

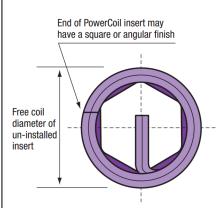
Insert Part Number		3521-22.00X1.5DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M22 X 2.0
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	mm	33.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-176
National Aerospace Standard	#	
Federal 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	-
Spring Loaded tang Break Tool	-
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

powercoil.com.au

PowerCoil is a registered trademark of Bordo International Ptv Ltd Australia



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

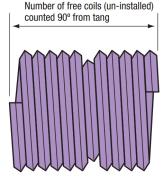
Q Nominal Length Installed

Free Coil Diameter minimum

Free Coil Diameter maximum

Free Coils minimum

Free Coils maximum



M22 X 2.00

24.598

23.299

23.406

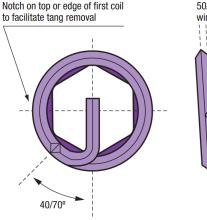
23.444

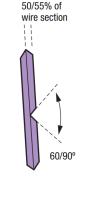
40.00

3521-22.00T

3521-22.00B

3521-22.001





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	mm	22.433	
A Minor Diameter maximum	mm	22.733	
S Drilling Depth minimum	mm	42.00	

STI

6H

STI

STI

STI

STI

mm

mm

mm

mm

#

mm

mm

mm

mm

mm

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

19.835

33.000

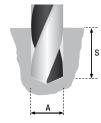
25.600

26.500

13.40

14.40





diameters and lengths shown are adhered to.

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.

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

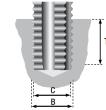
When using wire thread inserts it is

important that the drilling and tapping

specific and critical applications.

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.

