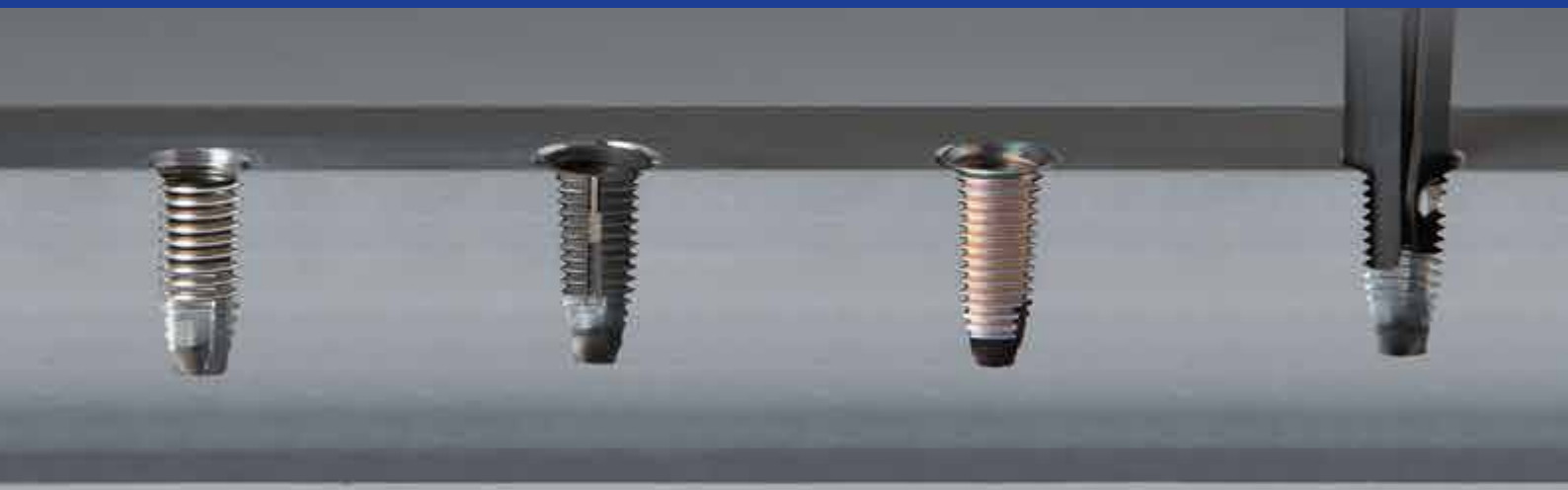
2016 UPDATE

BORDO®
INDUSTRIAL TOOLS



powercoil® loksert® tapsert® Nes®

THREADED INSERTS
& THREAD RESTORATION
BUYER'S GUIDE 03/2016

powercoil®

wire thread insert system

powercoil®

Insert Diameter Einsatz Durchmesser Diamètre du filet rapporté Diámetro del inserto 螺套直径 インサート径	Pitch (TPI) Steigung (TPI) Pas (TPI) Paso por pulgada 螺距(TPI) ピッチ(TPI)	Pitch (mm) Steigung (mm) Pas (mm) Paso en milímetros 螺距(mm) ピッチ(mm)	Installed Length Installierte Einsatzlänge Longueur implantée Longitud instalada 安装后长度 挿入深さ	# of inserts # Einsätze Nb de filets rapportés Número de insertos 螺套数量 インサート数	Drill Size Gewindebohrer-Größe Dimension du foret Diámetro de la broca 钻头尺寸 ドリルサイズ	Tap Part # Gewindeschneider # Code pièce du taraud Macho Nº 丝锥号 タップ部品番号	Install Tool Part # Einbauwerkzeug # Code pièce de l'outil d'installation Herramienta de instalación Nº 安装工具号码 挿入工具部品番号	Tang Break Part # Zapfenbrecher # Code pièce du tenon Rompedor Nº 折断柄号码 タング折取部品番号

FREE
Free Running Insert
Frei laufender Einsatz
Filet rapporté standard
Inserto standard
普通型螺套
フリーランニングインサート

LOCK
Screw Locking Insert
Screwlockender Einsatz
Filet rapporté à frein de vis
Inserto autofrenante
锁紧型螺套
ロックタイプインサート

MC
Metric Coarse
Metrisch Standard
Métrique à pas normaux
Métrica gruesa
公制粗牙螺纹
ミリ並目

MF
Metric Fine
Metrisch Fein
Métrique à pas fins
Métrica fina
公制细牙螺纹
ミリ細目

UNC
Unified National Coarse
Unified National Standard
Pas normal américain
Rosca Americana gruesa
统一标准粗牙螺纹
ユニファイ並目

UNF
Unified National Fine
Unified National Fein
Pas fin américain
Rosca Americana fina
统一标准细牙螺纹
ユニファイ細目

BSW
British Standard Whitworth
British Standard Whitworth
Pas normal britannique
Rosca inglesa gruesa
英制标准惠氏螺纹
英国規格ウイットワース

BSF
British Standard Fine
British Standard Fein
Pas fin britannique
Rosca inglesa fina
英制标准细牙螺纹
英国規格細目

BSP
British Standard Pipe
British Standard Pipe
filet de tube britannique
Rosca inglesa GAS
英制标准管螺纹
英国規格パイプ

NPT
National Pipe Taper
National Pipe Konus
tube conique américain
Rosca cónica Americana
标准管螺纹
アメリカ規格管用テーパー

8-UN
8-UN Constant Pitch
8-UN konstante Steigung
Pas constant 8-UN
Rosca Americana paso 8 hilos
英制 8螺纹
8-UN 一定ピッチ

BA
British Association
British Association
Association britannique
Rosca inglesa BA
BA螺纹
英国協会

BSC
British Standard Brass
British Standard Brass
Standard Anglais BSCY
Rosca inglesa BSC
英国标准（黄铜）
英国規格真鍮

1.0D
Installed Insert Length = Diameter x 1.0
Installierte Einsatzlänge = Durchmesser x 1.0
Longueur du filet rapporté installé = Diamètre x 1.0
Longitud del inserto instalado = Diámetro x 1
安装后螺套长度 = 直径 *1.0
挿入インサート長さ= 径 x 1.0

1.5D
Installed Insert Length = Diameter x 1.5
Installierte Einsatzlänge = Durchmesser x 1.5
Longueur du filet rapporté installé = Diamètre x 1.5
Longitud del inserto instalado = Diámetro x 1,5
安装后螺套长度 = 直径 *1.5
挿入インサート長さ= 径 x 1.5

2.0D
Installed Insert Length = Diameter x 2.0
Installierte Einsatzlänge = Durchmesser x 2.0
Longueur du filet rapporté installé = Diamètre x 2.0
Longitud del inserto instalado = Diámetro x 2
安装后螺套长度 = 直径 *2.0
挿入インサート長さ= 径 x 2.0

2.5D
Installed Insert Length = Diameter x 2.5
Installierte Einsatzlänge = Durchmesser x 2.5
Longueur du filet rapporté installé = Diamètre x 2.5
Longitud del inserto instalado = Diámetro x 2,5
安装后螺套长度 = 直径 *2.5
挿入インサート長さ= 径 x 2.5

3.0D
Installed Insert Length = Diameter x 3.0
Installierte Einsatzlänge = Durchmesser x 3.0
Longueur du filet rapporté installé = Diamètre x 3.0
Longitud del inserto instalado = Diámetro x 3
安装后螺套长度 = 直径 *3.0
挿入インサート長さ= 径 x 3.0

HSSE
HSS-EV **Spiral Flute** STI Tap
HSS-EV **Geradeer** STI- Gewindeschneider
Taraud STI **à rainures hélicoïdales** HSS-EV
Macho STI Helicoidal
螺旋槽丝锥
HSS-EV スパイラルフルートSTIタップ

HSSE
HSS-EV **Spiral Point** (Gun Nose) STI Tap
HSS-EV **Drallspitzen** -(Tiefloch-) STI- Gewindeschneider
Taraud STI **à entrée hélicoïdale** (nez mitrailleuse) HSS-EV
Macho STI con entrada corregida F/B
螺尖丝锥
HSS-EV スパイラルポイント(ガンノーズ)STIタップ

HSS (60°, 2-3)
MC, MF, UNC, UNF, 8 Pitch, NPT – HSS **Bottoming** STI Tap
MC, MF, UNC, UNF, 8 Steigungs-, NPT – HSS **vorschneider** STI-Gewindeschneider
Taraud STI **finisseur** MC, MF, UNC, UNF, 8 pas, NPT – HSS
Macho STI de acabado, Nº 3 – MC, MF, UNC, UNF, 8 UN, NPT
高速钢螺套专用丝锥（底锥）适用于MC,MF,UNC,UNF,8UN,NPT螺纹
MC, MF, UNC, UNF, 8 ピッチ, NPT - HSS STI上げタップ

HSS (60°, 4-5)
MC, MF, UNC, UNF, 8 Pitch, NPT – HSS **Intermediate** STI Tap
MC, MF, UNC, UNF, 8 Steigung, NPT – HSS **Einschnitt** STI- Gewindeschneider
Taraud STI **intermédiaire** MC, MF, UNC, UNF, 8 pas, NPT – HSS
Macho STI intermedio, Nº 2 – MC, MF, UNC, UNF, 8 UN, NPT
高速钢螺套专用丝锥（中锥）适用于MC,MF,UNC,UNF,8UN,NPT螺纹
MC, MF, UNC, UNF, 8 ピッチ, NPT - HSS STI中タップ

HSS (60°, 6-8)
MC, MF, UNC, UNF, 8 Pitch, NPT – HSS **Taper** STI Tap
MC, MF, UNC, UNF, 8 Steigung, NPT – HSS **fertigschneider** STI-Gewindeschneider
Taraud STI **ébaucheur** MC, MF, UNC, UNF, 8 pas, NPT – HSS
Macho STI cónico, Nº 1 – MC, MF, UNC, UNF, 8 UN, NPT
高速钢螺套专用丝锥（头锥）适用于MC,MF,UNC,UNF,8UN,NPT螺纹
MC, MF, UNC, UNF, 8 ピッチ, NPT - HSS STI先タップ

HSS (55°, 2-3)
BSW, BSF, BSP – HSS **Bottoming** STI Tap
BSW, BSF, BSP – HSS **vorschneider** STI- Gewindeschneider
Taraud **finisseur** STI BSW, BSF, BSP – HSS
Macho STI de acabado, Nº 3 – BSW, BSF, BSP
高速钢螺套专用丝锥（底锥）适用于 BSW, BSF, BSP螺纹
BSW, BSF, BSP - HSS STI上げタップ

HSS (55°, 4-5)
BSW, BSF, BSP – HSS **Intermediate** STI Tap
BSW, BSF, BSP – HSS **Einschnitt** STI Gewindeschneider
Taraud STI **intermédiaire** BSW, BSF, BSP – HSS
Macho STI intermedio, Nº 2 – BSW, BSF, BSP
高速钢螺套专用丝锥（中锥）适用于 BSW, BSF, BSP螺纹
BSW, BSF, BSP - HSS STI中タップ

HSS (55°, 6-8)
BSW, BSF, BSP – HSS **Taper** STI Tap
BSW, BSF, BSP – HSS **fertigschneider** STI-Gewindeschneider
Taraud STI **ébaucheur** BSW, BSF, BSP – HSS
Macho STI cónico, Nº 1 – BSW, BSF, BSP
高速钢螺套专用丝锥（头锥）适用于 BSW, BSF, BSP螺纹
BSW, BSF, BSP - HSS STI先タップ

HSS (47.5°, 2-3)
BA – HSS **Bottoming** STI Tap
BA – HSS **vorschneider** STI-Gewindeschneider
Taraud STI **finisseur** BA – HSS
Macho STI de acabado, Nº 3 –BA
高速钢螺套专用丝锥（底锥）适用于 BA螺纹
BA - HSS STI上げタップ

HSS (47.5°, 4-5)
BA – HSS **Intermediate** STI Tap
BA – HSS **Einschnitt** STI- Gewindeschneider
Taraud STI **intermédiaire** BA – HSS
Macho STI intermedio, Nº 2 –BA
高速钢螺套专用丝锥（中锥）适用于 BA螺纹
BA - HSS STI中タップ

HSS (47.5°, 6-8)
BA – HSS **Taper** STI Tap
BA – HSS **fertigschneider** STI- Gewindeschneider
Taraud STI **ébaucheur** BA – HSS
Macho STI cónico, Nº 1 –BA
高速钢螺套专用丝锥（头锥）适用于 BA螺纹
BA - HSS STI先タップ

HSS (60°)
Spark Plug – HSS **Pilot Nose** STI Tap
Zündkerze – HSS STI- Gewindeschneider mit **Führungszapfen**
Taraud STI **à embout pilote** bougie d'allumage - HSS
Macho STI con doble entrada para bujías
火花塞专用丝锥
スパークプラグ - HSS パイロットノーズSTIタップ

PowerCoil Wire Thread Inserts strengthen tapped threads in light weight parent materials such as aluminium. They are helically wound inserts made from high quality chromium nickel stainless steel with a diamond shaped cross section.

PowerCoil inserts are used in OEM applications in a wide range of industry sectors including aerospace, automotive, military and electronics. They are inexpensive when compared to other inserts and simple to install, yet are extremely tough, wear resistant and corrosion resistant.

Most importantly, PowerCoil inserts allow the stress loading from the bolt or similar threaded part to be more evenly distributed over the threads in the parent material.

In addition to PowerCoil standard 'free running' inserts, 'screw locking' inserts are also available. These inserts have polygonal grip coils within the length of the insert which exert radial pressure on the male thread, thereby gripping the bolt and preventing it from loosening under vibration or impact.

In addition to stainless steel, PowerCoil inserts can be made from Phosphor Bronze, Inconel or Nimonic 90 depending on the application. They can also be supplied with different surface finishes and coatings including cadmium, siver and zinc plating and dry film lubricant.

A complete range of Screw Thread Insert (STI) taps are available as well as low, medium and high volume installation tools and a wide range of individual and workshop repair kits. For further information we recommend you consult the technical pages in this guide, the PowerCoil website: www.powercoil.com.au or call your customer service representative.

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Insert **Internal** Thread
Einsatz **internes** Gewinde
Filetage **interne** du filet rapporté
Rosca interna del inserto
螺套内螺纹
インサート内部スレッド

Insert **External** Thread
Einsatz **externes** Gewinde
Filetage **externe** du filet rapporté
Rosca externa del inserto
螺套外螺纹
インサート外部スレッド

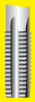
Pitch (mm)
Steigung (mm)
Pas (mm)
Paso en milímetros
螺距（mm）
ピッチ(mm)

Pitch (tpi)
Steigung (tpi)
Pas (tpi)
Paso en dientes por pulgada
螺距（tpi）
ピッチ(tpi)

Insert Length
Einsatzlänge
Longueur du filet rapporté
Longitud del inserto
螺套长度
インサートの長さ

# of Inserts
Einsätze
Nb de filets rapportés
Número de roscas del inserto
螺套数量
インサート数

Tapping Drill Size
Gewindebohrer-Größe
Dimension de l'avant-trou de taraudage
Diámetro de la broca previa
钻头尺寸
タッピングドリルサイズ



Thread Tap Size
Gewindeschneider-Größe
Dimension du taraud de filetage
Dimensión del macho de roscar
丝锥尺寸
スレッドタップサイズ

Countersink Diameter
Senkbohrer-Durchmesser
Diamètre de la fraise
Diámetro del avellanador
倒角直径
カウンターシンク径

Installation Tool Part #
Einbauwerkzeug #
Herramienta de instalación Nº
Code pièce de l'outil d'installation
安装工具编号
挿入工具部品番号

Loksert Thin Wall Insert
Loksert Thinwall Insert (dünnwandiger Einsatz)
Loksert Thin Wall Insert [Filet rapporté Loksert à paroi mince]
Inserto de seguridad Loksert de pared delgada
Loksert 薄壁型螺套
Loksert(ロックサート) 薄肉インサート

Loksert Heavy Duty Insert
Loksert Heavy-Duty Insert (Heavy-Duty Einsatz)
Loksert Heavy Duty Insert [Filet rapporté Loksert à paroi renforcée]
Inserto de seguridad Loksert reforzado
Loksert 厚重型螺套
Loksert(ロックサート) 高耐久性インサート

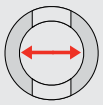
Loksert solid keylocking inserts are an easily installed thread assembly that is ideal for replacing damaged or worn threads in virtually any material – ferrous, non-ferrous and non-metallic.

