



Insert Part Number		3523-22.00X2.0D-MA
Insert Thread Form		Metric Fine
Nominal Thread Size		M22 X 1.50
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	mm	44.00
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3279-225
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	-
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	22.50
Drill Part Number		2654-22.50
Drill Size inch	inch	57/64
Drill Part Number inch		2651-57/64
A Minor Diameter inimum	mm	22.325
A Minor Diameter maximum	mm	22.561
S Drilling Depth minimum	mm	50.75

TAPPED HOLE DIMENSIONS

Tap Size	STI		M22 X 1.50
Tap Size	-		-
B Major Diameter		mm	23.949
C Pitch Diameter MIN		mm	22.974
C Pitch Diameter MAX	5H	mm	23.067
C Pitch Diameter MAX	6H	mm	23.099
T Tapping Depth MIN		mm	49.25
Power Coil Tap Part Number	STI	Taper	3523-22.00T
Power Coil Tap Part Number	STI	Intermediate	3523-22.00I
Power Coil Tap Part Number	STI	Bottoming	3523-22.00B
Power Coil Tap Part Number	STI	SpiralPoint	-
Power Coil Tap Part Number	STI	SpiralFlute	-

INSERT SPECIFICATIONS

E Fitted Minor Diameter	mm	20.376
Q Nominal Length Installed	mm	44.00
Free Coil Diameter minimum	mm	25.55
Free Coil Diameter maximum	mm	26.45
Free Coils minimum	#	24.60
Free Coils maximum	#	27.00

