

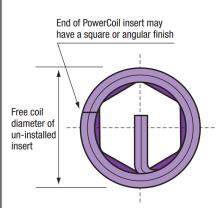
Insert Part Number		3532-12GX2.0DSL	
Insert Thread Form		Unified National Coarse -	
		UNC	
Nominal Thread Size		12 X 24	
Insert Length Q (installed)	D	2.0D	
Insert Length Q (installed)	inch	0.4320	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MS21209-C2-20	
National Aerospace Standard	#	NASM21209-C2-20	
Federal Stock	#	5340-863-8113	
National Stock / NATO	#	5325-00-863-8113	

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-TB8			
Removal Tool	3500-RT2			
Machine Installation Tool	3532-12GMIT			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3532-12GHIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	3500-STB7			
Pneumatic Front end assembly (FEA)	3532-12GMIP			
FEA Mandrel	3532-12GMIPM			
FEA Nozzle	3532-12GMIPN			
Pneumatic Tool	3500-MIP1			

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TAPPED HOLE DIMENSIONS

Tap Size

Tap Size

B Major Diameter

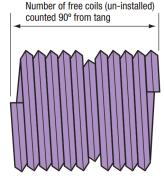
C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number



UNC 12 X 24

0.2701

0.2431

0.2454

0.247

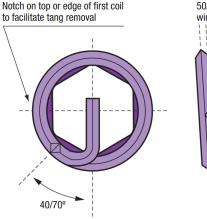
0.578

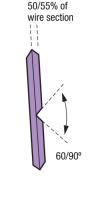
3532-12GT

3532-12GB

3532-12GSP

3532-12GI





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	5.70			
Drill Part Number		2007-5.70			
Drill Size inch	inch	15/64			
Drill Part Number inch		2006-15/64			
A Minor Diameter inimum	inch	0.225			
A Minor Diameter maximum	inch	0.231			
S Drilling Depth minimum	inch	0.619			

inch

inch

inch

inch

inch

Taper

Intermediate

Bottoming

SpiralPoint

STI

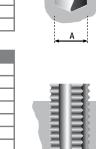
2B

1B

STI

STI

STI



drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes 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

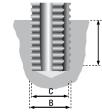
The figures outlined in these tables encompass effective free coil tolerances for most globally recognized standards and manufacturers, including those of reduced diameter wire thread inserts.

important that the drilling and tapping

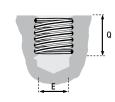
diameters and lengths shown are

adhered to.

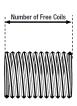
IMPORTANT The success of any



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







Power Coil Tap Part Number	STI	SpiralFlute	3532-12GSF
INSERT SPECIFICATIONS			
E Fitted Minor Diameter	inch	0.1710	
Q Nominal Length Installed	inch	0.4320	
Free Coil Diameter minimum	inch	0.267	
Free Coil Diameter maximum	inch	0.283	
Free Coils minimum	#	7.90	
Free Coils maximum	#	8.50	