They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece loksert inserts are supplied with the dove-tailed locking keys pre-assembled. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

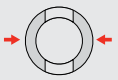
Features and Benefits

- Solid bushing utilising locking keys provides positive mechanical lock against rotation
- High strength and reliability provides maximum pullout strength
- Installed using standard drills and taps
- Simple installation - no special skills required
- Suitable for use in a wide range of parent materials
- Impossible to cross thread during installation
- Simple removal process if required
- No tang to break and remove
- Available in metric sizes, inch sizes and spark plug sizes
- Available in Thinwall and Heavy Duty

tapsert®



Insert **Internal** Thread
Einsatz **internes** Gewinde
Filetage **interne** du filet rapporté
Rosca interna del inserto
螺套内螺纹
インサート内部スレッド



Insert **External** Thread
Einsatz **externes** Gewinde
Filetage **externe** du filet rapporté
Rosca externa del inserto
螺套外螺纹
インサート外部スレッド

Pitch (mm)
Steigung (mm)
Pas (mm)
Paso en milímetros
螺距（mm）
ピッチ(mm)

Pitch (tpi)
Steigung (tpi)
Pas (tpi)
Paso en dientes por pulgada
螺距（tpi）
ピッチ(tpi)

Insert Length
Einsatzlänge
Longueur du filet rapporté
Longitud del inserto
螺套长度
インサートの長さ

# of Inserts
Einsätze
Nb de filets rapportés
Número de roscas del inserto
螺套数量
インサート数

Tapping Drill Size
Gewindebohrer-Größe
Dimension de l'avant-trou de taraudage
Diámetro de la broca previa
钻头尺寸
タッピングドリルサイズ

Tapserts are self cutting threaded inserts that feature both external and internal threads. They are driven into a pre-formed or pre-drilled retaining hole and the cutting slots (or cutting bores) effectively tap the hole as the insert is wound into the parent material.

Tapserts are available in case hardened steel or stainless steel.

Tapserts are ideal for use in low shear strength materials (such as alloys, plastics and castings) which require threaded seats with high load capacity and wear resistance.

Tapserts feature:

- High pull-out strength
- High loading capacity in low shear strength materials
- Wear free, vibration resistant screw joint
- Pre-cast or pre-drilled holes with standard tolerance
- No requirement for thread tapping tools
- Retains and captures chips from installation in chipping reservoirs.

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Part No. 3520 - 12.00 X 1.5D

35	PowerCoil - Stainless Steel
36	Loksert - Carbon Steel
37	Loksert - Stainless Steel

DIAMETER

XX . XX	Metric
XX / XX	Imperial

20	Metric Coarse	**32**	UNC
21	Metric Fine	**34**	UNF
22	Spark Plug	**44**	BA
23	Metric Fine	**46**	BSP
24	Metric Fine	**52**	NPT
28	BSW	**60**	BSC
30	BSF	**70**	8-UN
00	Multifunctional		

X.X D	Insert length as a factor of nominal screw
IR	PowerCoil strip-feed reel
SL	PowerCoil screw locking
K	PowerCoil thread repair kit
P	PowerCoil Hang sell insert packet
WK	PowerCoil workshop kit
HIT	Hand installation tool
HIP	Prewinder installation tool
MIT	Machine installation tool
HIM	Hex drive installation mandrel
MIP	Pneumatic installation tool
TB	Tang break tool
STB	Spring loaded tang break tool
PTB	Pneumatic tang break tool
RT	Removal/extraction tool
LH	Left Hand
GC	Gauge STI 4H5H tolerance
GM	Gauge STI 6H tolerance

PB	Phosphor bronze
IC	Iconel X-750
NM	Nimonic 90
NT	Nitronic 60
Y	316 Stainless Steel
CD	Cadmium plate
ZN	Zinc plate
AG	Silver plate
FL	Dry fim lubricant
I	Tap Intermediate STI
T	Tap Taper STI
B	Tap Bottoming STI
SF	Tap Spiral Flute STI
SP	Tap Spiral Point STI
FT	Tap Fluteless STI
TW	Loksert Thin Wall
HD	Loksert Heavy Duty
TT	Loksert Thin Wall install tool
HT	Loksert Heavy Duty install tool
T	Loksert Universal install tool

Teil-Nr. 3520 - 12.00 X 1.5D

35	PowerCoil - Edelstahl
36	Loksert - unlegierter Stahl
37	Loksert - Edelstahl

DURCHMESSER

XX . XX	Metrisch
XX / XX	Zoll

20	Metrisch Standard	**32**	UNC
21	Metrisch fein	**34**	UNF
22	Zündkerze	**44**	BA
23	Metrisch fein	**46**	BSP
24	Metrisch fein	**52**	NPT
28	BSW	**60**	BSC
30	BSF	**70**	8-UN
00	Multi-funktionell		

X.X D	Einsatzlänge als Faktor der Nennschraube
IR	PowerCoil Stripfeed-Rolle
SL	PowerCoil Screwlockung
K	PowerCoil Gewindereparatur-Sortiment
P	PowerCoil Hangsell-Einsatzpaket
WK	PowerCoil Werkstatt-Sortiment
HIT	Handeinbauwerkzeug
HIP	Vorspannpatronen-Einbauwerkzeug
MIT	Maschinelles Einbauwerkzeug
HIM	Hex-Drive-Einbauspindel
MIP	Pneumatisches Einbauwerkzeug
TB	Zapfenbrecher
STB	Vorgespannter Zapfenbrecher
PTB	Pneumatischer Zapfenbrecher
RT	Ausdrehwerkzeug
LH	Linksdrehend
GC	Maß STI - 4H5H Toleranz
GM	Maß STI - 6H Toleranz

PB	Phosphor bronze
IC	Iconel X-750
NM	Nimonic 90
NT	Nitronic 60
Y	316 Edelstahl
CD	Kadmiert
ZN	Galvanisiert
AG	Versilbert
FL	Trockenschmiermittel
I	Gewindebohrer Einschnitt STI
T	Gewindebohrer - konisch STI
B	Gewindebohrer bodengehend STI
SF	Gewindebohrer Gerade STI
SP	Gewindebohrer Drallspitze STI
FT	Gewindebohrer ohne Nuten STI
TW	Loksert - dünnwandig
HD	Loksert - Heavy-Duty
TT	Loksert – dünnwandig: Einbauwerkzeug
HT	Loksert – Heavy-Duty: Einbauwerkzeug
T	Loksert Universal- Einbauwerkzeug

Pièce Nr. 3520 - 12.00 X 1.5D

35	PowerCoil - Acier inoxydable
36	Loksert - Acier au carbone
37	Loksert - Acier inoxydable

DIAMETER

XX . XX	Métrique
XX / XX	Impérial

20	Métrique à pas normaux	**32**	UNC
21	Métrique à pas fins	**34**	UNF
22	Bougie d'allumage	**44**	BA
23	Métrique à pas fins	**46**	BSP
24	Métrique à pas fins	**52**	NPT
28	BSW	**60**	BSC
30	BSF	**70**	8-UN
00	Multifonctionnel		

X.X D	Longueur du filet rapporté tel que facteur de serrage nominal
IR	Moulinet d'entraînement de bande PowerCoil
SL	PowerCoil à frein de vis
K	kit de réparation de filets PowerCoil
P	Paquet de filets rapportés PowerCoil dans un emballage à système d'accroche
WK	PowerCoil kit d'atelier
HIT	Outil d'installation manuel
HIP	outil d'installation de pré-enroulage
MIT	Outil d'installation de la machine
HIM	mandrin d'installation Hex
MIP	Outil pneumatique d'installation
TB	Tenon
STB	Tenon à ressort
PTB	Pneumatic tang break tool
RT	Outil de dépose / d'extraction
LH	Coupe à gauche
GC	Jauge STI de tolérance 4H5H
GM	Jauge STI de tolérance 6H

PB	Bronze de phosphore
IC	Iconel X-750
NM	Nimonic 90
NT	Nitronic 60
Y	Acier inoxydable 316
CD	Plaque de cadmium
ZN	Plaque de zinc
AG	Plaque d'argent
FL	film de lubrifiant hydrofuge
I	Taraud STI intermédiaire
T	Taraud STI ébaucheur
B	Taraud STI finisseur
SF	Taraud STI à rainures hélicoïdales
SP	Taraud STI à entrée hélicoïdale
FT	Taraud STI sans goujoure
TW	Loksert à paroi fine
HD	Loksert à paroi renforcée
TT	Outil d'installation de Loksert à paroi fine
HT	Outil d'installation de Loksert à paroi renforcée
T	Outil d'installation universel de Loksert

powercoil®

loksert®

No. De Parte 3520-12.00X1,5D

35	PowerCoil en acero inoxidable
36	Loksert en acero al carbón
37	Loksert en acero inoxidable

DIAMETER

XX . XX	Métrico
XX / XX	Pulgadas

20	Métrico grueso	32	UNC
21	Métrico fino	34	UNF
22	Bujía	44	BA
23	Métrico fino	46	BSP
24	Métrico fino	52	NPT
28	BSW	60	BSC
30	BSF	70	8-UN
00	Multifuncional		

X.X D	Longitud del inserto teniendo en cuenta la longitud del tornillo
IR	Power Coil, Carrete de alimentación de insertos
SL	Power Coil, insertos autoblocantes (de seguridad) (autofrenantes)
K	Power Coil, Juego de reparación de roscas
P	Power Coil, paquetes de insertos para colgar
WK	Power Coil, Juegos para taller
HIT	Herramienta de instalación manual
HIP	Herramienta de instalación de roscas
MIT	Herramienta para insertar a máquina
HIM	Herramienta para insertar con mango hexagonal
MIP	Herramienta de instalación neumática
TB	Herramienta rompe arrastre
STB	Herramienta rompe arrastre automático
PTB	Herramienta rompe arrastre neumática
RT	Herramienta extractora de insertos
LH	Giro izquierda
GC	Roscas en tolerancia STI 4H5H

PB	Bronce con fósforo
IC	Iconel X-750
NM	Nimonic 90
NT	Nitronic 60
Y	Acero Inoxidable 316
CD	Terminado en cadmio
ZN	Terminado de zinc
AG	Terminado de plata
FL	lubricado en seco
I	Macho 2º o intermedio STI
T	Macho 1º o cónico STI
B	Macho 3º o de acabado STI
SF	Macho helicoidal STI
SP	Macho con entrada corregida STI
FT	Macho laminación STI
TW	Loksert de pared delgada
HD	Loksert para trabajos pesados (duros)
TT	Herramienta instalación de Loksert de pared delgada
HT	Herramienta instalación de Loksert para trabajos pesados
T	Herramienta de instalación universal

Part No. 3520 - 12.00 X 1.5D

35	PowerCoil – 不锈钢
36	Loksert – 碳钢
37	Loksert – 不锈钢

直径

XX . XX	公制
XX / XX	英制

20	公制粗牙	32	统一标准粗牙螺纹
21	公制细牙	34	统一标准细牙螺纹
22	火花塞	44	英国 BA标准螺纹
23	公制细牙	46	英制标准管螺纹
24	公制细牙	52	标准管螺纹
28	英制标准惠氏螺纹	60	英国BSC螺纹
30	英制标准细牙螺纹	70	英制8螺纹
00	多功能的		

X.X D	螺孔倍率因子
IR	PowerCoil盘装螺套
SL	PowerCoil自锁型螺套
K	PowerCoil螺纹修理套装
P	PowerCoil悬挂螺套包
WK	PowerCoil车间修理套装
HIT	手动安装工具
HIP	预拉伸安装工具
MIT	机用安装工具
HIM	HEX安装心轴
MIP	气动安装工具
TB	安装柄折断工具
STB	伸缩折断工具
PTB	气动折断工具
RT	螺套拆除工具
LH	左手
GC	STI专用量规(4H,5H)
GM	STI专用量规(6H)

PB	磷铜
IC	因科镍合金
NM	铌锰合金
NT	Nitronic60合金
Y	316不锈钢
CD	镀镉
ZN	镀锌
AG	镀银
FL	干性润滑剂涂层
I	中锥
T	头锥
B	底锥
SF	螺旋槽丝锥
SP	螺尖丝锥
FT	挤压丝锥
TW	Loksert 薄壁型螺套
HD	Loksert 厚重型螺套
TT	Loksert薄壁型螺套安装工具
HT	Loksert 厚重型螺套安装工具
T	Loksert 通用安装工具

部品番号 3520-12.00X1.5D

35	PowerCoil ー ステンレス網
36	Loksert ー カーボン網
37	Loksert ー ステンレス網

径

XX . XX	メートル法
XX / XX	インチ法

20	ミリ並目	32	UNC
21	ミリ細目	34	UNF
22	スパークプラグ	44	BA
23	ミリ細目	46	BSP
24	ミリ細目	52	NPT
28	BSW	60	BSC
30	BSF	70	8-UN
00	多機能性		

X.X D	呼びねじ寸法の倍数としてのインサートの長さ
IR	Power Coil ストリップフィードリール
SL	Power Coil ロックタイプ
K	Power Coil ねじ山補修キット
P	Power Coil ハングセルインサートパケット
WK	Power Coil 作業キット
HIT	手動挿入工具
HIP	プリワインダー挿入工具
MIT	電動挿入工具
HIM	6角ドライブ挿入マンドレル
MIP	エアー式挿入工具
TB	タング折取工具
STB	スプリング式タング折取工具
PTB	エアー式タング折取工具
RT	取出し/抜取り工具
LH	左(巻き方向)
GC	STI 4H5H公差ゲージ

PB	りん青銅
IC	インコネルX-750
NM	ナイモニック90
NT	ニトロニック60
Y	316ステンレス網
CD	カドミウムメッキ
ZN	亜鉛メッキ
AG	銀メッキ
FL	ドライフィルム潤滑材
I	STI中タップ
T	STI先タップ
B	STI上げタップ
SF	STIスパイラルフルートタップ
SP	STIスパイラルポイントタップ
FT	STIフルートレス溝なしタップ
TW	薄肉ロックサート
HD	高耐久性ロックサート
TT	薄肉ロックサート挿入工具
HT	高耐久性ロックサート挿入工具
T	Loksert(ロックサート)

powerCoil® wire thread insert system

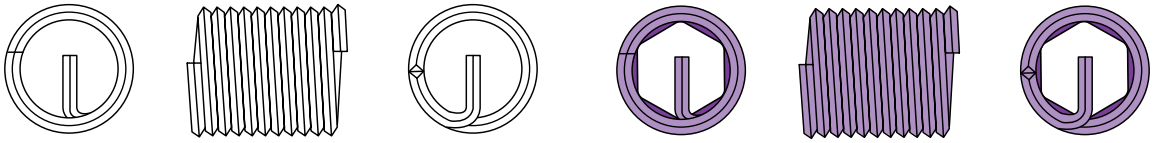
loksert®

tapsert®

Nes®

powercoil® wire thread insert system

BORDO INDUSTRIAL TOOLS



Manufactured from high quality chromium nickel stainless steel, PowerCoil Wire Thread Inserts provide high strength internal threads that resist the effects of temperature and corrosion. Their unique design ensures superior threads whose compound performance cannot be reproduced by any other single fastening method. Available in two basic forms, free running or screw locking, they are much lighter and less expensive than any other equivalent type of thread insert and because of their compact size they can generally be incorporated into existing designs where no previous provision has been made.

FREE RUNNING

Produced from precision profiled austenitic stainless steel wire wound into a helical spiral, PowerCoil free running inserts have a spring like appearance. When installed, using any one of a variety of manual or automatic tools, they provide strong permanent internal threads which resist heat and corrosion. Once fitted, their position is maintained by the action of radial pressure between their coils and the flanks of the tapped hole. This pressure exists because their free diameter is larger by a calculated amount, than their installed diameter.

SCREW LOCKING

Screw locking (or prevailing torque) inserts are of particular value in applications subject to the effects of cyclic vibration or impact. In addition to the benefits afforded by free running inserts, PowerCoil screw locking inserts offer the additional security of prevailing locking torque. This is achieved by the action of one or more polygonal grip coils positioned within the insert's length, which exert radial pressure on the male thread. Each grip coil consists of a number of tangential locking chords which protrude inside the minor diameter of the normal free running coils. As the male thread passes through these grip coils, the locking flats are displaced thus exerting radial pressure or prevailing torque on the male thread. On removal of the male thread, the locking coils relax to their original form permitting repeated assembly whilst retaining a measurable level of prevailing torque.

