

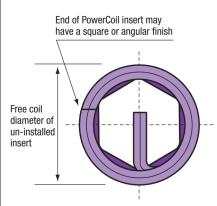
Insert Part Number		3520-2.50X2.5DSL		
Insert Thread Form		Metric Coarse		
Nominal Thread Size		M2.5 X 0.45		
Insert Length Q (installed)	D	2.5D		
Insert Length Q (installed)	mm	6.250		
Insert Material		304 Stainless Steel		
Insert Coating/Plating		-		
Military Standard	#	MA3329-251		
National Aerospace Standard	#			
Federal Stock	#	-		
National Stock / NATO	#	-		

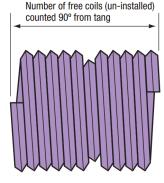
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

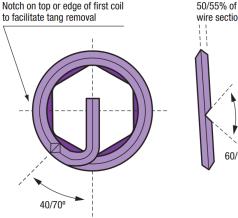
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	3500-TB3			
Removal Tool	3500-RT1			
Machine Installation Tool	3520-2.50MIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3520-2.50HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB2			
Pneumatic Front end assembly (FEA)	-			
FEA Mandrel	-			
FEA Nozzle	-			
Pneumatic Tool	-			

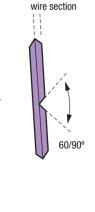
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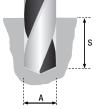


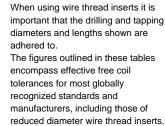




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
mm	2.60			
	2007-2.60			
inch	#37			
	2013-37			
mm	2.597			
mm	2.697			
mm	8.28			
	inch mm mm			







**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

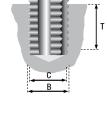
shown are recommendations only and

PowerCoil would strongly suggest that

independent testing be performed for

specific and critical applications.

TAPPED HOLE DIMENSIONS	;		
Tap Size	STI		M2.5 X 0.45
Tap Size	-		-
B Major Diameter		mm	3.085
C Pitch Diameter MIN		mm	2.792
C Pitch Diameter MAX	5H	mm	2.832
C Pitch Diameter MAX	6H	mm	2.847
T Tapping Depth MIN		mm	7.83
Power Coil Tap Part Number	STI	Taper	3520-2.50T
Power Coil Tap Part Number	STI	Intermediate	3520-2.501
Power Coil Tap Part Number	STI	Bottoming	3520-2.50B
Power Coil Tap Part Number	STI	SpiralPoint	3520-2.50SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-2.50SF



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

