

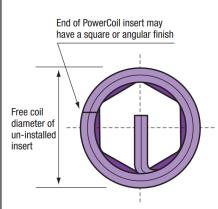
Insert Part Number		3520-4.00X3.0DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M4 X .7
Insert Length Q (installed)	D	3.0D
Insert Length Q (installed)	mm	12.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-304
National Aerospace Standard	#	
Federal 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-TB6
Removal Tool	3500-RT2
Machine Installation Tool	3520-4.00MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-4.00HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB5
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

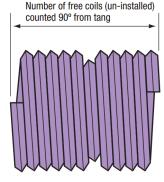
C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number



M4 X 0.70

4.909

4.455

4.509

4.529

14.45

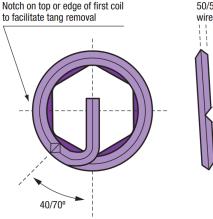
3520-4.00T

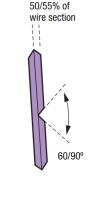
3520-4.00B

3520-4.00SP

3520-4.00SF

3520-4.001





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	4.20	
Drill Part Number		2007-4.20	
Drill Size inch	inch	11/64	
Drill Part Number inch		2006-11/64	
A Minor Diameter inimum	mm	4.152	
A Minor Diameter maximum	mm	4.292	
S Drilling Depth minimum	mm	15.15	

mm

mm

mm

mm

mm

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

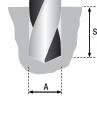
STI

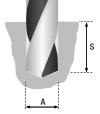
6H

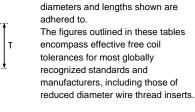
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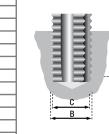
STI

STI









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

important that the drilling and tapping

specific and critical applications.

is not possible to give specific drill

sizes for each material. Drill sizes