Note: It is recommended that only close fit plated or lubricated bolts or screws are used with screw locking inserts.

FEATURES & BENEFITS

For many years, helically coiled wire thread inserts have been vastly underestimated. The popular misconception that they were designed for the repair of damaged threads has given this unique fastener a false image.

They are much lighter and less expensive than any other equivalent type of thread insert and because of their compact size, can generally be introduced into existing designs where no previous provision has been made. Unlike many other economic measures, their introduction increases quality and performance whilst reducing overall product cost. Their introduction may result in the use of thinner sections or lighter parent materials without sacrificing thread strength.

They protect tapped threads against failures due to stripping, seizing, corrosion and wear. PowerCoil wire thread inserts are produced from austenitic stainless steel wire which is work hardened to a tensile strength above 200,000psi and a hardness of Rc43-50.The inserts have an exceedingly smooth surface finish which virtually eliminates friction-induced thread erosion.

The continuous helically coiled design negates the need for thick wall structures to support the internal and external threads - the diamond profile wire coil *is* the thread. PowerCoil wire thread inserts can be installed in reduced size bosses or flanges and within constricted areas – saving space and weight while providing high strength.

A boss radius equal to the nominal bolt diameter is usually sufficient.

A complete range of installation tools are available to suit specific production techniques. A range of hand tools exist for small runs and repairs; electric and pneumatic tools are available for high volume production requirements.

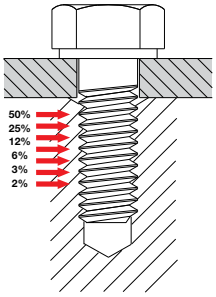
STRENGTH

Due to their flexibility, wire thread inserts create internal threads which have a much improved distribution of residual stress loading when compared with conventional tapped holes, where 75% of the shearing forces are carried by the first three threads in the tapped hole. The flexibility of wire thread inserts helps to compensate for pitch and flank angle errors, inherent in normal tapped holes, and significantly enhances the load bearing capacity by deflecting the residual forces into a helical hoop stress which is dispersed into the wall of the tapped hole. This enables the design to be confidently based on the bolt strength utilising smaller and shorter threads even when used in low strength materials.

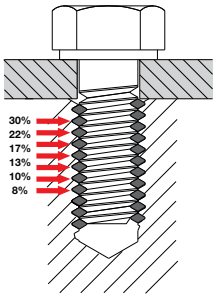
The high tensile coils of a wire thread insert undergo a diameter reduction during installation. The outward spring-like force of the coils "locks" the insert into place.

Each coil can flex independently to contact the greatest amount of parent material thread surface. Both static and dynamic load bearing capabilities are improved.

Standard Bolt



Bolt with PowerCoil insert



ELIMINATE STRESS

Virtually no stress is introduced into the parent material because there is no staking, locking, swaging or keying in place. The outward "spring action" of the insert holds it in place.

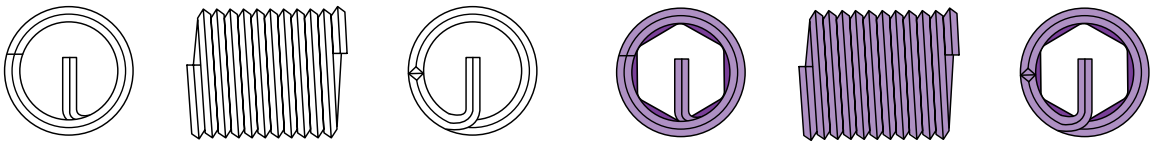
WEAR RESISTANCE

The combination of material hardness and the brilliant surface finish of wire thread inserts creates internal threads in which wear due to thread friction is virtually eliminated. This is of particular value in applications requiring repeated assembly and disassembly. The low frictional coefficient ensures that virtually all of the applied assembly torque is converted into clamping load. Thus providing threads that stay tight.

CORROSION PROTECTION

The 18/8 austenitic stainless steel wire used in PowerCoil inserts resists corrosion under normal environmental conditions. Galvanic action within the thread assembly is reduced, increasing the life of the fastening assembly.

Galvanic corrosion is most significant form of corrosion affecting



inserts and fasteners. Galvanic corrosion occurs when dissimilar metals are in contact in the presence of an electrolytic solution. All metals exhibit different degrees of "activity" or "nobility" and can be arranged in a galvanic series of increasing activity. Gold and platinum are most noble while zinc and magnesium are most active. The most common electrolytic solution encountered is ordinary water. Seawater or salt spray is more damaging because of high concentrations of dissolved salts.

The best way to preclude galvanic corrosion is to use similar potential metals and eliminate the electrolyte conductor. The active stainless steel of PowerCoil wire thread inserts are not passivated. This minimizes the possibility of galvanic corrosion occurring when they are installed in aluminum or magnesium parent materials.

Some additional precautions for reducing galvanic corrosion are:

1. Isolate the fasteners from the electrolyte. This can be done through gasketing or sealing.
2. Specify cadmium plated inserts. The cadmium plate provides a sacrificial barrier against corrosion. In addition, the cadmium plate has lubricating properties that minimize galling when stainless steel screws are used.
3. Apply corrosion inhibiting pastes or compounds to the screw. These include zinc chromate primer (MIL-P-8585) and strontium chromate primer (MIL-P-23377). Note: Pastes applied to the PowerCoil Thread Insert can become trapped between the wire and the hole and cause loss of proper tolerance. It is therefore recommended to apply the paste only to the screw, not the insert. If zinc chromate primer is applied to the tapped hole it should be thinned and applied sparingly. The insert should be installed while the primer is still wet.
4. Specify a dry film lubricant such as molybdenum disulphide on the inserts. This provides a secondary barrier against corrosion.
5. Where practical or where it will not interfere with the completed assembly, the external joint should be coated with a suitable paint.

MATERIALS

PowerCoil standard inserts are manufactured from fully certified, aircraft quality, 304 (18/8) austenitic stainless steel in accordance with DTD 734A. Alternative materials include 316 stainless steel and a variety of application specific surface coatings.

ALTERNATIVE MATERIALS

Phosphor Bronze

Non ferrous copper/tin alloy in accordance with BS2783 PB 102 EH – is suitable for operation in temperatures ranging from -200ºC to +300ºC.

Inconel X-750

Heat resisting precipitation hardenable nickel base alloy (equivalent specifications SAE AS 7246, DIN/NF 3018, W.NR 2.4669, UNS N07750). Inconel X-750 is suitable for operation in temperatures ranging from -200ºC to +550ºC.

Nimonic 90

Heat resisting precipitation hardenable nickel base alloy in accordance with BS2 HR 501 (equivalent specifications W.NR 2.4632, UNS N07090).

Nimonic 90 is suitable for operation in temperatures ranging from -100ºC to +650ºC.

Insert Material	Max. Temp. Peak	Max. Temp. Cont.	Typical Applications	Coatings
Stainless 304	425ºC 800ºF	315ºC 600ºF	Most general applications in all materials	FL, AG, CD
Stainless 316	425ºC 800ºF	315ºC 600ºF	Increased corrosion resistance for salt water applications	FL, AG, CD
Phosphor Bronze	300ºC 572ºF	235ºC 455ºF	Copper parts, non-magnetic, low permeability applications	AG, CD
Iconel X-750	650ºC 1200ºF	550ºC 1020ºF	Aerospace, turbines, corrosive environments, high temp. use	AG
Nimonic 90	650ºC 1200ºF	550ºC 1020ºF	Aerospace and turbine applications	AG

ALTERNATIVE FINISHES & COATINGS

Cadmium Plate

Electro-deposited Cadmium in accordance with DTD 904/Def Stan 03-19 (equivalent specifications FED. QQ-P-416, LN 9368). Cadmium plating provides an excellent barrier between dissimilar metals dramatically reducing the effects of galvanic corrosion, its high lubricity and excellent corrosion resistance prevents seizure and galling between threaded components. Cadmium plate is suitable for operation in temperatures ranging from -200ºC to +235ºC.

Cadmium plated parts must not be

- subjected to temperatures exceeding 235ºC (455ºF)
- come into contact with fuel or hot oil
- come into contact with food or drinking water
- be used with titanium components (either directly or indirectly). At elevated temperatures embrittlement and subsequent component failure may occur.
- Cadmium is highly toxic – consequently extreme care must be taken when shipping, handling and installing.

Zinc Plate

Electrolytically deposited zinc in accordance with BS 3382. Electro-deposited zinc is the most widely applied electroplated finish in industry. Zinc is suitable for operation in temperatures ranging from -200ºC to +250ºC.

Silver Plate

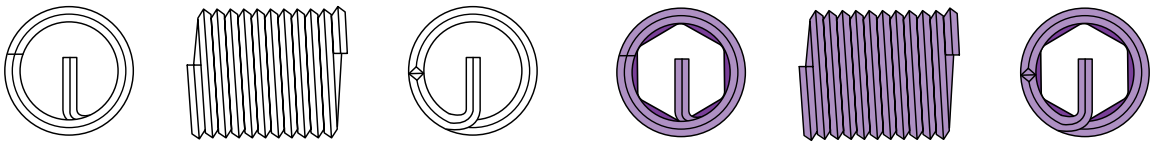
Electrolytically deposited silver in accordance with DTD 939. Silver plating is used to prevent seizure and galling between thread components in high temperature applications and is most commonly applied to aero-engine fasteners. Silver plate is suitable for operation in temperatures ranging from -200ºC to +650ºC. Silver plated wire inserts may be installed in various materials including aluminium alloys, magnesium alloys, corrosion and heat resistant materials etc.

Silver plated inserts are not recommended for installation in titanium alloy which may exceed a service temperature of 300ºC (570ºF). Stress corrosion as a result of the combination of silver and titanium may occur in the housing material.

Dry Film Lubricant

Solid film heat cured molybdenum disulphide dry film lubricant coating in accordance with MIL-L-0046010 provides a low frictional coefficient coating with excellent load bearing capabilities. Dry film lubricant prevents seizing and galling between threaded components and is particularly effective in screw locking insert applications. Dry film lubricant is suitable for operation in temperatures ranging from -100ºC to +250ºC.

powercoil® wire thread insert system



Plating / Finish	Part No. Suffix	Applicable Process Specification
Silver Plating	AG	DTD 939
Cadmium Plating	CD	QQP-416 or DEF STD 03-19
Dry Film Lubricant	FL	MIL-L-8937 or MIL-L-46010
Red Dye	–	Applied to locking inserts for identification purposes*

* other colour dyes may also be utilised for specific identification purposes

SELECTION OF CORRECT INSERT LENGTH

PowerCoil wire thread inserts are available in all popular thread types. Five insert lengths are available for each thread size. It is important to select the correct insert length in order to balance the bolt tensile strength against the shear strength of the parent material. The five insert lengths (recommended thread engagement of the PowerCoil wire thread insert), 1D, 1.5D, 2D, 2.5D and 3D are shown in the shaded area of the table below. These are calculated numbers since the inserts cannot be measured in the free (un-installed) state. The numbers are multiples of the nominal thread size, or diameter, of the insert. The actual insert lengths in the installed position are listed in the insert selection tables. There they represent the actual installed length plus 1/2 pitch. Using the table below, an insert length can be selected which will produce a thread system strong enough to fracture a bolt before it will strip or damage either the parent material or the insert.

Recommended Nominal Insert lengths Based on Parent Material Versus Bolt Material Strengths

UNIFIED (source BS7752 Part 1:1994)

Shear Strength of Parent Material (KSI)	Bolt Material Minimum Ultimate Tensile Strength (KSI)								
	54	75	96	108	125	132	160	180	220
10	2.0	2.5	3.0	3.0	–	–	–	–	–
15	1.5	1.5	2.0	2.5	2.5	3.0	–	–	–
20	1.0	1.5	1.5	2.0	2.0	2.0	2.5	3.0	3.0
25	1.0	1.0	1.5	1.5	1.5	2.0	2.0	2.5	2.5
30	1.0	1.0	1.0	1.5	1.5	1.5	2.0	2.0	2.5
40	1.0	1.0	1.0	1.0	1.0	1.5	1.5	1.5	2.0
50	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.5	1.5

EXAMPLE: If parent material shear strength is 10KSI and the bolt tensile strength is 54 KSI, the correct insert length is 2.0 diameters (2D).

METRIC

Shear Strength of Parent Material (MPa)	Bolt Material Minimum Ultimate Tensile Strength (MPa)							
	300	400	500	600	800	1000	1200	1400
70	1.5	2.0	2.5	2.5	–	–	–	–
100	1.0	1.5	1.5	2.0	2.5	3.0	–	–
150	1.0	1.0	1.5	1.5	2.0	2.0	2.5	3.0
200	1.0	1.0	1.0	1.0	1.5	1.5	2.0	2.5
250	1.0	1.0	1.0	1.0	1.0	1.5	1.5	2.0
300	1.0	1.0	1.0	1.0	1.0	1.5	1.5	1.5
350	1.0	1.0	1.0	1.0	1.0	1.0	1.5	1.5

EXAMPLE: If parent material shear strength is 150Mpa and the bolt tensile strength is 600Mpa, the correct insert length is 1.5 diameters (1.5D).

BOLT PROJECTION

PowerCoil wire thread inserts are designed to be used with standard, readily available bolts and screws that require no special hardware.

The bolt must engage the entire insert length to achieve maximum assembly strength. To ensure against partial engagement, it is recommended that the tang always be removed. This will also guarantee that the locking coil(s) will be engaged by the full threads of the bolt. If design parameters prevent this, contact PowerCoil for assistance.

NOTES:

1. Bolt tensile strengths are specified minimums. When choosing an insert length, consideration should be given the maximum tensile strength allowed by the bolt drawing or procurement specification.
2. Service temperatures can cause significant variations in strength values, therefore compensation should be allowed.
3. The importance of shear values should be kept in mind because the parent material is subject to shearing stress near the major diameter of the tapped threads.
4. When the strength values fall between two values in the tables, use next lower material shear value, or the next higher bolt tensile strength value.
5. To achieve maximum strength, bolt length and thread length as well as full tapped thread depth must be sufficient to assure full thread engagement over the entire length of the insert.

SCREW LOCKING (PREVAILING TORQUE) INSERTS

Screw Locking PowerCoil wire thread inserts are designed for applications subject to the effects of cyclic vibration or impact. The screw locking insert exerts a prevailing torque on male threaded fasteners to prevent loosening due to vibration or impact. They eliminate the need for other, less desirable and costly locking mechanisms. They are excellent in “adjusting screw” applications by preventing the male fastener from creeping.

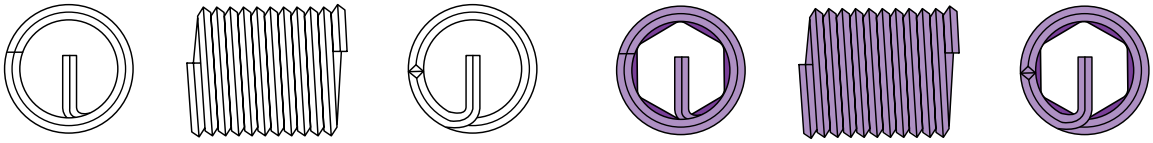
HOW SCREW LOCKING INSERTS WORK

PowerCoil Screw Locking inserts offer the additional security of prevailing locking torque. This is achieved by the action of one or more polygonal grip coils positioned within the insert’s length, which exert radial pressure on the male thread. Each grip coil consists of a number of tangential locking chords that protrude inside the minor diameter of the normal free running coils. As the male thread passes through these grip coils, the locking flats are displaced and exert radial pressure (prevailing torque) on the male thread.

On removal of the male thread, the locking coils relax to their original form permitting repeated assembly whilst retaining a measurable level of prevailing torque.

Please note:

It is recommended that only close fit plated or lubricated bolts or screws are used with screw locking PowerCoil wire thread inserts. When using heat treated unplated or stainless steel bolts, an anti-seize compound, e.g., molybdenum disulfide, must be used in order to minimize galling and assure maximum cycle life. Wear life of screw or bolt using PowerCoil screw locking wire thread inserts can also be improved by specifying dry film lubrication or cadmium plating.



LOCATION OF LOCKING COILS

For 1D, 1.5D, and 2D diameter lengths: The center of the locking coil (or coils) equals 1/2 the number of free coils. For 2.5D and 3D diameter lengths: The locking coil is located the same distance from the tang as 2D length inserts.

