

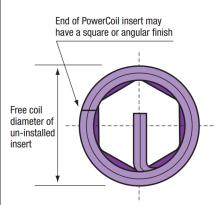
Insert Part Number		3523-20.00X2.0DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M20 X 1.50
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	mm	40.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-222
National Aerospace Standard	#	
Federal Stock	#	-
National Stock / NATO	#	-

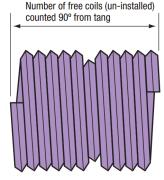
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate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

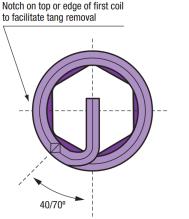
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS		
TOOL TYPE	Part #	
Hand Installation Tool	-	
Tang Break Tool	-	
Removal Tool	3500-RT3	
Machine Installation Tool	-	
Mandrel Installation Tool	-	
Captive Prewinder Tool	-	
Non-Captive Prewinder Tool	3523-20.00HIP	
Spring Loaded tang Break Tool	-	
Pneumatic Front end assembly (FEA)	-	
FEA Mandrel	-	
FEA Nozzle	-	
Pneumatic Tool	-	

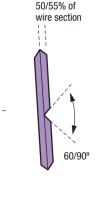
## powercoil.com.au

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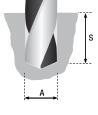


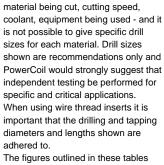




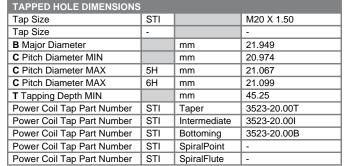
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	20.50		
Drill Part Number		2654-20.50		
Drill Size inch	inch	13/16		
Drill Part Number inch		2651-13/16		
A Minor Diameter inimum	mm	20.325		
A Minor Diameter maximum	mm	20.561		
S Drilling Depth minimum	mm	46.75		

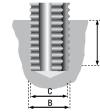






**IMPORTANT** The success of any drilling and tapping operation is dependant upon many factors -type of





encompass effective free coil tolerances for most globally recognized standards and manufacturers, including those of reduced diameter wire thread inserts.

Number of Free Coils – the number

INSERT SPECIFICATIONS				
E Fitted Minor Diameter	mm	18.376		
Q Nominal Length Installed	mm	40.000		
Free Coil Diameter minimum	mm	23.150		
Free Coil Diameter maximum	mm	24.000		
Free Coils minimum	#	22.40		
Free Coils maximum	#	24.40		



