powercoil®

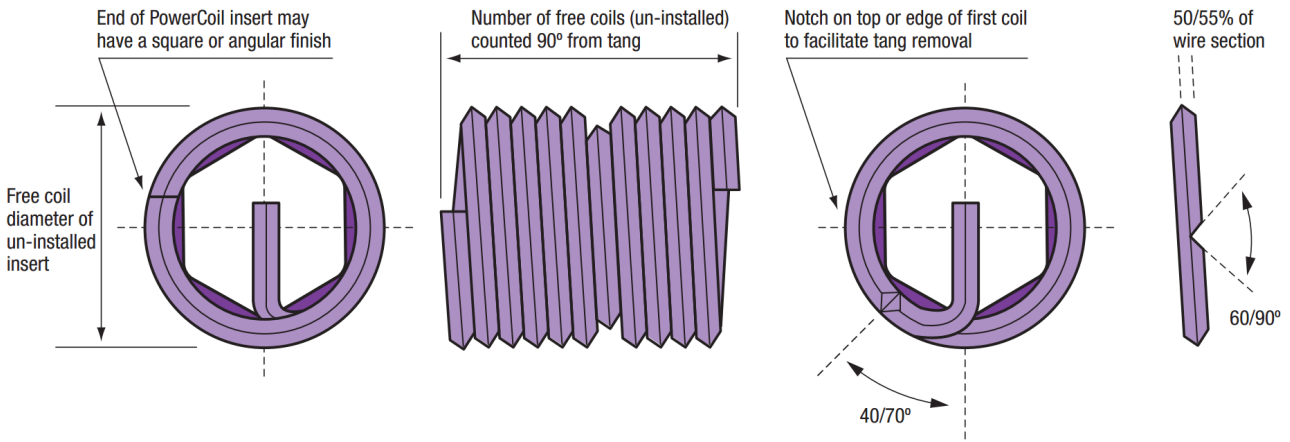
Insert Part Number		3520-2.50X1.0DSLIR
Insert Thread Form		Metric Coarse
Nominal Thread Size		M2.5 X 0.45
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	mm	2.500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-101
National Aerospace Standard	#	
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.

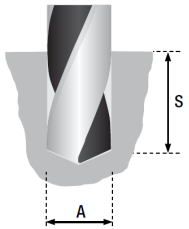
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS	
TOOL TYPE	Part #
Hand Installation Tool	-
Tang Break Tool	3500-TB3
Removal Tool	3500-RT1
Machine Installation Tool	3520-2.50MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-2.50HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB2
Pneumatic Front end assembly (FEA)	3520-2.50MIP
FEA Mandrel	3520-2.50MIPM
FEA Nozzle	3520-2.50MIPN
Pneumatic Tool	3500-MIP1

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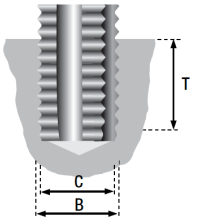
PowerCoil is a registered trademark of Bordo International Pty Ltd Australia



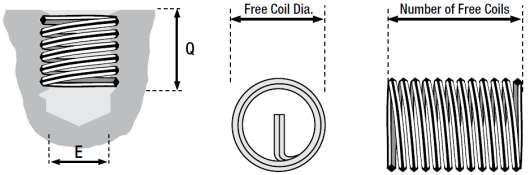
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP		
Drill Size	mm	2.60
Drill Part Number		2007-2.60
Drill Size inch	inch	#37
Drill Part Number inch		2013-37
A Minor Diameter inimum	mm	2.597
A Minor Diameter maximum	mm	2.697
S Drilling Depth minimum	mm	4.53



TAPPED HOLE DIMENSIONS			
Tap Size	STI		M2.5 X 0.45
Tap Size	-		-
B Major Diameter		mm	3.085
C Pitch Diameter MIN		mm	2.792
C Pitch Diameter MAX	5H	mm	2.832
C Pitch Diameter MAX	6H	mm	2.847
T Tapping Depth MIN		mm	4.08
Power Coil Tap Part Number	STI	Taper	3520-2.50T
Power Coil Tap Part Number	STI	Intermediate	3520-2.50I
Power Coil Tap Part Number	STI	Bottoming	3520-2.50B
Power Coil Tap Part Number	STI	SpiralPoint	3520-2.50SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-2.50SF



INSERT SPECIFICATIONS		
E Fitted Minor Diameter	mm	2.013
Q Nominal Length Installed	mm	2.500
Free Coil Diameter minimum	mm	3.054
Free Coil Diameter maximum	mm	3.700
Free Coils minimum	#	3.10
Free Coils maximum	#	3.80



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.