

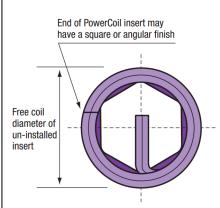
Insert Part Number		3521-18.00X2.5DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M18 X 2.0
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	mm	45.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-270
National Aerospace Standard	#	
Federal 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	-
Removal Tool	3500-RT3
Machine Installation Tool	-
Mandrel Installation Tool	-
Captive Prewinder Tool	-
Non-Captive Prewinder Tool	3521-18.00HIP
Spring Loaded tang Break Tool	-
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

**INSERT SPECIFICATIONS** E Fitted Minor Diameter

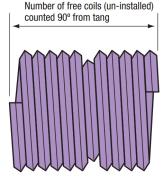
Q Nominal Length Installed

Free Coil Diameter minimum

Free Coil Diameter maximum

Free Coils minimum

Free Coils maximum



M18 X 2.00

20.598

19.299

19.406

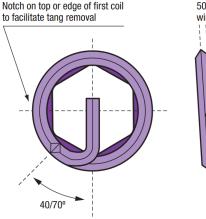
19.444

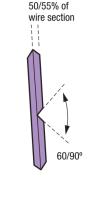
52.00

3521-18.00T

3521-18.00B

3521-18.001





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	18.50	
Drill Part Number		2654-18.50	
Drill Size inch	inch	23/32	
Drill Part Number inch		2651-23/32	
A Minor Diameter inimum	mm	18.433	
A Minor Diameter maximum	mm	18.733	
S Drilling Depth minimum	mm	54.00	

mm

mm

mm

mm

mm

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

15.835

45.000

21.150

21.850

19.10

20.20

STI

6H

STI

STI

STI

STI

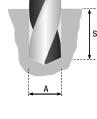
mm

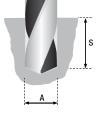
mm

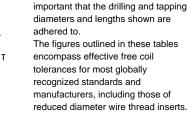
mm

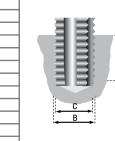
mm

#









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

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

