



Insert Part Number		3520-2.20X2.5DSL
Insert Thread Form		Metric Coarse
Nominal Thread Size		M2.2 X 0.45
Insert Length Q (installed)	D	2.5D
Insert Length Q (installed)	mm	5.500
Insert Material		304 Stainless Steel
Insert Coating/Plating		-
Military Standard	#	MA3329-250
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-TB2
Removal Tool	3500-RT1
Machine Installation Tool	3520-2.20MIT
Mandrel Installation Tool	-
Captive Prewinder Tool	3520-2.20HIP
Non-Captive Prewinder Tool	-
Spring Loaded tang Break Tool	3500-STB1
Pneumatic Front end assembly (FEA)	-
FEA Mandrel	-
FEA Nozzle	-
Pneumatic Tool	-

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DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

Drill Size	mm	2.30
Drill Part Number		2007-2.30
Drill Size inch	inch	#42
Drill Part Number inch		2013-42
A Minor Diameter minimum	mm	2.297
A Minor Diameter maximum	mm	2.397
S Drilling Depth minimum	mm	7.53

TAPPED HOLE DIMENSIONS

Tap Size	STI		M2.2 X 0.45
Tap Size	-		-
B Major Diameter		mm	2.785
C Pitch Diameter MIN		mm	2.492
C Pitch Diameter MAX	5H	mm	2.532
C Pitch Diameter MAX	6H	mm	2.547
T Tapping Depth MIN		mm	7.08
Power Coil Tap Part Number	STI	Taper	3520-2.20T
Power Coil Tap Part Number	STI	Intermediate	3520-2.20I
Power Coil Tap Part Number	STI	Bottoming	3520-2.20B
Power Coil Tap Part Number	STI	SpiralPoint	3520-2.20SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-2.20SF

INSERT SPECIFICATIONS

E Fitted Minor Diameter	mm	1.713
Q Nominal Length Installed	mm	5.500
Free Coil Diameter minimum	mm	2.757
Free Coil Diameter maximum	mm	3.000
Free Coils minimum	#	9.30
Free Coils maximum	#	10.30

