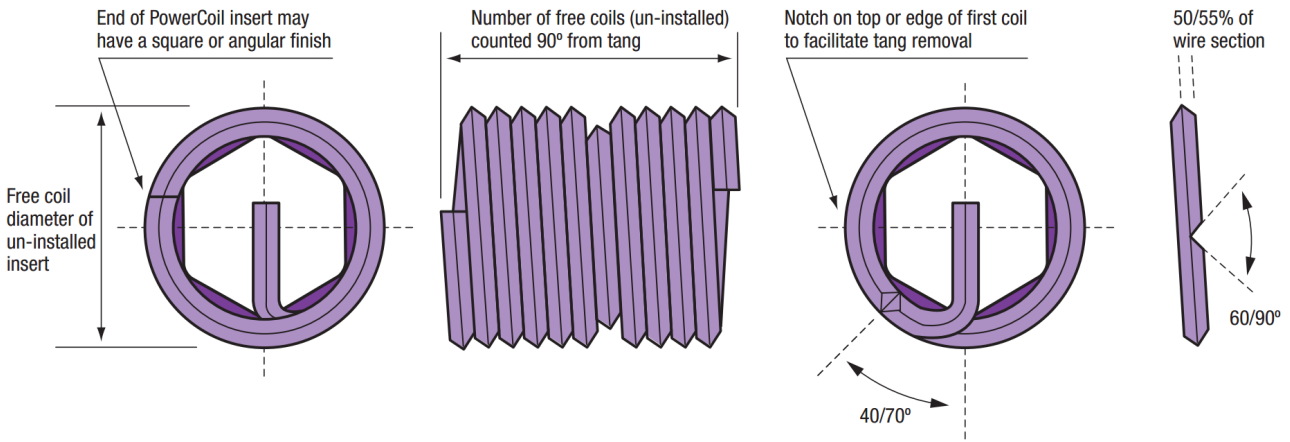
Insert Part Number		3534-4GX2.5DSL
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		4 X 48
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	inch	0.2800
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F0425
National Aerospace Standard	#	NASM21209-F0425
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.

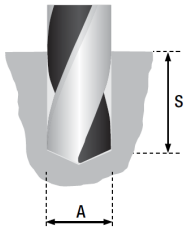
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS	
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB4
Removal Tool	3500-RT1
Machine Installation Tool	3534-4GMIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3534-4GHIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB3
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

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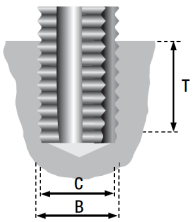
PowerCoil is a registered trademark of Bordo International Pty Ltd Australia



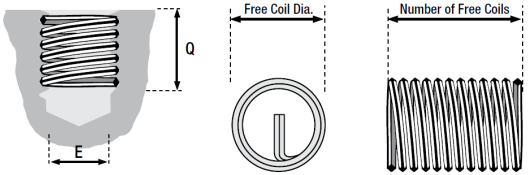
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP		
Drill Size	mm	3.00
Drill Part Number		2007-3.00
Drill Size inch	inch	#31
Drill Part Number inch		2013-31
A Minor Diameter inimum	inch	0.117
A Minor Diameter maximum	inch	0.121
S Drilling Depth minimum	inch	0.374



TAPPED HOLE DIMENSIONS			
Tap Size	STI		UNF 4 X 48
Tap Size	-		-
B Major Diameter		inch	0.1391
C Pitch Diameter MIN		inch	0.1255
C Pitch Diameter MAX	2B	inch	0.1270
C Pitch Diameter MAX	1B	inch	0.128
T Tapping Depth MIN		inch	0.353
Power Coil Tap Part Number	STI	Taper	3534-4GT
Power Coil Tap Part Number	STI	Intermediate	3534-4GI
Power Coil Tap Part Number	STI	Bottoming	3534-4GB
Power Coil Tap Part Number	STI	SpiralPoint	3534-4GSP
Power Coil Tap Part Number	STI	SpiralFlute	3534-4GSF



INSERT SPECIFICATIONS		
E Fitted Minor Diameter	inch	0.0894
Q Nominal Length Installed	inch	0.2800
Free Coil Diameter minimum	inch	0.140
Free Coil Diameter maximum	inch	0.162
Free Coils minimum	#	9.80
Free Coils maximum	#	11.60



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 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 important that the drilling and tapping diameters and lengths shown are adhered to.
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.

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