

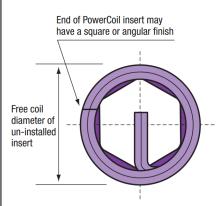
Insert Part Number		3534-7/8X2.0DSL
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		7/8 X 14
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	inch	1.7500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F1420
National Aerospace Standard	#	NASM21209-F1420
Federal Stock	#	5340-721-5110
National Stock / NATO	#	5325-01-014-4621

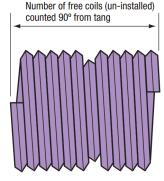
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

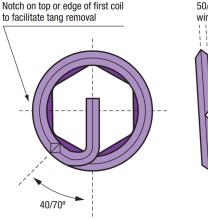
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	-
Removal Tool	3500-RT3
Machine Installation Tool	-
Mandrel Installation Tool	-
Captive Prewinder Tool	-
Non-Captive Prewinder Tool	3534-7/8HIP
Spring Loaded tang Break Tool	-
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

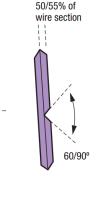
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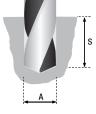


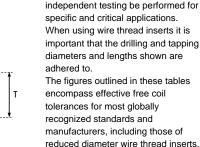


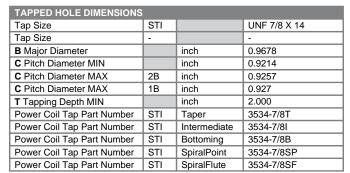


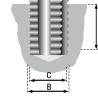
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	22.50		
Drill Part Number		2654-22.50		
Drill Size inch	inch	57/64		
Drill Part Number inch		2651-57/64		
A Minor Diameter inimum	inch	0.891		
A Minor Diameter maximum	inch	0.899		
S Drilling Depth minimum	inch	2.071		

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Number of Free Coils – the number of coils on an un-installed insert counted along the insert length 90° from the tang.

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

shown are recommendations only and

PowerCoil would strongly suggest that

is not possible to give specific drill

sizes for each material. Drill sizes