Screw locking inserts are dyed red for easy identification purposes only. It is alcohol soluble and can be removed if desired.

RED DYE COATING

PowerCoil screw locking inserts are generally colour coded with an organic red dye for identification purposes. The dye does not affect the installation or performance of the insert and does not need to be removed (in most situations). In situations requiring extreme cleanliness (such as assembly of precision instruments in clean room conditions) the dye may be removed by soaking the inserts in a denatured alcohol solution prior to installation.

POWERCOIL LOCKING INSERT TORQUE VALUES

METRIC COARSE

Thread mm x mm	Torque Max (Nm)	Torque Min (Nm)
M2.2x0.45	0.14	0.02
M2.5x0.45	0.23	0.05
M3.0x0.50	0.45	0.10
M3.5x0.60	0.68	0.12
M4.0x0.70	0.90	0.15
M5.0x0.80	1.60	0.30
M6.0x1.00	3.00	0.40
M7.0x1.00	4.50	0.60
M8.0x1.25	6.00	0.80
M10.0x1.50	10.50	1.40
M12.0x1.75	15.50	2.10
M14.0x2.00	23.50	3.00
M16.0x2.00	31.50	4.20
M18.0x2.50	42.00	5.50
M20.0x2.50	54.00	7.00
M22.0x2.50	67.50	9.00
M24.0x3.00	80.00	10.50
M27.0x3.00	94.00	12.00
M30.0x3.50	108.00	14.00
M33.0x3.50	122.00	15.50
M36.0x4.00	136.00	17.50
M39.0x4.00	150.00	19.50

METRIC FINE

Thread mm x mm	Torque Max (Nm)	Torque Min (Nm)
M8.0x1.00	6.00	0.80
M10.0x1.00	10.50	1.40
M10.0x1.25	10.50	1.40
M12.0x1.25	15.50	2.10
M12.0x1.50	15.50	2.10
M14.0x1.50	23.50	3.00
M16.0x1.50	31.50	4.20
M18.0x1.50	42.00	5.50
M20.0x1.50	54.00	7.00
M22.0x1.50	67.50	9.00
M18.0x2.00	42.00	5.50
M20.0x2.00	54.00	7.00
M22.0x2.00	67.50	9.00
M24.0x2.00	80.00	10.50
M27.0x2.00	94.00	12.00
M30.0x2.00	108.00	14.00
M33.0x2.00	122.00	15.50
M36.0x2.00	136.00	17.50
M39.0x2.00	150.00	19.50
M36.0x3.00	136.00	17.50

Locking torque values conform to MP3329, MP3330, MP3331

UNIFIED NATIONAL COARSE – UNC

Thread inch x tpi	Torque Max (lb in)	Torque Min (lb in)
2x56	1.25	0.19
3x48	2.00	0.44
4x40	3.00	0.63
5x40	4.69	0.81
6x32	6.00	1.00
8x32	9.00	1.50
10x24	13.00	2.00
12x24	24.00	3.00
1/4x20	30.00	4.50
5/16x18	60.00	7.50
3/8x18	80.00	12.00
7/16x14	100.00	16.50
1/2x13	150.00	24.00
9/16x12	200.00	30.00
5/8x11	300.00	40.00
3/4x10	400.00	60.00
7/8x9	600.00	82.00
1x8	800.00	110.00
11/8x7	900.00	137.00
11/4x7	1000.00	165.00
13/8x6	1150.00	185.00
11/2x6	1350.00	210.00

UNIFIED NATIONAL FINE – UNF

Thread inch x tpi	Torque Max (lb in)	Torque Min (lb in)
3x56	0.13	0.44
4x48	0.19	0.63
6x40	6.00	1.00
8x36	9.00	1.50
10x32	13.00	2.00
1/4x28	30.00	3.50
5/16x24	60.00	6.50
3/8x24	80.00	9.50
7/16x20	100.00	14.00
1/2x20	150.00	18.00
9/16x18	200.00	24.00
5/8x18	300.00	32.00
3/4x16	400.00	50.00
7/8x14	600.00	70.00
1x12	800.00	90.00
11/8x12	900.00	117.00
11/4x12	1000.00	143.00
13/8x12	1150.00	165.00
11/2x12	1350.00	190.00

Locking torque values conform to NASM8846

Note: It is also essential that the bolt fully engages all insert coils for maximum strength.

PowerCoil screw locking inserts can be designed to suit a customer's specific needs. In certain instances and appllications prevailing torque can be lessened or increased to cater for a specific application. In these situations please contact your PowerCoil representative to discuss your specific requirements.

Please Note: Installation of PowerCoil screw locking inserts requires the use of a pre-winder tool. Please discuss other installation options with your PowerCoil agent.

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MC

METRIC COARSE

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
2.00	0.40	1.5D	3.00MM	**110.86**	3520-2.00K	20	2.1	3520-2.00I	3500-HIT2	3500-TB1
2.20	0.45	1.5D	3.30MM	**106.14**	3520-2.20K	20	2.3	3520-2.20I	3500-HIT2	3500-TB2
2.50	0.45	1.5D	3.75MM	**79.49**	3520-2.50K	20	2.6	3520-2.50I	3500-HIT3	3500-TB3
3.00	0.50	1.5D	4.50MM	**79.37**	3520-3.00K	20	3.2	3520-3.00I	3500-HIT4	3500-TB4
3.50	0.60	1.5D	5.25MM	**80.08**	3520-3.50K	20	3.7	3520-3.50I	3500-HIT5	3500-TB5
4.00	0.70	1.5D	6.00MM	**65.75**	3520-4.00K	20	4.2	3520-4.00I	3500-HIT6	3500-TB6
5.00	0.80	1.5D	7.50MM	**57.03**	3520-5.00K	20	5.2	3520-5.00I	3500-HIT8	3500-TB8
6.00	1.00	1.5D	9.00MM	**58.43**	3520-6.00K	20	6.3	3520-6.00I	3500-HIT9	3500-TB9
7.00	1.00	1.5D	10.50MM	**72.06**	3520-7.00K	20	7.3	3520-7.00I	3500-HIT10	3500-TB11
8.00	1.25	1.5D	12.00MM	**70.64**	3520-8.00K	20	8.3	3520-8.00I	3500-HIT11	3500-TB12
9.00	1.25	1.5D	13.50MM	**83.56**	3520-9.00K	15	9.4	3520-9.00I	3500-HIT13	3500-TB12
10.00	1.50	1.5D	15.00MM	**89.33**	3520-10.00K	15	10.4	3520-10.00I	3500-HIT13	3500-TB13
11.00	1.50	1.5D	16.50MM	**111.80**	3520-11.00K	10	11.4	3520-11.00I	3500-HIT14	3500-TB14
12.00	1.75	1.5D	18.00MM	**116.47**	3520-12.00K	10	12.4	3520-12.00I	3500-HIT15	3500-TB15
13.00	1.75	1.5D	19.50MM	**106.14**	3520-13.00K	10	13.5*	3520-13.00I	3500-HIT15	–
14.00	2.00	1.5D	21.00MM	**120.12**	3520-14.00K	10	14.5*	3520-14.00I	3500-HIT16	–
15.00	2.00	1.5D	22.50MM	**129.73**	3520-15.00K	10	15.5*	3520-15.00I	3500-HIT16	–
16.00	2.00	1.5D	24.00MM	**139.87**	3520-16.00K	10	16.5*	3520-16.00I	3500-HIT18	–
18.00	2.50	1.5D	27.00MM	**188.70**	3520-18.00K	5	18.5*	3520-18.00I	3500-HIT20	–
20.00	2.50	1.5D	30.00MM	**224.08**	3520-20.00K	5	20.8*	3520-20.00I	3500-HIT21	–
22.00	2.50	1.5D	33.00MM	**265.36**	3520-22.00K	5	22.8*	3520-22.00I	3500-HIT22	–
24.00	3.00	1.5D	36.00MM	**336.12**	3520-24.00K	5	25.0*	3520-24.00I	3500-HIT23	–
27.00	3.00	1.5D	40.50MM	**414.37**	3520-27.00K	5	28.0*	3520-27.00I	3500-HIT24	–
30.00	3.50	1.5D	45.00MM	**516.45**	3520-30.00K	5	31.0*	3520-30.00I	3500-HIT25	–
33.00	3.50	1.5D	49.50MM	**550.98**	3520-33.00K	5	34.0*	3520-33.00I	3500-HIT26	–
36.00	4.00	1.5D	54.00MM	**552.77**	3520-36.00K	5	37.0*	3520-36.00I	3500-HIT28	–

IMPORTANT

It is recommended that when repairing the thread on spark plug ports that you remove the head.

If you do not remove the head it is essential that you protect the engine from the ingress of chips and swarf generated by the tapping process.

* Tapping drill not included in thread repair kit.

Some large repair kits over 24mm may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

SPARK PLUG

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
10.00	1.00	–	1/2"	**97.89**	3522-10.00K	5	–	3520-10.00PN	3500-HIT13	3500-TB13
–	–	–	0.339"	–	–	5	–	–	–	–
12.00	1.25	–	1/2"	**113.22**	3522-12.00K	5	–	3520-10.00PN	3500-HIT15	3500-TB15
–	–	–	3/4"	–	–	5	–	–	–	–
14.00	1.25	–	3/8"	**102.61**	3522-14.00K	5	–	3522-14.00PN	3500-HIT17	–
–	–	–	1/2"	–	–	5	–	–	–	–
–	–	–	3/4"	–	–	5	–	–	–	–
14.00	1.25	8.4MM	–	**122.65**	3522-14.00K1	5	–	3522-14.00PN	3500-HIT17	–
–	–	12.4MM	–	–	–	5	–	–	–	–
–	–	16.4MM	–	–	–	5	–	–	–	–
18.00	1.50	–	1/2"	**206.39**	3522-18.00K	5	–	3522-18.00PN	3500-HIT20	–

STI Pilot Nose Taps are used to repair damaged threads and do not require the drilling of a pilot hole.

These taps use the existing thread as a guide in tapping a straight hole. STI Pilot Nose Taps are most commonly used to tap holes for the repair of spark plug threads.

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

METRIC FINE

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
8.00	1.00	1.5D	12.00MM	**78.90**	3521-8.00K	20	8.3	3521-8.00I	3500-HIT11	3500-TB12
10.00	1.25	1.5D	15.00MM	**93.46**	3521-10.00K	15	10.3	3521-10.00I	3500-HIT13	3500-TB13
10.00	1.00	1.5D	15.00MM	**94.65**	3523-10.00K	15	10.3	3523-10.00I	3500-HIT13	3500-TB13
11.00	1.25	1.5D	16.50MM	**111.80**	3521-11.00K	10	11.3	3521-11.00I	3500-HIT14	3500-TB14
11.00	1.00	1.5D	16.50MM	**111.80**	3523-11.00K	10	11.3	3523-11.00I	3500-HIT14	3500-TB14
12.00	1.50	1.5D	18.00MM	**118.82**	3521-12.00K	10	12.4	3521-12.00I	3500-HIT15	3500-TB15
12.00	1.25	1.5D	18.00MM	**120.59**	3523-12.00K	10	12.3	3523-12.00I	3500-HIT15	3500-TB15
12.00	1.00	1.5D	18.00MM	**182.81**	3524-12.00K	10	12.3	3524-12.00I	3500-HIT15	3500-TB15
13.00	1.50	1.5D	19.50MM	**117.94**	3521-13.00K	10	13.2*	3521-13.00I	3500-HIT15	–
13.00	1.25	1.5D	19.50MM	**129.73**	3523-13.00K	10	13.2*	3523-13.00I	3500-HIT15	–
14.00	1.50	1.5D	21.00MM	**123.66**	3521-14.00K	10	14.4*	3521-14.00I	3500-HIT16	–
14.00	1.25	1.5D	21.00MM	**123.66**	3523-14.00K	10	14.3*	3523-14.00I	3500-HIT16	–
14.00	1.00	1.5D	21.00MM	**188.70**	3524-14.00K	10	14.3*	3524-14.00I	3500-HIT16	–
15.00	1.50	1.5D	22.50MM	**135.63**	3521-15.00K	10	15.3*	3521-15.00I	3500-HIT16	–
16.00	1.50	1.5D	24.00MM	**146.95**	3521-16.00K	10	16.5*	3521-16.00I	3500-HIT18	–
18.00	2.00	1.5D	27.00MM	**200.49**	3521-18.00K	5	18.5*	3521-18.00I	3500-HIT20	–
18.00	1.50	1.5D	27.00MM	**200.49**	3523-18.00K	5	18.5*	3523-18.00I	3500-HIT20	–
20.00	2.00	1.5D	30.00MM	**229.97**	3521-20.00K	5	20.5*	3521-20.00I	3500-HIT21	–
20.00	1.50	1.5D	30.00MM	**229.97**	3523-20.00K	5	20.5*	3523-20.00I	3500-HIT21	–
22.00	2.00	1.5D	33.00MM	**271.26**	3521-22.00K	5	22.5*	3521-22.00I	3500-HIT22	–
22.00	1.50	1.5D	33.00MM	**271.26**	3523-22.00K	5	22.5*	3523-22.00I	3500-HIT22	–
24.00	2.00	1.5D	36.00MM	**377.39**	3521-24.00K	5	24.5*	3521-24.00I	3500-HIT23	–
24.00	1.50	1.5D	36.00MM	**377.39**	3523-24.00K	5	24.5*	3523-24.00I	3500-HIT23	–
26.00	1.50	1.5D	39.00MM	**414.37**	3523-26.00K	5	26.5*	3523-26.00I	3500-HIT24	–
27.00	2.00	1.5D	40.50MM	**414.37**	3521-27.00K	5	27.5*	3521-27.00I	3500-HIT24	–
27.00	1.50	1.5D	40.50MM	**414.37**	3523-27.00K	5	27.5*	3523-27.00I	3500-HIT24	–
28.00	1.50	1.5D	42.00MM	**507.57**	3523-28.00K	5	28.5*	3523-28.00I	3500-HIT24	–
30.00	2.00	1.5D	45.00MM	**536.87**	3521-30.00K	5	30.5*	3521-30.00I	3500-HIT26	–
30.00	1.50	1.5D	45.00MM	**536.87**	3523-30.00K	5	30.5*	3523-30.00I	3500-HIT26	–
33.00	2.00	1.5D	49.50MM	**550.98**	3521-33.00K	5	33.5*	3521-33.00I	3500-HIT26	–
36.00	3.00	1.5D	54.00MM	**552.77**	3521-36.00K	3	37.0*	3521-36.00I	3500-HIT28	–
36.00	2.00	1.5D	54.00MM	**552.77**	3523-36.00K	3	36.5*	3523-36.00I	3500-HIT28	–
36.00	1.50	1.5D	54.00MM	**552.77**	3524-36.00K	3	36.5*	3524-36.00I	3500-HIT28	–

* Tapping drill not included in thread repair kit.

Some large repair kits over 24mm may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

Bulk Free Running Inserts
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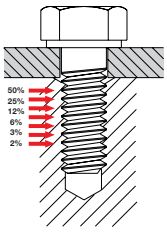
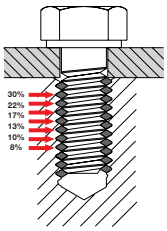
MF

Standard Bolt



Bolt with PowerCoil insert



In a conventional threaded joint 75% of the load is placed on the first three threads.

The helical coil design of the PowerCoil Wire Thread Insert allows the shear loading to be transformed into a more desirable radial loading (hoop stress) over the entire length of the insert.

Use of a PowerCoil insert results in a far stronger thread than can be obtained by using conventional drilling or tapping. Improved strength allows designers to select fasteners based on minimum bolt strength and allows the use of smaller diameters and thread lengths - even in magnesium and aluminium alloys.

