powercoil®

Insert Part Number		3530-9/16X1.0DP
Insert Thread Form		British Standard Fine - BSF
Nominal Thread Size		9/16 X 16
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	inch	0.562
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	
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	3500-HIT16
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	-

powercoil.com.au

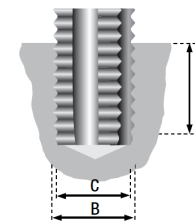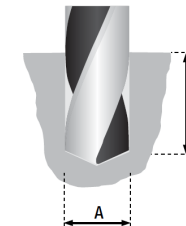PowerCoil is a registered trademark of Bordo International Pty Ltd Australia

End of PowerCoil insert may have a square or angular finish

Free coil diameter of un-installed insert

Number of free coils (un-installed) counted 90º from tang

Notch on top or edge of first coil to facilitate tang removal

50/55% of wire section

60/90º

40/70º

DRILLED HOLE DIMENSIONS	INTERMEDIATE/PLUG TAP	
Drill Size	mm	14.80
Drill Part Number		-
Drill Size inch	inch	37/64
Drill Part Number inch		2651-37/64
A Minor Diameter inimum	inch	0.577
A Minor Diameter maximum	inch	0.586
S Drilling Depth minimum	inch	0.844

TAPPED HOLE DIMENSIONS			
Tap Size	STI		BSF 9/16 X 16
Tap Size	-		-
B Major Diameter		inch	0.636
C Pitch Diameter MIN		inch	0.6025
C Pitch Diameter MAX	Close	inch	0.6049
C Pitch Diameter MAX	Medium	inch	0.6067
T Tapping Depth MIN		inch	0.781
Power Coil Tap Part Number	STI	Taper	3530-9/16T
Power Coil Tap Part Number	STI	Intermediate	3530-9/16I
Power Coil Tap Part Number	STI	Bottoming	3530-9/16B
Power Coil Tap Part Number	STI	SpiralPoint	-
Power Coil Tap Part Number	STI	SpiralFlute	-

INSERT SPECIFICATIONS		
E Fitted Minor Diameter	inch	0.4825
Q Nominal Length Installed	inch	0.562
Free Coil Diameter minimum	inch	0.64
Free Coil Diameter maximum	inch	0.70
Free Coils minimum	#	6.60
Free Coils maximum	#	7.30

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 90º from the tang.

Free Coil Dia.

Number of Free Coils