

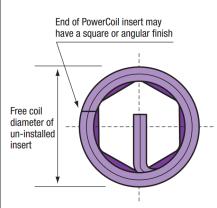
Insert Part Number		3521-12.00X3.0DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M12 X 1.50
Insert Length Q (installed)	D	3.0D
Insert Length Q (installed)	mm	36.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-313
National Aerospace Standard	#	
Federal 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
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB15
Removal Tool	3500-RT3
Machine Installation Tool	3521-12.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3521-12.00HIP
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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**TAPPED HOLE DIMENSIONS** 

Tap Size

Tap Size

**B** Major Diameter

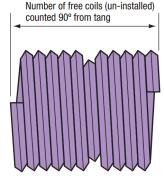
C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number



M12 X 1.50

13.949

12.974

13.067

13.099

3521-12.00T

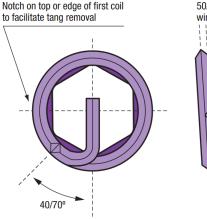
3521-12.00B

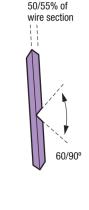
3521-12.00SP

3521-12.00SF

3521-12.001

41.25





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	12.40	
Drill Part Number		2007-12.40	
Drill Size inch	inch	31/64	
Drill Part Number inch		2006-31/64	
A Minor Diameter inimum	mm	12.325	
A Minor Diameter maximum	mm	12.561	
S Drilling Depth minimum	mm	42.75	

STI

6H

STI

STI

STI

mm

mm

mm

mm

mm

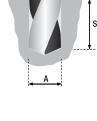
Taper

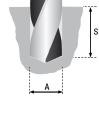
Intermediate

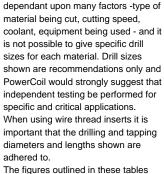
**Bottoming** 

SpiralPoint

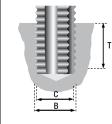
SpiralFlute







**IMPORTANT** The success of any drilling and tapping operation is



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.