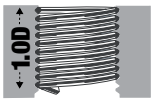
powercoil® wire thread insert system

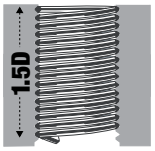
BORDO® INDUSTRIAL TOOLS

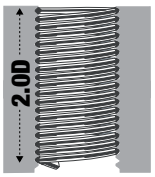
GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

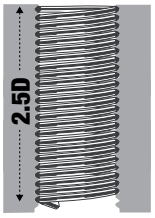
UNC
UNF

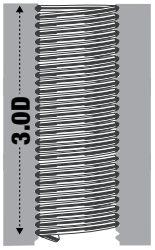
1.0D











UNC

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
2G	56	1.5D	0.13"	**75.83**	3532-2GK	20	2.4	3532-2GI	3500-HIT2	3500-TB2
3G	48	1.5D	0.15"	**75.83**	3532-3GK	20	2.7	3532-3GI	3500-HIT3	3500-TB3
4G	40	1.5D	0.17"	**73.42**	3532-4GK	20	3.1	3532-4GI	3500-HIT4	3500-TB4
5G	40	1.5D	0.19"	**73.71**	3532-5GK	20	3.4	3532-5GI	3500-HIT4	3500-TB4
6G	32	1.5D	0.21"	**70.11**	3532-6GK	20	3.8	3532-6GI	3500-HIT5	3500-TB5
8G	32	1.5D	0.25"	**70.41**	3532-8GK	20	4.4	3532-8GI	3500-HIT6	3500-TB6
10G	24	1.5D	0.28"	**65.22**	3532-10GK	20	5.2	3532-10GI	3500-HIT7	3500-TB8
12G	24	1.5D	0.33"	**66.34**	3532-12GK	20	5.8	3532-12GI	3500-HIT8	3500-TB8
1/4	20	1.5D	0.38"	**61.20**	3532-1/4K	20	6.7	3532-1/4I	3500-HIT9	3500-TB9
5/16	18	1.5D	0.47"	**67.04**	3532-5/16K	20	8.3	3532-5/16I	3500-HIT10	3500-TB12
3/8	16	1.5D	0.56"	**79.19**	3532-3/8K	15	9.9	3532-3/8I	3500-HIT13	3500-TB12
7/16	14	1.5D	0.66"	**92.35**	3532-7/16K	10	11.6	3532-7/16I	3500-HIT14	3500-TB14
1/2	13	1.5D	0.75"	**98.35**	3532-1/2K	10	13.0	3532-1/2I	3500-HIT15	3500-TB15
9/16	12	1.5D	0.84"	**121.47**	3532-9/16K	10	15.0*	3532-9/16I	3500-HIT16	–
5/8	11	1.5D	0.94"	**132.50**	3532-5/8K	10	16.5*	3532-5/8I	3500-HIT18	–
3/4	10	1.5D	1.13"	**182.81**	3532-3/4K	5	19.8*	3532-3/4I	3500-HIT20	–
7/8	9	1.5D	1.31"	**224.08**	3532-7/8K	5	23.0*	3532-7/8I	3500-HIT22	–
1	8	1.5D	1.50"	**267.12**	3532-1K	5	26.2*	3532-1I	3500-HIT23	–
1-1/8	7	1.5D	1.69"	**355.45**	3532-1.1/8K	3	29.5*	3532-1.1/8I	3500-HIT25	–
1-1/4	7	1.5D	1.88"	**432.83**	3532-1.1/4K	3	32.5*	3532-1.1/4I	3500-HIT26	–
1-3/8	6	1.5D	2.06"	**506.77**	3532-1.3/8K	3	36.0*	3532-1.3/8I	3500-HIT27	–
1-1/2	6	1.5D	2.25"	**648.27**	3532-1.1/2K	3	39.5*	3532-1.1/2I	3500-HIT28	–

UNF

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
3G	56	1.5D	0.15"	**75.83**	3534-3GK	20	2.7	3534-3GI	3500-HIT3	3500-TB3
4G	48	1.5D	0.17"	**73.42**	3534-4GK	20	3.0	3534-4GI	3500-HIT4	3500-TB4
6G	40	1.5D	0.21"	**116.11**	3534-6GK	20	3.8	3534-6GI	3500-HIT5	3500-TB5
8G	36	1.5D	0.25"	**116.40**	3534-8GK	20	4.4	3534-8GI	3500-HIT6	3500-TB6
10G	32	1.5D	0.28"	**64.98**	3534-10GK	20	5.1	3534-10GI	3500-HIT8	3500-TB8
12G	28	1.5D	0.33"	**66.34**	3534-12GK	20	5.6	3534-12GI	3500-HIT8	3500-TB8
1/4	28	1.5D	0.38"	**61.20**	3534-1/4K	20	6.7	3534-1/4I	3500-HIT9	3500-TB9
5/16	24	1.5D	0.47"	**67.04**	3534-5/16K	20	8.3	3534-5/16I	3500-HIT11	3500-TB12
3/8	24	1.5D	0.56"	**79.19**	3534-3/8K	15	9.8	3534-3/8I	3500-HIT13	3500-TB13
7/16	16	1.5D	0.66"	**122.48**	3534-7/16-16K	10	11.5	3534-7/16-16I	3500-HIT14	3500-TB14
7/16	20	1.5D	0.66"	**94.23**	3534-7/16K	10	11.5	3534-7/16I	3500-HIT14	3500-TB14
1/2	20	1.5D	0.75"	**107.03**	3534-1/2K	10	13.0	3534-1/2I	3500-HIT15	3500-TB15
9/16	18	1.5D	0.84"	**121.47**	3534-9/16K	10	14.7*	3534-9/16I	3500-HIT16	–
5/8	18	1.5D	0.94"	**132.50**	3534-5/8K	10	16.3*	3534-5/8I	3500-HIT18	–
3/4	16	1.5D	1.13"	**182.81**	3534-3/4K	5	19.5*	3534-3/4I	3500-HIT21	–
7/8	14	1.5D	1.31"	**224.08**	3534-7/8K	5	22.5*	3534-7/8I	3500-HIT22	–
1	12	1.5D	1.50"	**267.12**	3534-1K	5	26.0*	3534-1I	3500-HIT23	–
1	14	1.5D	1.50"	**278.92**	3535-1K	5	26.0*	3535-1I	3500-HIT23	–
1-1/8	12	1.5D	1.69"	**355.45**	3534-1.1/8K	3	29.5*	3534-1.1/8I	3500-HIT25	–
1-1/4	12	1.5D	1.88"	**432.83**	3534-1.1/4K	3	32.5*	3534-1.1/4I	3500-HIT26	–
1-3/8	12	1.5D	2.06"	**506.77**	3534-1.3/8K	3	35.5*	3534-1.3/8I	3500-HIT27	–
1-1/2	12	1.5D	2.25"	**648.27**	3534-1.1/2K	3	38.5*	3534-1.1/2I	3500-HIT28	–

* Tapping drill not included in thread repair kit.

Some large repair kits over 1" may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSW

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/8	40	1.5D	0.19"	**76.89**	3528-1/8K	20	3.4	3528-1/8I	3500-HIT4	3500-TB4
3/16	24	1.5D	0.28"	**66.05**	3528-3/16K	20	5.0	3528-3/16I	3500-HIT7	3500-TB8
1/4	20	1.5D	0.38"	**64.74**	3528-1/4K	20	6.7	3528-1/4I	3500-HIT9	3500-TB9
5/16	18	1.5D	0.47"	**69.52**	3528-5/16K	20	8.3	3528-5/16I	3500-HIT10	3500-TB11
3/8	16	1.5D	0.56"	**81.55**	3528-3/8K	15	9.9	3528-3/8I	3500-HIT11	3500-TB12
7/16	14	1.5D	0.66"	**96.59**	3528-7/16K	10	11.5	3528-7/16I	3500-HIT14	3500-TB14
1/2	12	1.5D	0.75"	**108.27**	3528-1/2K	10	13.0	3528-1/2I	3500-HIT15	3500-TB15
9/16	12	1.5D	0.84"	**123.84**	3528-9/16K	10	14.8*	3528-9/16I	3500-HIT16	–
5/8	11	1.5D	0.94"	**137.98**	3528-5/8K	10	16.7*	3528-5/8I	3500-HIT18	–
3/4	10	1.5D	1.13"	**182.81**	3528-3/4K	5	20.0*	3528-3/4I	3500-HIT20	–
7/8	9	1.5D	1.31"	**222.89**	3528-7/8K	5	23.2*	3528-7/8I	3500-HIT22	–
1	8	1.5D	1.50"	**283.05**	3528-1K	5	26.5*	3528-1I	3500-HIT23	–

BSF

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
3/16	32	1.5D	0.28"	**89.69**	3530-3/16K	20	5.0	3530-3/16I	3500-HIT8	3500-TB6
1/4	26	1.5D	0.38"	**89.45**	3530-1/4K	20	6.6	3530-1/4I	3500-HIT9	3500-TB9
5/16	22	1.5D	0.47"	**95.53**	3530-5/16K	20	8.3	3530-5/16I	3500-HIT11	3500-TB11
3/8	20	1.5D	0.56"	**101.60**	3530-3/8K	15	9.9	3530-3/8I	3500-HIT13	3500-TB12
7/16	18	1.5D	0.66"	**117.40**	3530-7/16K	10	11.5	3530-7/16I	3500-HIT14	3500-TB14
1/2	16	1.5D	0.75"	**140.11**	3530-1/2K	10	13.0	3530-1/2I	3500-HIT15	3500-TB15
9/16	16	1.5D	0.84"	**147.42**	3530-9/16K	10	14.8*	3530-9/16I	3500-HIT16	–
5/8	14	1.5D	0.94"	**183.98**	3530-5/8K	10	16.3*	3530-5/8I	3500-HIT18	–
3/4	12	1.5D	1.13"	**270.07**	3530-3/4K	5	19.5*	3530-3/4I	3500-HIT20	–
7/8	11	1.5D	1.31"	**329.04**	3530-7/8K	5	22.8*	3530-7/8I	3500-HIT22	–
1	10	1.5D	1.50"	**379.17**	3530-1K	5	26.2*	3530-1I	3500-HIT23	–

BSP

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/8	28	1.5D	0.19"	**103.85**	3546-1/8K	10	10.0*	3546-1/8I	3500-HIT14	–
1/4	19	1.5D	0.38"	**135.20**	3546-1/4K	10	13.6*	3546-1/4I	3500-HIT16	–
3/8	19	1.5D	0.56"	**168.41**	3546-3/8K	10	17.1*	3546-3/8I	3500-HIT20	–
1/2	14	1.5D	0.75"	**281.59**	3546-1/2K	10	21.5*	3546-1/2I	3500-HIT23	–
5/8	14	1.5D	0.94"	**346.70**	3546-5/8K	10	23.4*	3546-5/8I	3500-HIT23	–
3/4	14	1.5D	1.13"	**389.34**	3546-3/4K	10	27.0*	3546-3/4I	3500-HIT24	–
7/8	14	1.5D	1.31"	**434.07**	3546-7/8K	5	30.5*	3546-7/8I	3500-HIT27	–
1	11	1.5D	1.50"	**460.77**	3546-1K	5	33.7*	3546-1I	3500-HIT27	–

* Tapping drill not included in thread repair kit.

Some repair kits may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

BSW
BSF
BSP

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

NPT
8-UN
BSC
BA

NPT

INCH	TPI	INSTALLED LENGTH	$	PART #	#		PART #	PART #	PART #
1/16	27	0.271"	**129.73**	3552-1/16K	10	K*	3552-1/16I	3500-HIT10	–
1/8	27	0.273"	**129.73**	3552-1/8K	10	U*	3552-1/8I	3500-HIT13	–
1/4	18	0.394"	**176.90**	3552-1/4K	10	31/64*	3552-1/4I	3500-HIT16	–
3/8	18	0.407"	**247.66**	3552-3/8K	10	5/8*	3552-3/8I	3500-HIT18	–
1/2	14	0.534"	**324.32**	3552-1/2K	10	35/32*	3552-1/2I	3500-HIT22	–
3/4	14	0.553"	**442.26**	3552-3/4K	10	63/64*	3552-3/4I	3500-HIT24	–
1	11.5	0.661"	**613.26**	3552-1K	10	1-1/4*	3552-1I	3500-HIT27	–

Some repair kits may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

8-UN

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1-1/8	8	1.5D	1.69"	**506.48**	3570-1.1/8K	3	28.5*	3570-1.1/8I	3500-HIT25	–
1-1/4	8	1.5D	1.88"	**601.47**	3570-1.1/4K	3	32.0*	3570-1.1/4I	3500-HIT26	–
1-3/8	8	1.5D	2.06"	**744.09**	3570-1.3/8K	3	35.0*	3570-1.3/8I	3500-HIT27	–
1-1/2	8	1.5D	2.25"	**620.26**	3570-1.1/2K	3	38.0*	3570-1.1/2I	3500-HIT28	–
1-5/8	8	1.5D	2.44"	**929.43**	3570-1.5/8K	3	41.0*	3570-1.5/8I	3500-HIT28	–
1-3/4	8	1.5D	2.63"	**1027.40**	3570-1.3/4K	3	44.5*	3570-1.3/4I	3500-HIT28	–
1-7/8	8	1.5D	2.81"	**1211.11**	3570-1.7/8K	3	47.5*	3570-1.7/8I	3500-HIT30	–
2	8	1.5D	3.00"	**1295.48**	3570-2K	3	50.8*	3570-2I	3500-HIT30	–

Some repair kits may be supplied with HIM tools (hex installation mandrels) in place of HIT tools (hand installation tools).

BSC

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/4	26	1.5D	0.38"	**67.92**	3560-1/4K	20	6.6	3560-1/4I	3500-HIT10	3500-TB9
5/16	26	1.5D	0.47"	**78.25**	3560-5/16K	20	8.0	3560-5/16I	3500-HIT11	3500-TB12
3/8	26	1.5D	0.56"	**85.05**	3560-3/8K	15	9.8	3560-3/8I	3500-HIT13	3500-TB13
7/16	26	1.5D	0.66"	**103.19**	3560-7/16K	10	11.1	3560-7/16I	3500-HIT14	3500-TB14
1/2	26	1.5D	0.75"	**117.94**	3560-1/2K	10	12.7	3560-1/2I	3500-HIT15	3500-TB15

BA

	INCH	MM	INCH	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
0	0.236	6.0	0.0394	1.5D	0.35"	**200.49**	3544-0K	20	6.2	3544-0I	3500-HIT9	3500-TB11
2	0.185	4.7	0.0319	1.5D	0.28"	**100.24**	3544-2K	20	4.9	3544-2I	3500-HIT7	3500-TB8
4	0.142	3.6	0.0260	1.5D	0.21"	**100.24**	3544-4K	20	3.8	3544-4I	3500-HIT5	3500-TB5
6	0.110	2.8	0.0209	1.5D	0.17"	**153.32**	3544-6K	20	2.9	3544-6I	3500-HIT3	3500-TB3

* Tapping drill not included in thread repair kit.

