

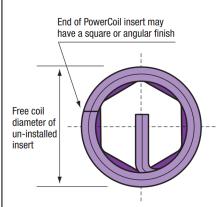
Insert Part Number		3521-8.00X1.0DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M8 X 1.00
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	mm	8.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-108
National Aerospace Standard	#	
Federal 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-TB12
Removal Tool	3500-RT2
Machine Installation Tool	3521-8.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3521-8.00HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB9
Pneumatic Front end assembly (FEA)	3521-8.00MIP
FEA Mandrel	3521-8.00MIPM
FEA Nozzle	3521-8.00MIPN
Pneumatic Tool	3500-MIP2

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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

INSERT SPECIFICATIONS E Fitted Minor Diameter

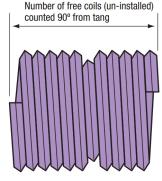
Q Nominal Length Installed

Free Coil Diameter minimum

Free Coil Diameter maximum

Free Coils minimum

Free Coils maximum



M8 X 1.00

9.299

8.650

8.719

8.742

11.50

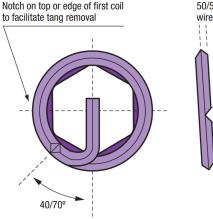
3521-8.00T

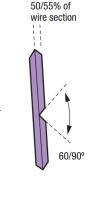
3521-8.00B

3521-8.00SP

3521-8.00SF

3521-8.00I





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	8.30	
Drill Part Number		2007-8.30	
Drill Size inch	inch	21/64	
Drill Part Number inch		2006-21/64	
A Minor Diameter inimum	mm	8.406	
A Minor Diameter maximum	mm	8.216	
S Drilling Depth minimum	mm	12.50	

STI

6H

STI

STI

STI

STI

mm

mm

mm

mm

#

mm

mm

mm

mm

mm

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

6.917

8.000

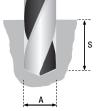
11.412

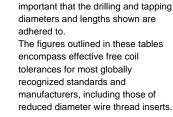
12.500

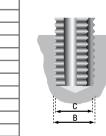
5.60

6.10









reduced diameter wire thread inserts. Number of Free Coils – the number of coils on an un-installed insert counted along the insert length 90°

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

independent testing be performed for

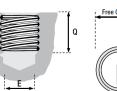
When using wire thread inserts it is

specific and critical applications.

is not possible to give specific drill

sizes for each material. Drill sizes







from the tang.

