

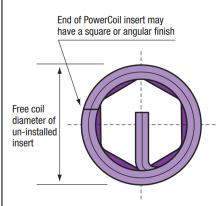
Insert Part Number		3534-6GX1.0DSL
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		6 X 40
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	inch	0.1380
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F0610
National Aerospace Standard	#	NASM21209-F0610
Federal Stock	#	5340-754-1207
National Stock / NATO	#	5325-00-288-1921

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-TB5
Removal Tool	3500-RT1
Machine Installation Tool	3534-6GMIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3534-6GHIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB4
Pneumatic Front end assembly (FEA)	3534-6GMIP
FEA Mandrel	3534-6GMIPM
FEA Nozzle	3534-6GMIPN
Pneumatic Tool	3500-MIP1

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TAPPED HOLE DIMENSIONS

Tap Size

Tap Size

B Major Diameter

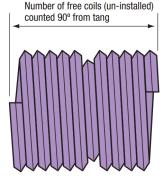
C Pitch Diameter MIN

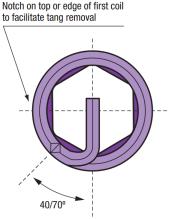
C Pitch Diameter MAX

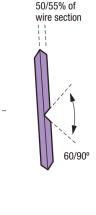
C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number

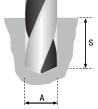


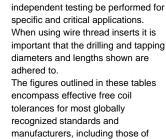




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	3.70	
Drill Part Number		2007-3.70	
Drill Size inch	inch	#26	
Drill Part Number inch		2013-26	
A Minor Diameter inimum	inch	0.143	
A Minor Diameter maximum	inch	0.148	
S Drilling Depth minimum	inch	0.250	







IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed,

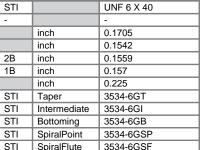
coolant, equipment being used - and it

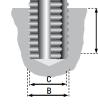
shown are recommendations only and

PowerCoil would strongly suggest that

is not possible to give specific drill

sizes for each material. Drill sizes





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

reduced diameter wire thread inserts.