BORDO® INDUSTRIAL TOOLS

MC
MF

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

METRIC COARSE M5-M12

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
5.00	0.80	1.5D	7.5MM	**377.39**	3520-WK1	25	5.2	3520-5.00I	3500-HIT8	3500-TB8
6.00	1.00	1.5D	9.0MM			25	6.3	3520-6.00I	3500-HIT9	3500-TB9
8.00	1.25	1.5D	12.0MM			25	8.3	3520-8.00I	3500-HIT11	3500-TB12
10.00	1.50	1.5D	15.0MM			25	10.4	3520-10.00I	3500-HIT13	3500-TB13
12.00	1.75	1.5D	18.0MM			10	12.4	3520-12.00I	3500-HIT15	3500-TB15

METRIC COARSE M6-M12 + M14 SPARK PLUG

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
6.00	1.00	1.5D	9.0MM	**454.05**	3522-WK4	25	6.3	3520-6.00I	3500-HIT9	3500-TB9
8.00	1.25	1.5D	12.0MM			25	8.3	3520-8.00I	3500-HIT11	3500-TB12
10.00	1.50	1.5D	15.0MM			25	10.4	3520-10.00I	3500-HIT13	3500-TB13
12.00	1.75	1.5D	18.0MM			10	12.4	3520-12.00I	3500-HIT15	3500-TB15
14.00	1.25	–	8.4MM			5	–	3522-14.00PN	3500-HIT17	–
14.00	1.25	–	12.4MM			5	–	–	–	–
14.00	1.25	–	16.4MM			5	–	–	–	–

SPARK PLUG

MM	MM	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
10.00	1.00	–	0.339"	**369.46**	3522-WK1	5	–	3522-10.00PN	3500-HIT13	3500-TB13
–	–	–	1/2"			5	–	–	–	–
12.00	1.25	–	1/2"			5	–	3522-12.00PN	3500-HIT15	3500-TB15
–	–	–	3/4"			5	–	–	–	–
14.00	1.25	–	3/8"			5	–	3522-14.00PN	3500-HIT17	–
–	–	–	1/2"			5	–	–	–	–
–	–	–	3/4"			5	–	–	–	–

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

UNC
UNF
BSW
BSF

GROUP	PCRK
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNC 1/4" – UNC 1/2"

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/4	20	1.5D	0.38"	**385.82**	3532-WK1	25	6.7	3532-1/4I	3500-HIT9	3500-TB9
5/16	18	1.5D	0.47"			25	8.3	3532-5/16I	3500-HIT10	3500-TB12
3/8	16	1.5D	0.56"			25	9.9	3532-3/8I	3500-HIT13	3500-TB12
7/16	14	1.5D	0.66"			10	11.6	3532-7/16I	3500-HIT14	3500-TB14
1/2	13	1.5D	0.75"			10	13.0	3532-1/2I	3500-HIT15	3500-TB15

UNF 1/4" – UNF 1/2"

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/4	28	1.5D	0.38"	**385.82**	3534-WK1	25	6.7	3534-1/4I	3500-HIT9	3500-TB9
5/16	24	1.5D	0.47"			25	8.3	3534-5/16I	3500-HIT11	3500-TB12
3/8	24	1.5D	0.56"			25	9.8	3534-3/8I	3500-HIT13	3500-TB13
7/16	20	1.5D	0.66"			10	11.5	3534-7/16I	3500-HIT14	3500-TB14
1/2	20	1.5D	0.75"			10	13.0	3534-1/2I	3500-HIT15	3500-TB15

BSW 1/4" – BSW 1/2"

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/4	20	1.5D	0.38"	**391.55**	3528-WK1	25	6.7	3528-1/4I	3500-HIT9	3500-TB9
5/16	18	1.5D	0.47"			25	8.3	3528-5/16I	3500-HIT10	3500-TB11
3/8	16	1.5D	0.56"			25	9.9	3528-3/8I	3500-HIT11	3500-TB12
7/16	14	1.5D	0.66"			10	11.5	3528-7/16I	3500-HIT14	3500-TB14
1/2	12	1.5D	0.75"			10	13.0	3528-1/2I	3500-HIT15	3500-TB15

BSF 1/4" – BSF 1/2"

INCH	TPI	INSTALLED LENGTH		$	PART #	#	MM	PART #	PART #	PART #
1/4	26	1.5D	0.38"	**509.43**	3530-WK1	25	6.6	3530-1/4I	3500-HIT9	3500-TB9
5/16	22	1.5D	0.47"			25	8.3	3530-5/16I	3500-HIT11	3500-TB11
3/8	20	1.5D	0.56"			25	9.9	3530-3/8I	3500-HIT13	3500-TB12
7/16	18	1.5D	0.66"			10	11.5	3530-7/16I	3500-HIT14	3500-TB14
1/2	16	1.5D	0.75"			10	13.0	3530-1/2I	3500-HIT15	3500-TB15

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BORDO® INDUSTRIAL TOOLS

MC

METRIC COARSE

D		INSTALLED LENGTH		#	1.0D		1.5D		2.0D	
MM	MM				$	PART #	$	PART #	$	PART #
2.00	0.40	**1.0D**	2.00MM	10	**8.41**	3520-2.00X1.0DP	–	–	–	–
2.00	0.40	**1.5D**	3.00MM	10	–	–	**9.26**	3520-2.00X1.5DP	–	–
2.00	0.40	**2.0D**	4.00MM	10	–	–	–	–	**9.83**	3520-2.00X2.0DP
2.20	0.45	**1.0D**	2.20MM	10	**7.58**	3520-2.20X1.0DP	–	–	–	–
2.20	0.45	**1.5D**	3.30MM	10	–	–	**8.14**	3520-2.20X1.5DP	–	–
2.20	0.45	**2.0D**	4.40MM	10	–	–	–	–	**8.41**	3520-2.20X2.0DP
2.50	0.45	**1.0D**	2.50MM	10	**6.88**	3520-2.50X1.0DP	–	–	–	–
2.50	0.45	**1.5D**	3.75MM	10	–	–	**7.32**	3520-2.50X1.5DP	–	–
2.50	0.45	**2.0D**	5.00MM	10	–	–	–	–	**7.70**	3520-2.50X2.0DP
3.00	0.50	**1.0D**	3.00MM	10	**6.88**	3520-3.00X1.0DP	–	–	–	–
3.00	0.50	**1.5D**	4.50MM	10	–	–	**7.32**	3520-3.00X1.5DP	–	–
3.00	0.50	**2.0D**	6.00MM	10	–	–	–	–	**7.70**	3520-3.00X2.0DP
3.50	0.60	**1.0D**	3.50MM	10	**7.29**	3520-3.50X1.0DP	–	–	–	–
3.50	0.60	**1.5D**	5.25MM	10	–	–	**7.84**	3520-3.50X1.5DP	–	–
3.50	0.60	**2.0D**	7.00MM	10	–	–	–	–	**8.41**	3520-3.50X2.0DP
4.00	0.70	**1.0D**	4.00MM	10	**6.88**	3520-4.00X1.0DP	–	–	–	–
4.00	0.70	**1.5D**	6.00MM	10	–	–	**7.32**	3520-4.00X1.5DP	–	–
4.00	0.70	**2.0D**	8.00MM	10	–	–	–	–	**7.70**	3520-4.00X2.0DP
5.00	0.80	**1.0D**	5.00MM	10	**6.88**	3520-5.00X1.0DP	–	–	–	–
5.00	0.80	**1.5D**	7.50MM	10	–	–	**7.32**	3520-5.00X1.5DP	–	–
5.00	0.80	**2.0D**	10.00MM	10	–	–	–	–	**7.70**	3520-5.00X2.0DP
6.00	1.00	**1.0D**	6.00MM	10	**7.53**	3520-6.00X1.0DP	–	–	–	–
6.00	1.00	**1.5D**	9.00MM	10	–	–	**8.25**	3520-6.00X1.5DP	–	–
6.00	1.00	**2.0D**	12.00MM	10	–	–	–	–	**8.70**	3520-6.00X2.0DP
7.00	1.00	**1.0D**	7.00MM	10	**7.70**	3520-7.00X1.0DP	–	–	–	–
7.00	1.00	**1.5D**	10.50MM	10	–	–	**9.02**	3520-7.00X1.5DP	–	–
7.00	1.00	**2.0D**	14.00MM	10	–	–	–	–	**9.93**	3520-7.00X2.0DP
8.00	1.25	**1.0D**	8.00MM	10	**7.96**	3520-8.00X1.0DP	–	–	–	–
8.00	1.25	**1.5D**	12.00MM	10	–	–	**9.02**	3520-8.00X1.5DP	–	–
8.00	1.25	**2.0D**	16.00MM	10	–	–	–	–	**9.93**	3520-8.00X2.0DP
9.00	1.25	**1.0D**	9.00MM	10	**11.20**	3520-9.00X1.0DP	–	–	–	–
9.00	1.25	**1.5D**	13.50MM	10	–	–	**12.67**	3520-9.00X1.5DP	–	–
9.00	1.25	**2.0D**	18.00MM	10	–	–	–	–	**14.45**	3520-9.00X2.0DP
10.00	1.50	**1.0D**	10.00MM	10	**11.20**	3520-10.00X1.0DP	–	–	–	–
10.00	1.50	**1.5D**	15.00MM	10	–	–	**12.67**	3520-10.00X1.5DP	–	–
10.00	1.50	**2.0D**	20.00MM	10	–	–	–	–	**14.45**	3520-10.00X2.0DP
11.00	1.50	**1.0D**	11.00MM	10	**16.37**	3520-11.00X1.0DP	–	–	–	–
11.00	1.50	**1.5D**	16.50MM	10	–	–	**17.69**	3520-11.00X1.5DP	–	–
11.00	1.50	**2.0D**	22.00MM	10	–	–	–	–	**20.64**	3520-11.00X2.0DP
12.00	1.75	**1.0D**	12.00MM	10	**16.37**	3520-12.00X1.0DP	–	–	–	–
12.00	1.75	**1.5D**	18.00MM	10	–	–	**17.69**	3520-12.00X1.5DP	–	–
12.00	1.75	**2.0D**	24.00MM	10	–	–	–	–	**20.64**	3520-12.00X2.0DP
13.00	1.75	**1.0D**	13.00MM	5	**16.39**	3520-13.00X1.0DP	–	–	–	–
13.00	1.75	**1.5D**	19.50MM	5	–	–	**20.99**	3520-13.00X1.5DP	–	–
13.00	1.75	**2.0D**	26.00MM	5	–	–	–	–	**26.26**	3520-13.00X2.0DP
14.00	2.00	**1.0D**	14.00MM	5	**10.93**	3520-14.00X1.0DP	–	–	–	–
14.00	2.00	**1.5D**	21.00MM	5	–	–	**14.01**	3520-14.00X1.5DP	–	–
14.00	2.00	**2.0D**	28.00MM	5	–	–	–	–	**17.51**	3520-14.00X2.0DP
15.00	2.00	**1.0D**	15.00MM	5	**14.01**	3520-15.00X1.0DP	–	–	–	–
15.00	2.00	**1.5D**	22.50MM	5	–	–	**17.25**	3520-15.00X1.5DP	–	–
15.00	2.00	**2.0D**	30.00MM	5	–	–	–	–	**22.11**	3520-15.00X2.0DP

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

MC

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

METRIC COARSE

D		INSTALLED LENGTH		#	1.0D $	1.0D PART #	1.5D $	1.5D PART #	2.0D $	2.0D PART #
MM	MM									
16.00	2.00	**1.0D**	16.00MM	5	**14.01**	3520-16.00X1.0DP	–	–	–	–
16.00	2.00	**1.5D**	24.00MM	5	–	–	**17.25**	3520-16.00X1.5DP	–	–
16.00	2.00	**2.0D**	32.00MM	5	–	–	–	–	**22.11**	3520-16.00X2.0DP
18.00	2.50	**1.0D**	18.00MM	5	**20.03**	3520-18.00X1.0DP	–	–	–	–
18.00	2.50	**1.5D**	27.00MM	5	–	–	**23.58**	3520-18.00X1.5DP	–	–
18.00	2.50	**2.0D**	36.00MM	5	–	–	–	–	**30.95**	3520-18.00X2.0DP
20.00	2.50	**1.0D**	20.00MM	5	**28.01**	3520-20.00X1.0DP	–	–	–	–
20.00	2.50	**1.5D**	30.00MM	5	–	–	**32.43**	3520-20.00X1.5DP	–	–
20.00	2.50	**2.0D**	40.00MM	5	–	–	–	–	**36.86**	3520-20.00X2.0DP
22.00	2.50	**1.0D**	22.00MM	3	**21.23**	3520-22.00X1.0DP	–	–	–	–
22.00	2.50	**1.5D**	33.00MM	3	–	–	**24.33**	3520-22.00X1.5DP	–	–
22.00	2.50	**2.0D**	44.00MM	3	–	–	–	–	**28.31**	3520-22.00X2.0DP
24.00	3.00	**1.0D**	24.00MM	3	**26.53**	3520-24.00X1.0DP	–	–	–	–
24.00	3.00	**1.5D**	36.00MM	3	–	–	**30.07**	3520-24.00X1.5DP	–	–
24.00	3.00	**2.0D**	48.00MM	3	–	–	–	–	**34.49**	3520-24.00X2.0DP

METRIC COARSE

D		INSTALLED LENGTH		#	2.5D $	2.5D PART #	3.0D $	3.0D PART #
MM	MM							
3.00	0.50	**2.5D**	7.50MM	10	**8.30**	3520-3.00X2.5DP	–	–
4.00	0.70	**2.5D**	10.00MM	10	**8.30**	3520-4.00X2.5DP	–	–
4.00	0.70	**3.0D**	12.00MM	10	–	–	**9.28**	3520-4.00X3.0DP
6.00	1.00	**2.5D**	15.00MM	10	**9.39**	3520-6.00X2.5DP	–	–
6.00	1.00	**3.0D**	18.00MM	10	–	–	**10.37**	3520-6.00X3.0DP
7.00	1.00	**3.0D**	21.00MM	10	–	–	**13.37**	3520-7.00X3.0DP
8.00	1.25	**2.5D**	20.00MM	10	**12.36**	3520-8.00X2.5DP	–	–
8.00	1.25	**3.0D**	24.00MM	10	–	–	**12.39**	3520-8.00X3.0DP
9.00	1.25	**3.0D**	27.00MM	10	–	–	**20.64**	3520-9.00X3.0DP
10.00	1.50	**2.5D**	25.00MM	10	**19.37**	3520-10.00X2.5DP	–	–
10.00	1.50	**3.0D**	30.00MM	10	–	–	**20.64**	3520-10.00X3.0DP
12.00	1.75	**2.5D**	30.00MM	10	**24.79**	3520-12.00X2.5DP	–	–
12.00	1.75	**3.0D**	36.00MM	10	–	–	**26.53**	3520-12.00X3.0DP
14.00	2.00	**2.5D**	35.00MM	5	**21.74**	3520-14.00X2.5DP	–	–
14.00	2.00	**3.0D**	42.00MM	5	–	–	**25.22**	3520-14.00X3.0DP
16.00	2.00	**2.5D**	40.00MM	5	**26.53**	3520-16.00X2.5DP	–	–
24.00	3.00	**2.5D**	60.00MM	3	**41.57**	3520-24.00X2.5DP	–	–

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BORDO® INDUSTRIAL TOOLS

MF

METRIC FINE

D		INSTALLED LENGTH		#	1.0D		1.5D		2.0D	
MM	MM				$	PART #	$	PART #	$	PART #
6.00	0.75	**1.0D**	6.00	10	**7.53**	3521-6.00X1.0DP	–	–	–	–
6.00	0.75	**1.5D**	9.00	10	–	–	**8.25**	3521-6.00X1.5DP	–	–
6.00	0.75	**2.0D**	12.00	10	–	–	–	–	**8.70**	3521-6.00X2.0DP
8.00	1.00	**1.0D**	8.00	10	**7.96**	3521-8.00X1.0DP	–	–	–	–
8.00	1.00	**1.5D**	12.00	10	–	–	**9.02**	3521-8.00X1.5DP	–	–
8.00	1.00	**2.0D**	16.00	10	–	–	–	–	**9.93**	3521-8.00X2.0DP
8.00	0.75	**1.0D**	8.00	10	**11.20**	3523-8.00X1.0DP	–	–	–	–
8.00	0.75	**1.5D**	12.00	10	–	–	**12.67**	3523-8.00X1.5DP	–	–
8.00	0.75	**2.0D**	16.00	10	–	–	–	–	**14.45**	3523-8.00X2.0DP
9.00	1.00	**1.0D**	9.00	10	**11.20**	3521-9.00X1.0DP	–	–	–	–
9.00	1.00	**1.5D**	13.50	10	–	–	**12.67**	3521-9.00X1.5DP	–	–
9.00	1.00	**2.0D**	18.00	10	–	–	–	–	**14.45**	3521-9.00X2.0DP
10.00	1.25	**1.0D**	10.00	10	**11.20**	3521-10.00X1.0DP	–	–	–	–
10.00	1.25	**1.5D**	15.00	10	–	–	**12.67**	3521-10.00X1.5DP	–	–
10.00	1.25	**2.0D**	20.00	10	–	–	–	–	**14.45**	3521-10.00X2.0DP
10.00	1.00	**1.0D**	10.00	10	**11.20**	3523-10.00X1.0DP	–	–	–	–
10.00	1.00	**1.5D**	15.00	10	–	–	**12.67**	3523-10.00X1.5DP	–	–
10.00	1.00	**2.0D**	20.00	10	–	–	–	–	**14.45**	3523-10.00X2.0DP
11.00	1.25	**1.0D**	11.00	10	**16.37**	3521-11.00X1.0DP	–	–	–	–
11.00	1.25	**1.5D**	16.50	10	–	–	**17.69**	3521-11.00X1.5DP	–	–
11.00	1.25	**2.0D**	22.00	10	–	–	–	–	**20.64**	3521-11.00X2.0DP
11.00	1.00	**1.0D**	11.00	10	**16.37**	3523-11.00X1.0DP	–	–	–	–
11.00	1.00	**1.5D**	16.50	10	–	–	**17.69**	3523-11.00X1.5DP	–	–
11.00	1.00	**2.0D**	22.00	10	–	–	–	–	**20.64**	3523-11.00X2.0DP
12.00	1.50	**1.0D**	12.00	10	**16.37**	3521-12.00X1.0DP	–	–	–	–
12.00	1.50	**1.5D**	18.00	10	–	–	**17.69**	3521-12.00X1.5DP	–	–
12.00	1.50	**2.0D**	24.00	10	–	–	–	–	**20.64**	3521-12.00X2.0DP
12.00	1.25	**1.0D**	12.00	10	**16.37**	3523-12.00X1.0DP	–	–	–	–
12.00	1.25	**1.5D**	18.00	10	–	–	**17.69**	3523-12.00X1.5DP	–	–
12.00	1.25	**2.0D**	24.00	10	–	–	–	–	**20.64**	3523-12.00X2.0DP
12.00	1.00	**1.0D**	12.00	10	**17.69**	3524-12.00X1.0DP	–	–	–	–
12.00	1.00	**1.5D**	18.00	10	–	–	**24.77**	3524-12.00X1.5DP	–	–
12.00	1.00	**2.0D**	24.00	10	–	–	–	–	**31.25**	3524-12.00X2.0DP
13.00	1.50	**1.0D**	13.00	5	**16.39**	3521-13.00X1.0DP	–	–	–	–
13.00	1.50	**1.5D**	19.50	5	–	–	**20.99**	3521-13.00X1.5DP	–	–
13.00	1.50	**2.0D**	26.00	5	–	–	–	–	**26.26**	3521-13.00X2.0DP
13.00	1.25	**1.0D**	13.00	5	**16.39**	3523-13.00X1.0DP	–	–	–	–
13.00	1.25	**1.5D**	19.50	5	–	–	**20.99**	3523-13.00X1.5DP	–	–
13.00	1.25	**2.0D**	26.00	5	–	–	–	–	**26.26**	3523-13.00X2.0DP
14.00	1.50	**1.0D**	14.00	5	**10.93**	3521-14.00X1.0DP	–	–	–	–
14.00	1.50	**1.5D**	21.00	5	–	–	**14.01**	3521-14.00X1.5DP	–	–
14.00	1.50	**2.0D**	28.00	5	–	–	–	–	**17.51**	3521-14.00X2.0DP
14.00	1.25	**1.0D**	14.00	5	**10.91**	3523-14.00X1.0DP	–	–	–	–
14.00	1.25	**1.5D**	21.00	5	–	–	**14.01**	3523-14.00X1.5DP	–	–
14.00	1.25	**2.0D**	28.00	5	–	–	–	–	**20.64**	3523-14.00X2.0DP
14.00	1.00	**1.0D**	14.00	5	**11.79**	3524-14.00X1.0DP	–	–	–	–
14.00	1.00	**1.5D**	21.00	5	–	–	**13.27**	3524-14.00X1.5DP	–	–
14.00	1.00	**2.0D**	28.00	5	–	–	–	–	**20.64**	3524-14.00X2.0DP
15.00	1.50	**1.0D**	15.00	5	**14.01**	3521-15.00X1.0DP	–	–	–	–
15.00	1.50	**1.5D**	22.50	5	–	–	**17.25**	3521-15.00X1.5DP	–	–
15.00	1.50	**2.0D**	30.00	5	–	–	–	–	**22.11**	3521-15.00X2.0DP

