

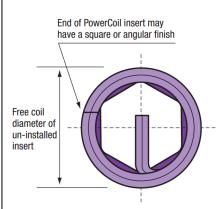
Insert Part Number		3534-7/8X1.0DSL	
Insert Thread Form		Unified National Fine - UNF	
Nominal Thread Size		7/8 X 14	
Insert Length Q (installed)	D	1.0D	
Insert Length Q (installed)	inch	0.8750	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MS21209-F1410	
National Aerospace Standard	#	NASM21209-F1410	
Federal Stock	#	5340-985-6568	
National Stock / NATO	#	5325-00-985-6568	

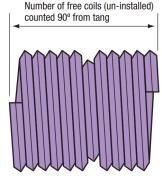
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

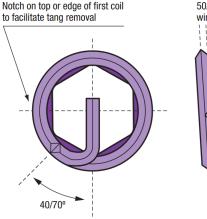
COMPATIBLE POWERCOIL INSTALLATION	AND REMOVAL TOOLS	
TOOL TYPE	Part #	
Hand Installation Tool	-	
Tang Break Tool	-	
Removal Tool	3500-RT3	
Machine Installation Tool	-	
Mandrel Installation Tool	-	
Captive Prewinder Tool	-	
Non-Captive Prewinder Tool	3534-7/8HIP	
Spring Loaded tang Break Tool	-	
Pneumatic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

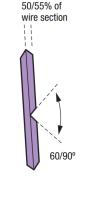
## powercoil.com.au

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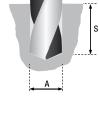


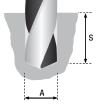


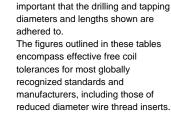




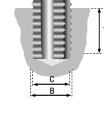
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	22.50			
Drill Part Number		2654-22.50			
Drill Size inch	inch	57/64			
Drill Part Number inch		2651-57/64			
A Minor Diameter inimum	inch	0.891			
A Minor Diameter maximum	inch	0.899			
S Drilling Depth minimum	inch	1.196			







TAPPED HOLE DIMENSIONS			
Tap Size	STI		UNF 7/8 X 14
Tap Size	-		-
B Major Diameter		inch	0.9678
C Pitch Diameter MIN		inch	0.9214
C Pitch Diameter MAX	2B	inch	0.9257
C Pitch Diameter MAX	1B	inch	0.927
T Tapping Depth MIN		inch	1.125
Power Coil Tap Part Number	STI	Taper	3534-7/8T
Power Coil Tap Part Number	STI	Intermediate	3534-7/8I
Power Coil Tap Part Number	STI	Bottoming	3534-7/8B
Power Coil Tap Part Number	STI	SpiralPoint	3534-7/8SP
Power Coil Tap Part Number	STI	SpiralFlute	3534-7/8SF



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,

is not possible to give specific drill

sizes for each material. Drill sizes

coolant, equipment being used - and it

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

