



Insert Part Number		3520-22.00X2.0DP
Insert Thread Form		Metric Coarse
Nominal Thread Size		M22 X 2.50
Insert Length Q (installed)	D	2.0D
Insert Length Q (installed)	mm	44.00
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 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	3500-HIT22
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	22.80
Drill Part Number		-
Drill Size inch	inch	57/64
Drill Part Number inch		2651-57/64
A Minor Diameter minimum	mm	22.541
A Minor Diameter maximum	mm	22.896
S Drilling Depth minimum	mm	55.25

TAPPED HOLE DIMENSIONS

Tap Size	STI		M22 X 2.50
Tap Size	-		-
B Major Diameter		mm	25.248
C Pitch Diameter MIN		mm	23.624
C Pitch Diameter MAX	5H	mm	23.738
C Pitch Diameter MAX	6H	mm	23.778
T Tapping Depth MIN		mm	52.75
Power Coil Tap Part Number	STI	Taper	3520-22.00T
Power Coil Tap Part Number	STI	Intermediate	3520-22.00I
Power Coil Tap Part Number	STI	Bottoming	3520-22.00B
Power Coil Tap Part Number	STI	SpiralPoint	3520-22.00SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-22.00SF

INSERT SPECIFICATIONS

E Fitted Minor Diameter	mm	19.294
Q Nominal Length Installed	mm	44.00
Free Coil Diameter minimum	mm	25.00
Free Coil Diameter maximum	mm	26.90
Free Coils minimum	#	14.50
Free Coils maximum	#	15.80



IMPORTANT The success of any drilling and