

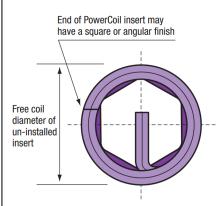
Insert Part Number		3534-10GX2.0DSLIR
Insert Thread Form		Unified National Fine - UNF
Nominal Thread Size		10 X 32
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	inch	0.3800
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MS21209-F1-20
National Aerospace Standard	#	NASM21209-F1-20
Federal Stock	#	5340-721-7653
National Stock / NATO	#	5325-00-721-7653

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	3534-10GMIT	
Mandrel Installation Tool	-	
Captive Prewinder Tool	3534-10GHIP	
Non-Captive Prewinder Tool	-	
Spring Loaded tang Break Tool	3500-STB6	
Pneumatic Front end assembly (FEA)	3534-10GMIP	
FEA Mandrel	3534-10GMIPM	
FEA Nozzle	3534-10GMIPN	
Pneumatic Tool	3500-MIP1	

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TAPPED HOLE DIMENSIONS

Tap Size

Tap Size

B Major Diameter

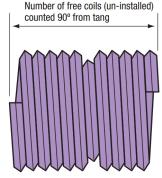
C Pitch Diameter MIN

C Pitch Diameter MAX

C Pitch Diameter MAX

T Tapping Depth MIN

Power Coil Tap Part Number



UNF 10 X 32

0.2306

0.2103

0.2123

0.213

0.489

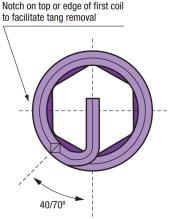
3534-10GT

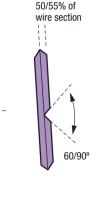
3534-10GB

3534-10GSP

3534-10GSF

3534-10GI





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	5.10	
Drill Part Number		2007-5.10	
Drill Size inch	inch	13/64	
Drill Part Number inch		2006-13/64	
A Minor Diameter inimum	inch	0.197	
A Minor Diameter maximum	inch	0.202	
S Drilling Depth minimum	inch	0.521	

inch

inch

inch

inch

inch

Taper

Intermediate

Bottoming

SpiralPoint

SpiralFlute

STI

2B

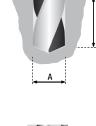
1B

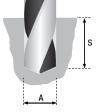
STI

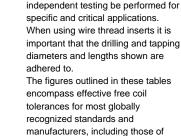
STI

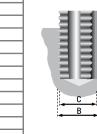
STI

STI









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

reduced diameter wire thread inserts.

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

shown are recommendations only and

PowerCoil would strongly suggest that

is not possible to give specific drill

sizes for each material. Drill sizes