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

MF

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

METRIC FINE

D					1.0D		1.5D		2.0D	
MM	MM	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
16.00	1.50	**1.0D**	16.00MM	5	**14.01**	3521-16.00X1.0DP	–	–	–	–
16.00	1.50	**1.5D**	24.00MM	5	–	–	**17.25**	3521-16.00X1.5DP	–	–
16.00	1.50	**2.0D**	32.00MM	5	–	–	–	–	**22.11**	3521-16.00X2.0DP
18.00	2.00	**1.0D**	18.00MM	5	**20.03**	3521-18.00X1.0DP	–	–	–	–
18.00	2.00	**1.5D**	27.00MM	5	–	–	**23.58**	3521-18.00X1.5DP	–	–
18.00	2.00	**2.0D**	36.00MM	5	–	–	–	–	**30.95**	3521-18.00X2.0DP
18.00	1.50	**1.0D**	18.00MM	5	**20.03**	3523-18.00X1.0DP	–	–	–	–
18.00	1.50	**1.5D**	27.00MM	5	–	–	**23.58**	3523-18.00X1.5DP	–	–
18.00	1.50	**2.0D**	36.00MM	5	–	–	–	–	**30.95**	3523-18.00X2.0DP
20.00	2.00	**1.0D**	20.00MM	5	**28.01**	3521-20.00X1.0DP	–	–	–	–
20.00	2.00	**1.5D**	30.00MM	5	–	–	**32.43**	3521-20.00X1.5DP	–	–
20.00	2.00	**2.0D**	40.00MM	5	–	–	–	–	**36.86**	3521-20.00X2.0DP
20.00	1.50	**1.0D**	20.00MM	5	**28.01**	3523-20.00X1.0DP	–	–	–	–
20.00	1.50	**1.5D**	30.00MM	5	–	–	**32.43**	3523-20.00X1.5DP	–	–
20.00	1.50	**2.0D**	40.00MM	5	–	–	–	–	**36.86**	3523-20.00X2.0DP
20.00	1.25	**1.5D**	30.00MM	5	–	–	**40.55**	3524-20.00X1.5DP	–	–
22.00	2.00	**1.0D**	22.00MM	3	**21.23**	3521-22.00X1.0DP	–	–	–	–
22.00	2.00	**1.5D**	33.00MM	3	–	–	**24.33**	3521-22.00X1.5DP	–	–
22.00	2.00	**2.0D**	44.00MM	3	–	–	–	–	**28.31**	3521-22.00X2.0DP
22.00	1.50	**1.0D**	22.00MM	3	**21.23**	3523-22.00X1.0DP	–	–	–	–
22.00	1.50	**1.5D**	33.00MM	3	–	–	**24.33**	3523-22.00X1.5DP	–	–
22.00	1.50	**2.0D**	44.00MM	3	–	–	–	–	**28.31**	3523-22.00X2.0DP
24.00	2.00	**1.0D**	24.00MM	3	**26.53**	3521-24.00X1.0DP	–	–	–	–
24.00	2.00	**1.5D**	36.00MM	3	–	–	**30.07**	3521-24.00X1.5DP	–	–
24.00	2.00	**2.0D**	48.00MM	3	–	–	–	–	**34.49**	3521-24.00X2.0DP
24.00	1.50	**1.0D**	24.00MM	3	**26.53**	3523-24.00X1.0DP	–	–	–	–
24.00	1.50	**1.5D**	36.00MM	3	–	–	**30.07**	3523-24.00X1.5DP	–	–
24.00	1.50	**2.0D**	48.00MM	3	–	–	–	–	**34.49**	3523-24.00X2.0DP

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

SPARK PLUG

D	MM	INST LENGTH	#	$	0.339" PART #	$	1/2" PART #	$	3/4" PART #
10.00	1.00	**0.339"**	10	**11.45**	3522-10.00X.339P	–	–	–	–
10.00	1.00	**1/2"**	10	–	–	**12.96**	3522-10.00X1/2P	–	–
12.00	1.25	**1/2"**	10	–	–	**16.70**	3522-12.00X1/2P	–	–
12.00	1.25	**3/4"**	10	–	–	–	–	**17.69**	3522-12.00X3/4P
18.00	1.25	**1/2"**	10	–	–	**13.84**	3522-18.00X1/2P	–	–

SPARK PLUG

D	MM	INST LENGTH	#	$	3/8" PART #	$	7/16" PART #	$	1/2" PART #	$	3/4" PART #
14.00	1.25	**3/8"**	10	**9.78**	3522-14.00X3/8P	–	–	–	–	–	–
14.00	1.25	**7/16"**	10	–	–	**12.50**	3522-14.00X7/16P	–	–	–	–
14.00	1.25	**1/2"**	10	–	–	–	–	**14.90**	3522-14.00X1/2P	–	–
14.00	1.25	**3/4"**	10	–	–	–	–	–	–	**19.57**	3522-14.00X3/4P

SPARK PLUG

D	MM	INST LENGTH	#	$	8.4mm PART #	$	12.4mm PART #	$	16.4mm PART #
14	1.25	**8.4MM**	10	**9.93**	3522-14.00X8.4P	–	–	–	–
14	1.25	**12.4MM**	10	–	–	**15.39**	3522-14.00X12.4P	–	–
14	1.25	**16.4MM**	10	–	–	–	–	**21.07**	3522-14.00X16.4P

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

UNC

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNC

					1.0D		1.5D		2.0D	
INCH	TPI	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
2G	56	**1.0D**	0.09"	10	**8.84**	3532-2GX1.0DP	–	–	–	–
2G	56	**1.5D**	0.13"	10	–	–	**9.59**	3532-2GX1.5DP	–	–
2G	56	**2.0D**	0.17"	10	–	–	–	–	**10.03**	3532-2GX2.0DP
3G	48	**1.0D**	0.10"	10	**14.74**	3532-3GX1.0DP	–	–	–	–
3G	48	**1.5D**	0.15"	10	–	–	**15.92**	3532-3GX1.5DP	–	–
3G	48	**2.0D**	0.20"	10	–	–	–	–	**16.81**	3532-3GX2.0DP
4G	40	**1.0D**	0.11"	10	**6.78**	3532-4GX1.0DP	–	–	–	–
4G	40	**1.5D**	0.17"	10	–	–	**7.22**	3532-4GX1.5DP	–	–
4G	40	**2.0D**	0.22"	10	–	–	–	–	**7.67**	3532-4GX2.0DP
5G	40	**1.0D**	0.13"	10	**6.78**	3532-5GX1.0DP	–	–	–	–
5G	40	**1.5D**	0.19"	10	–	–	**7.22**	3532-5GX1.5DP	–	–
5G	40	**2.0D**	0.25"	10	–	–	–	–	**7.67**	3532-5GX2.0DP
6G	32	**1.0D**	0.14"	10	**6.78**	3532-6GX1.0DP	–	–	–	–
6G	32	**1.5D**	0.21"	10	–	–	**7.22**	3532-6GX1.5DP	–	–
6G	32	**2.0D**	0.28"	10	–	–	–	–	**7.67**	3532-6GX2.0DP
8G	32	**1.0D**	0.16"	10	**6.78**	3532-8GX1.0DP	–	–	–	–
8G	32	**1.5D**	0.25"	10	–	–	**7.22**	3532-8GX1.5DP	–	–
8G	32	**2.0D**	0.33"	10	–	–	–	–	**7.67**	3532-8GX2.0DP
10G	24	**1.0D**	0.19"	10	**6.78**	3532-10GX1.0DP	–	–	–	–
10G	24	**1.5D**	0.29"	10	–	–	**7.22**	3532-10GX1.5DP	–	–
10G	24	**2.0D**	0.38"	10	–	–	–	–	**7.67**	3532-10GX2.0DP
12G	24	**1.0D**	0.22"	10	**7.82**	3532-12GX1.0DP	–	–	–	–
12G	24	**1.5D**	0.32"	10	–	–	**8.12**	3532-12GX1.5DP	–	–
12G	24	**2.0D**	0.43"	10	–	–	–	–	**9.14**	3532-12GX2.0DP
1/4	20	**1.0D**	0.25"	10	**7.82**	3532-1/4X1.0DP	–	–	–	–
1/4	20	**1.5D**	0.38"	10	–	–	**8.12**	3532-1/4X1.5DP	–	–
1/4	20	**2.0D**	0.50"	10	–	–	–	–	**9.14**	3532-1/4X2.0DP
5/16	18	**1.0D**	0.31"	10	**8.55**	3532-5/16X1.0DP	–	–	–	–
5/16	18	**1.5D**	0.47"	10	–	–	**9.00**	3532-5/16X1.5DP	–	–
5/16	18	**2.0D**	0.63"	10	–	–	–	–	**9.88**	3532-5/16X2.0DP
3/8	16	**1.0D**	0.38"	10	**11.50**	3532-3/8X1.0DP	–	–	–	–
3/8	16	**1.5D**	0.56"	10	–	–	**12.67**	3532-3/8X1.5DP	–	–
3/8	16	**2.0D**	0.75"	10	–	–	–	–	**14.74**	3532-3/8X2.0DP
7/16	14	**1.0D**	0.44"	10	**14.15**	3532-7/16X1.0DP	–	–	–	–
7/16	14	**1.5D**	0.66"	10	–	–	**15.04**	3532-7/16X1.5DP	–	–
7/16	14	**2.0D**	0.88"	10	–	–	–	–	**16.81**	3532-7/16X2.0DP
1/2	13	**1.0D**	0.50"	10	**16.21**	3532-1/2X1.0DP	–	–	–	–
1/2	13	**1.5D**	0.75"	10	–	–	**17.25**	3532-1/2X1.5DP	–	–
1/2	13	**2.0D**	1.00"	10	–	–	–	–	**19.46**	3532-1/2X2.0DP
9/16	12	**1.0D**	0.56"	5	**10.32**	3532-9/16X1.0DP	–	–	–	–
9/16	12	**1.5D**	0.84"	5	–	–	**11.79**	3532-9/16X1.5DP	–	–
9/16	12	**2.0D**	1.13"	5	–	–	–	–	**16.96**	3532-9/16X2.0DP
5/8	11	**1.0D**	0.63"	5	**13.86**	3532-5/8X1.0DP	–	–	–	–
5/8	11	**1.5D**	0.94"	5	–	–	**16.96**	3532-5/8X1.5DP	–	–
5/8	11	**2.0D**	1.25"	5	–	–	–	–	**21.53**	3532-5/8X2.0DP
3/4	10	**1.0D**	0.75"	5	**19.91**	3532-3/4X1.0DP	–	–	–	–
3/4	10	**1.5D**	1.13"	5	–	–	**23.52**	3532-3/4X1.5DP	–	–
3/4	10	**2.0D**	1.50"	5	–	–	–	–	**30.95**	3532-3/4X2.0DP
7/8	9	**1.0D**	0.88"	3	**20.35**	3532-7/8X1.0DP	–	–	–	–
7/8	9	**1.5D**	1.31"	3	–	–	**23.88**	3532-7/8X1.5DP	–	–
7/8	9	**2.0D**	1.75"	3	–	–	–	–	**27.42**	3532-7/8X2.0DP
1	8	**1.0D**	1.00"	3	**26.10**	3532-1X1.0DP	–	–	–	–
1	8	**1.5D**	1.50"	3	–	–	**30.07**	3532-1X1.5DP	–	–
1	8	**2.0D**	2.00"	3	–	–	–	–	**34.49**	3532-1X2.0DP

