

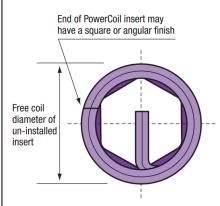
Insert Part Number		3520-14.00X1.0DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M14 X 2.0
Insert Length Q (installed)	D	1.0D
Insert Length Q (installed)	mm	14.000
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-116
National Aerospace Standard	#	
Federal Stock	#	-
National Stock / NATO	#	-

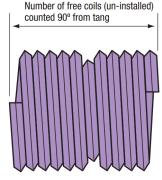
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate 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.

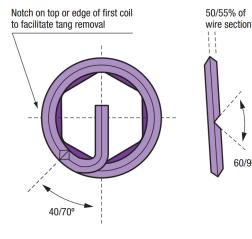
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS			
TOOL TYPE	Part #		
Hand Installation Tool	-		
Tang Break Tool	-		
Removal Tool	3500-RT3		
Machine Installation Tool	3520-14.00MIT		
Mandrel Installation Tool	-		
Captive Prewinder Tool	3520-14.00HIP		
Non-Captive Prewinder Tool	-		
Spring Loaded tang Break Tool	-		
Pneumatic Front end assembly (FEA)	-		
FEA Mandrel	-		
FEA Nozzle	-		
Pneumatic Tool	-		

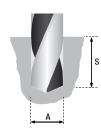
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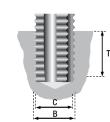
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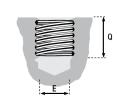


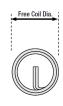


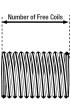
IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and PowerCoil would 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

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

encompass effective free coil tolerances for most globally recognized standards and manufacturers, including those of reduced diameter wire thread inserts.







DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP			
Drill Size	mm	14.50	
Drill Part Number		2654-14.50	
Drill Size inch	inch	37/64	
Drill Part Number inch		2651-37/64	
A Minor Diameter minimum	mm	14.433	
A Minor Diameter maximum	mm	14.733	
S Drilling Depth minimum	mm	23.00	

TAPPED HOLE DIMENSIONS				
STI		M14 X 2.00		
-		-		
	mm	16.598		
	mm	15.299		
5H	mm	15.406		
6H	mm	15.444		
	mm	21.00		
STI	Taper	3520-14.00T		
STI	Intermediate	3520-14.001		
STI	Bottoming	3520-14.00B		
STI	SpiralPoint	3520-14.00SP		
STI	SpiralFlute	3520-14.00SF		
	STI - 5H 6H STI STI STI STI	STI		

INSERT SPECIFICATIONS		
E Fitted Minor Diameter	mm	11.835
Q Nominal Length Installed	mm	14.000
Free Coil Diameter minimum	mm	16.432
Free Coil Diameter maximum	mm	17.350
Free Coils minimum	#	5.00
Free Coils maximum	#	5.30