bordo International Pty Ltd Australia

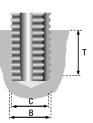


DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	-]	
Drill Part Number		-		
Drill Size inch	inch	W		
Drill Part Number inch		-]	
A Minor Diameter inimum	inch	0.3963		
A Minor Diameter maximum	inch	0.4047		
S Drilling Depth minimum	inch	0.592	1	

STI		NPT 1/8 X 27
3B		-
	inch	0.459
	inch	-
3B	inch	-
-	inch	-
	inch	0.519
STI	Taper	3552-1/8T
STI	Intermediate	3552-1/81
STI	Bottoming	3552-1/8B
STI	SpiralPoint	-
STI	SpiralFlute	
	3B 3B - STI STI STI STI	3B inch inch 3B inch - inch 5TI Taper STI Intermediate STI Bottoming STI SpiralPoint

INSERT SPECIFICATIONS				
E Fitted Minor Diameter	inch			
Q Nominal Length Installed	inch	0.273		
Free Coil Diameter minimum	inch	0.486		
Free Coil Diameter maximum	inch	0.511		
Free Coils minimum	#	5-1/8		
Free Coils maximum	#			

s



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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.

