

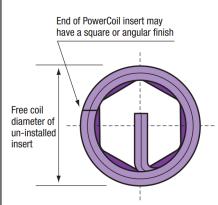
Insert Part Number		3520-14.00X1.0DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M14 X 2.0
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	mm	14.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-116
National Aerospace Standard	#	
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	3520-14.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-14.00HIP
Non-Captive Prewinder Tool	-
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

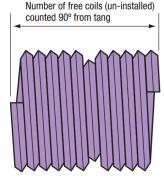
C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number



M14 X 2.00

16.598

15.299

15.406

15.444

21.00

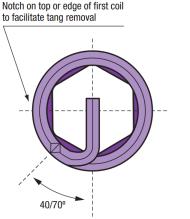
3520-14.00T

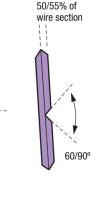
3520-14.00B

3520-14.00SP

3520-14.00SF

3520-14.001





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	14.50		
Drill Part Number		2654-14.50		
Drill Size inch	inch	37/64		
Drill Part Number inch		2651-37/64		
A Minor Diameter inimum	mm	14.433		
A Minor Diameter maximum	mm	14.733		
S Drilling Depth minimum	mm	23.00		

mm

mm

mm

mm

mm

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

STI

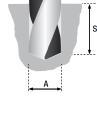
6H

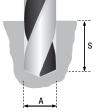
STI

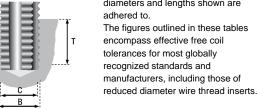
STI

STI

STI







PowerCoil would strongly suggest that independent testing be performed for specific and critical applications. When using wire thread inserts it is important that the drilling and tapping 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

**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

is not possible to give specific drill

sizes for each material. Drill sizes





INSERT SPECIFICATIONS				
mm	11.835			
mm	14.000			
mm	16.432			
mm	17.350			
#	5.00			
#	5.30			
	mm mm mm			

