



Insert Part Number		3530-1X1.5D
Insert Thread Form		British Standard Fine - BSF
Nominal Thread Size		1 X 10
Insert Length Q (installed)	D	1.5D
Insert Length Q (installed)	inch	1.500
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 may be 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-HIT23
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	-

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DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

Drill Size	mm	26.20
Drill Part Number		-
Drill Size inch	inch	1.1/32
Drill Part Number inch		-
A Minor Diameter minimum	inch	1.031
A Minor Diameter maximum	inch	1.044
S Drilling Depth minimum	inch	1.950

TAPPED HOLE DIMENSIONS

Tap Size	STI		BSF 1 X 10
Tap Size	-		-
B Major Diameter		inch	1.117
C Pitch Diameter MIN		inch	1.0641
C Pitch Diameter MAX	Clos e	inch	1.0675
C Pitch Diameter MAX	Medi um	inch	1.0697
T Tapping Depth MIN		inch	1.850
Power Coil Tap Part Number	STI	Taper	3530-1T
Power Coil Tap Part Number	STI	Intermediate	3530-1I
Power Coil Tap Part Number	STI	Bottoming	3530-1B
Power Coil Tap Part Number	STI	SpiralPoint	-
Power Coil Tap Part Number	STI	SpiralFlute	-

INSERT SPECIFICATIONS

E Fitted Minor Diameter	inch	0.8720
Q Nominal Length Installed	inch	1.500
Free Coil Diameter minimum	inch	1.13
Free Coil Diameter maximum	inch	1.22
Free Coils minimum	#	12.10
Free Coils maximum	#	13.20



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