

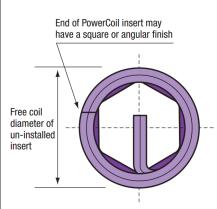
Insert Part Number		3520-18.00X1.5DSL		
Insert Thread Form		Metric Coarse		
Nominal Thread Size		M18 X 2.5		
Insert Length Q (installed)	D	1.5D		
Insert Length Q (installed)	mm	27.000		
Insert Material		304 Stainless Steel		
Insert Coating/Plating		-		
Military Standard	#	MA3329-171		
National Aerospace Standard	#			
Federal Stock	#	-		
National Stock / NATO	#	-		

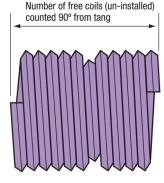
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate 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.

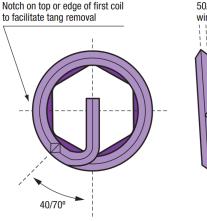
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	-			
Removal Tool	3500-RT3			
Machine Installation Tool	-			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3520-18.00HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	-			
Pneumatic Front end assembly (FEA)	-			
FEA Mandrel	-			
FEA Nozzle	-			
Pneumatic Tool	-			

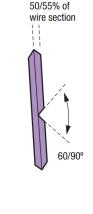
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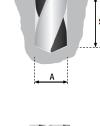


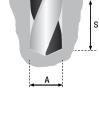


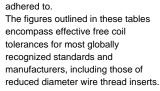




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	18.80			
Drill Part Number		-			
Drill Size inch	inch	47/64			
Drill Part Number inch		2651-47/64			
A Minor Diameter inimum	mm	18.541			
A Minor Diameter maximum	mm	18.896			
S Drilling Depth minimum	mm	38.25			







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

is not possible to give specific drill

sizes for each material. Drill sizes

coolant, equipment being used - and it

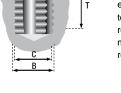
shown are recommendations only and

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

TAPPED HOLE DIMENSIONS					
Tap Size	STI		M18 X 2.50		
Tap Size	-		-		
B Major Diameter		mm	21.248		
C Pitch Diameter MIN		mm	19.624		
C Pitch Diameter MAX	5H	mm	19.738		
C Pitch Diameter MAX	6H	mm	19.778		
T Tapping Depth MIN		mm	35.75		
Power Coil Tap Part Number	STI	Taper	3520-18.00T		
Power Coil Tap Part Number	STI	Intermediate	3520-18.00I		
Power Coil Tap Part Number	STI	Bottoming	3520-18.00B		
Power Coil Tap Part Number	STI	SpiralPoint	3520-18.00SP		
Power Coil Tap Part Number	STI	SpiralFlute	3520-18.00SF		



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

