

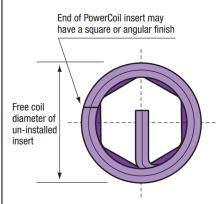
Insert Part Number		3523-12.00X2.5DSL
Insert Thread Form		Metric Fine
Nominal Thread Size		M12 X 1.25
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	mm	30.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-262
National Aerospace Standard	#	
Federal 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.

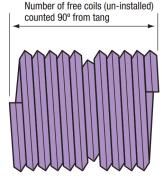
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS			
TOOL TYPE	Part #		
Hand Installation Tool	-		
Tang Break Tool	3500-TB15		
Removal Tool	3500-RT3		
Machine Installation Tool	3523-12.00MIT		
Mandrel Installation Tool	-		
Captive Prewinder Tool	3523-12.00HIP		
Non-Captive Prewinder Tool	-		
Spring Loaded tang Break Tool	3500-STB12		
Pneumatic Front end assembly (FEA)	-		
FEA Mandrel	-		
FEA Nozzle	-		
Pneumatic Tool	-		

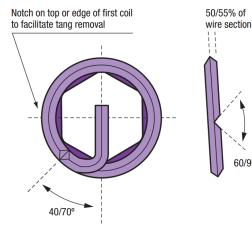
powercoil.com.au

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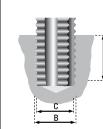


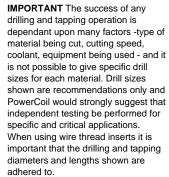
TARRED HOLE DIMENSIONS











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.

Free Coil Dia.

Number of Free Coils





DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP				
Drill Size	mm	12.30		
Drill Part Number		2007-12.30		
Drill Size inch	inch	31/64		
Drill Part Number inch		2006-31/64		
A Minor Diameter minimum	mm	12.271		
A Minor Diameter maximum	mm	12.483		
S Drilling Depth minimum	mm	35.63		

TAPPED HOLE DIMENSIONS				
Tap Size	STI		M12 X 1.25	
Tap Size	-		-	
B Major Diameter		mm	13.624	
C Pitch Diameter MIN		mm	12.812	
C Pitch Diameter MAX	5H	mm	12.898	
C Pitch Diameter MAX	6H	mm	12.926	
T Tapping Depth MIN		mm	34.38	
Power Coil Tap Part Number	STI	Taper	3523-12.00T	
Power Coil Tap Part Number	STI	Intermediate	3523-12.001	
Power Coil Tap Part Number	STI	Bottoming	3523-12.00B	
Power Coil Tap Part Number	STI	SpiralPoint	3523-12.00SP	
Power Coil Tap Part Number	STI	SpiralFlute	3523-12.00SF	

INSERT SPECIFICATIONS		
E Fitted Minor Diameter	mm	10.647
Q Nominal Length Installed	mm	30.000
Free Coil Diameter minimum	mm	13.760
Free Coil Diameter maximum	mm	15.000
Free Coils minimum	#	19.70
Free Coils maximum	#	21.60