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNF

					1.0D		1.5D		2.0D	
INCH	TPI	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
3G	56	**1.0D**	0.10"	10	**14.74**	3534-3GX1.0DP	–	–	–	–
3G	56	**1.5D**	0.15"	10	–	–	**15.92**	3534-3GX1.5DP	–	–
3G	56	**2.0D**	0.20"	10	–	–	–	–	**16.81**	3534-3GX2.0DP
4G	48	**1.0D**	0.11"	10	**6.78**	3534-4GX1.0DP	–	–	–	–
4G	48	**1.5D**	0.17"	10	–	–	**7.22**	3534-4GX1.5DP	–	–
4G	48	**2.0D**	0.22"	10	–	–	–	–	**7.67**	3534-4GX2.0DP
6G	40	**1.0D**	0.14"	10	**6.78**	3534-6GX1.0DP	–	–	–	–
6G	40	**1.5D**	0.21"	10	–	–	**7.22**	3534-6GX1.5DP	–	–
6G	40	**2.0D**	0.28"	10	–	–	–	–	**7.67**	3534-6GX2.0DP
8G	36	**1.0D**	0.16"	10	**6.78**	3534-8GX1.0DP	–	–	–	–
8G	36	**1.5D**	0.25"	10	–	–	**7.22**	3534-8GX1.5DP	–	–
8G	36	**2.0D**	0.33"	10	–	–	–	–	**7.67**	3534-8GX2.0DP
10G	32	**1.0D**	0.19"	10	**6.78**	3534-10GX1.0DP	–	–	–	–
10G	32	**1.5D**	0.29"	10	–	–	**7.22**	3534-10GX1.5DP	–	–
10G	32	**2.0D**	0.38"	10	–	–	–	–	**7.67**	3534-10GX2.0DP
12G	28	**1.0D**	0.22"	10	**7.82**	3534-12GX1.0DP	–	–	–	–
12G	28	**1.5D**	0.32"	10	–	–	**8.12**	3534-12GX1.5DP	–	–
12G	28	**2.0D**	0.43"	10	–	–	–		**9.14**	3534-12GX2.0DP
1/4	32	**1.5D**	0.38"	10	–	–	**9.92**	3535-1/4X1.5DP	–	–
1/4	28	**1.0D**	0.25"	10	**7.82**	3534-1/4X1.0DP	–	–	–	–
1/4	28	**1.5D**	0.38"	10	–	–	**8.12**	3534-1/4X1.5DP	–	–
1/4	28	**2.0D**	0.50"	10	–	–	–	–	**9.14**	3534-1/4X2.0DP
5/16	24	**1.0D**	0.31"	10	**8.55**	3534-5/16X1.0DP	–	–	–	–
5/16	24	**1.5D**	0.47"	10	–	–	**9.00**	3534-5/16X1.5DP	–	–
5/16	24	**2.0D**	0.62"	10	–	–	–	–	**9.88**	3534-5/16X2.0DP
3/8	24	**1.0D**	0.38"	10	**11.50**	3534-3/8X1.0DP	–	–	–	–
3/8	24	**1.5D**	0.57"	10	–	–	**12.67**	3534-3/8X1.5DP	–	–
3/8	24	**2.0D**	0.76"	10	–	–	–	–	**14.74**	3534-3/8X2.0DP
7/16	20	**1.0D**	0.44"	10	**14.15**	3534-7/16X1.0DP	–	–	–	–
7/16	20	**1.5D**	0.66"	10	–	–	**15.04**	3534-7/16X1.5DP	–	–
7/16	20	**2.0D**	0.88"	10	–	–	–		**16.81**	3534-7/16X2.0DP
1/2	20	**1.0D**	0.50"	10	**16.21**	3534-1/2X1.0DP	–	–	–	–
1/2	20	**1.5D**	0.75"	10	–	–	**17.25**	3534-1/2X1.5DP	–	–
1/2	20	**2.0D**	1.00"	10	–	–	–	–	**19.46**	3534-1/2X2.0DP
9/16	18	**1.0D**	0.56"	5	**10.32**	3534-9/16X1.0DP	–	–	–	–
9/16	18	**1.5D**	0.84"	5	–	–	**11.79**	3534-9/16X1.5DP	–	–
9/16	18	**2.0D**	1.12"	5	–	–	–	–	**16.96**	3534-9/16X2.0DP
5/8	18	**1.0D**	0.63"	5	**13.86**	3534-5/8X1.0DP	–	–	–	–
5/8	18	**1.5D**	0.95"	5	–	–	**16.96**	3534-5/8X1.5DP	–	–
5/8	18	**2.0D**	1.26"	5	–	–	–	–	**21.53**	3534-5/8X2.0DP
3/4	16	**1.0D**	0.75"	5	**19.91**	3534-3/4X1.0DP	–	–	–	–
3/4	16	**1.5D**	1.13"	5	–	–	**23.52**	3534-3/4X1.5DP	–	–
3/4	16	**2.0D**	1.50"	5	–	–	–	–	**30.95**	3534-3/4X2.0DP
7/8	14	**1.0D**	0.88"	3	**20.35**	3534-7/8X1.0DP	–	–	–	–
7/8	14	**1.5D**	1.32"	3	–	–	**23.88**	3534-7/8X1.5DP	–	–
7/8	14	**2.0D**	1.76"	3	–	–	–	–	**27.42**	3534-7/8X2.0DP
1	14	**1.0D**	1.00"	3	**26.10**	3535-1X1.0DP	–	–	–	–
1	14	**1.5D**	1.50"	3	–	–	**30.07**	3535-1X1.5DP	–	–
1	14	**2.0D**	2.00"	3	–	–	–	–	**34.49**	3535-1X2.0DP
1	12	**1.0D**	1.00"	3	**26.10**	3534-1X1.0DP	–	–	–	–
1	12	**1.5D**	1.50"	3	–	–	**30.07**	3534-1X1.5DP	–	–
1	12	**2.0D**	2.00"	3	–	–	–	–	**34.49**	3534-1X2.0DP

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

BSW

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSW

D					1.0D		1.5D		2.0D	
INCH	TPI	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
1/8	40	**1.0D**	0.13"	10	**7.96**	3528-1/8X1.0DP	–	–	–	–
1/8	40	**1.5D**	0.20"	10	–	–	**8.25**	3528-1/8X1.5DP	–	–
1/8	40	**2.0D**	0.26"	10	–	–	–	–	**8.84**	3528-1/8X2.0DP
3/16	24	**1.0D**	0.19"	10	**6.88**	3528-3/16X1.0DP	–	–	–	–
3/16	24	**1.5D**	0.29"	10	–	–	**7.29**	3528-3/16X1.5DP	–	–
3/16	24	**2.0D**	0.38"	10	–	–	–	–	**7.70**	3528-3/16X2.0DP
1/4	20	**1.0D**	0.25"	10	**7.82**	3528-1/4X1.0DP	–	–	–	–
1/4	20	**1.5D**	0.38"	10	–	–	**8.12**	3528-1/4X1.5DP	–	–
1/4	20	**2.0D**	0.50"	10	–	–	–	–	**9.14**	3528-1/4X2.0DP
5/16	18	**1.0D**	0.31"	10	**7.96**	3528-5/16X1.0DP	–	–	–	–
5/16	18	**1.5D**	0.47"	10	–	–	**9.14**	3528-5/16X1.5DP	–	–
5/16	18	**2.0D**	0.62"	10	–	–	–	–	**10.91**	3528-5/16X2.0DP
3/8	16	**1.0D**	0.38"	10	**11.20**	3528-3/8X1.0DP	–	–	–	–
3/8	16	**1.5D**	0.57"	10	–	–	**12.67**	3528-3/8X1.5DP	–	–
3/8	16	**2.0D**	0.76"	10	–	–	–	–	**14.45**	3528-3/8X2.0DP
7/16	14	**1.0D**	0.44"	10	**13.86**	3528-7/16X1.0DP	–	–	–	–
7/16	14	**1.5D**	0.66"	10	–	–	**15.04**	3528-7/16X1.5DP	–	–
7/16	14	**2.0D**	0.88"	10	–	–	–	–	**16.51**	3528-7/16X2.0DP
1/2	12	**1.0D**	0.50"	10	**16.37**	3528-1/2X1.0DP	–	–	–	–
1/2	12	**1.5D**	0.75"	10	–	–	**17.40**	3528-1/2X1.5DP	–	–
1/2	12	**2.0D**	1.00"	10	–	–	–	–	**20.64**	3528-1/2X2.0DP
9/16	12	**1.0D**	0.56"	5	**10.32**	3528-9/16X1.0DP	–	–	–	–
9/16	12	**1.5D**	0.84"	5	–	–	**11.79**	3528-9/16X1.5DP	–	–
9/16	12	**2.0D**	1.12"	5	–	–	–	–	**16.96**	3528-9/16X2.0DP
5/8	11	**1.0D**	0.63"	5	**13.86**	3528-5/8X1.0DP	–	–	–	–
5/8	11	**1.5D**	0.95"	5	–	–	**17.69**	3528-5/8X1.5DP	–	–
5/8	11	**2.0D**	1.26"	5	–	–	–	–	**22.11**	3528-5/8X2.0DP
3/4	10	**1.0D**	0.75"	5	**19.91**	3528-3/4X1.0DP	–	–	–	–
3/4	10	**1.5D**	1.13"	5	–	–	**23.58**	3528-3/4X1.5DP	–	–
3/4	10	**2.0D**	1.50"	5	–	–	–	–	**30.95**	3528-3/4X2.0DP
7/8	9	**1.0D**	0.88"	3	**20.35**	3528-7/8X1.0DP	–	–	–	–
7/8	9	**1.5D**	1.32"	3	–	–	**23.88**	3528-7/8X1.5DP	–	–
7/8	9	**2.0D**	1.76"	3	–	–	–	–	**27.42**	3528-7/8X2.0DP
1	8	**1.0D**	1.00"	3	**26.53**	3528-1X1.0DP	–	–	–	–
1	8	**1.5D**	1.50"	3	–	–	**30.07**	3528-1X1.5DP	–	
1	8	**2.0D**	2.00"	3	–	–	–	–	**34.49**	3528-1X2.0DP

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSF

INCH	TPI	INSTALLED LENGTH		#	$	1.0D PART #	$	1.5D PART #	$	2.0D PART #
3/16	32	**1.0D**	0.19"	10	**6.88**	3530-3/16X1.0DP	–	–	–	–
3/16	32	**1.5D**	0.29"	10	–	–	**7.29**	3530-3/16X1.5DP	–	–
3/16	32	**2.0D**	0.38"	10	–	–	–	–	**7.70**	3530-3/16X2.0DP
1/4	26	**1.0D**	0.25"	10	**7.82**	3530-1/4X1.0DP	–	–	–	–
1/4	26	**1.5D**	0.38"	10	–	–	**8.12**	3530-1/4X1.5DP	–	–
1/4	26	**2.0D**	0.50"	10	–	–	–	–	**9.14**	3530-1/4X2.0DP
5/16	22	**1.0D**	0.31"	10	**7.96**	3530-5/16X1.0DP	–	–	–	–
5/16	22	**1.5D**	0.47"	10	–	–	**9.14**	3530-5/16X1.5DP	–	–
5/16	22	**2.0D**	0.62"	10	–	–	–	–	**10.91**	3530-5/16X2.0DP
3/8	20	**1.0D**	0.38"	10	**11.20**	3530-3/8X1.0DP	–	–	–	–
3/8	20	**1.5D**	0.57"	10	–	–	**12.67**	3530-3/8X1.5DP	–	–
3/8	20	**2.0D**	0.76"	10	–	–	–	–	**14.45**	3530-3/8X2.0DP
7/16	18	**1.0D**	0.44"	10	**13.86**	3530-7/16X1.0DP	–	–	–	–
7/16	18	**1.5D**	0.66"	10	–	–	**15.04**	3530-7/16X1.5DP	–	–
7/16	18	**2.0D**	0.88"	10	–	–	–	–	**16.51**	3530-7/16X2.0DP
1/2	16	**1.0D**	0.50"	10	**16.37**	3530-1/2X1.0DP	–	–	–	–
1/2	16	**1.5D**	0.75"	10	–	–	**17.40**	3530-1/2X1.5DP	–	–
1/2	16	**2.0D**	1.00"	10	–	–	–	–	**20.64**	3530-1/2X2.0DP
9/16	16	**1.0D**	0.56"	5	**10.32**	3530-9/16X1.0DP	–	–	–	–
9/16	16	**1.5D**	0.84"	5	–	–	**11.79**	3530-9/16X1.5DP	–	–
9/16	16	**2.0D**	1.12"	5	–	–	–	–	**16.96**	3530-9/16X2.0DP
5/8	14	**1.0D**	0.63"	5	**13.86**	3530-5/8X1.0DP	–	–	–	–
5/8	14	**1.5D**	0.95"	5	–	–	**17.69**	3530-5/8X1.5DP	–	–
5/8	14	**2.0D**	1.26"	5	–	–	–	–	**22.11**	3530-5/8X2.0DP
3/4	12	**1.0D**	0.75"	5	**19.91**	3530-3/4X1.0DP	–	–	–	–
3/4	12	**1.5D**	1.13"	5	–	–	**23.58**	3530-3/4X1.5DP	–	–
3/4	12	**2.0D**	1.50"	5	–	–	–	–	**30.95**	3530-3/4X2.0DP
7/8	11	**1.0D**	0.88"	3	**20.35**	3530-7/8X1.0DP	–	–	–	–
7/8	11	**1.5D**	1.32"	3	–	–	**23.88**	3530-7/8X1.5DP	–	–
7/8	11	**2.0D**	1.76"	3	–	–	–	–	**27.42**	3530-7/8X2.0DP
1	10	**1.0D**	1.00"	3	**26.53**	3530-1X1.0DP	–	–	–	–
1	10	**1.5D**	1.50"	3	–	–	**30.07**	3530-1X1.5DP	–	–
1	10	**2.0D**	2.00"	3	–	–	–	–	**34.49**	3530-1X2.0DP

BSF

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCRP
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSC
BSP
NPT

BSC

INCH	TPI	INSTALLED LENGTH		#	$	1.0D PART #	$	1.5D PART #	$	2.0D PART #
1/4	26	**1.5D**	0.38"	10	–	–	**10.77**	3560-1/4X1.5DP	–	–
5/16	26	**1.5D**	0.47"	10	–	–	**14.06**	3560-5/16X1.5DP	–	–
3/8	26	**1.5D**	0.56"	10	–	–	**16.33**	3560-3/8X1.5DP	–	–
7/16	26	**1.5D**	0.66"	10	–	–	**22.68**	3560-7/16X1.5DP	–	–
1/2	26	**1.5D**	0.75"	10	–	–	**36.29**	3560-1/2X1.5DP	–	–

BSP

INCH	TPI	INSTALLED LENGTH		#	$	1.0D PART #	$	1.5D PART #	$	2.0D PART #
1/8	28	**1.5D**	0.19"	10	–	–	**19.34**	3546-1/8X1.5DP	–	–
1/4	19	**1.5D**	0.38"	10	–	–	**28.31**	3546-1/4X1.5DP	–	–
1/4	19	**2.0D**	0.50"	10	–	–	–	–	**37.78**	3546-1/4X2.0DP
3/8	19	**1.5D**	0.56"	10	–	–	**35.39**	3546-3/8X1.5DP	–	–
1/2	14	**1.5D**	0.75"	5	–	–	**28.90**	3546-1/2X1.5DP	–	–
5/8	14	**1.5D**	0.94"	5	–	–	**41.28**	3546-5/8X1.5DP	–	–
5/8	14	**2.0D**	1.25"	5	–	–	–	–	**51.89**	3546-5/8X2.0DP
3/4	14	**1.0D**	0.75"	5	**35.39**	3546-3/4X1.0DP	–	–	–	–
3/4	14	**1.5D**	1.13"	5	–	–	**42.46**	3546-3/4X1.5DP	–	–
7/8	14	**1.5D**	1.32"	3	–	–	**26.53**	3546-7/8X1.5DP	–	–
1	11	**1.5D**	1.50"	3	–	–	**33.61**	3546-1X1.5DP	–	–

NPT

INCH	TPI	INSTALLED LENGTH	#	$	1.0D PART #	$	1.5D PART #	$	2.0D PART #
1/16	27	**0.271"**	10	–	–	**19.34**	3552-1/16X1.5DP	–	–
1/8	27	**0.273"**	10	–	–	**19.34**	3552-1/8X1.5DP	–	–
1/4	18	**0.394"**	10	–	–	**28.31**	3552-1/4X1.5DP	–	–
3/8	18	**0.407"**	10	–	–	**35.39**	3552-3/8X1.5DP	–	–
1/2	14	**0.534"**	5	–	–	**28.90**	3552-1/2X1.5DP	–	–
3/4	14	**0.553"**	5	–	–	**42.46**	3552-3/4X1.5DP	–	–
1	11	**0.661"**	3	–	–	**33.61**	3552-1X1.5DP	–	–

GROUP	–
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MERCHANDISER	$	PART #
POWERCOIL HANG SELL MERCHANDISER	**2,680.60**	3500-D1

CONTENTS

#	MM / INCH	PART #	PART #
	METRIC COARSE		
1	4 x 0.7	3520-4.00K	3520-4.00 x 1.5DP
1	5 x 0.8	3520-5.00K	3520-5.00 x 1.5DP
1	6 x 1.0	3520-6.00K	3520-6.00 x 1.5DP
1	6 x 1.0	–	3520-6.00 x 2.0DP
1	8 x 1.25	3520-8.00K	3520-8.00 x 1.5DP
1	8 x 1.25	–	3520-8.00 x 2.0DP
1	10 x 1.5	3520-10.00K	3520-10.00 x 1.5DP
1	12 x 1.75	3520-12.00K	3520-12.00 x 1.5DP
1	12 x 1.75	–	3520-12.00 x 2.0DP
1	16 x 2.0	3520-16.00K	3520-16.00 x 1.5DP
1	10 x 1.25	3521-10.00K	3521-10.00 x 1.5DP
1	12 x 1.5	3521-12.00K	3521-12.00 x 1.5DP
	SPARK PLUG		
1	12 x 1.25	3522-12.00K	3522-12.00 x 1/2P
1	12 x 1.25	–	3522-12.00 x 3/4P
1	14 x 1.25	3522-14.00K	3522-14.00 x 3/8P
1	14 x 1.25	–	3522-14.00 x 1/2P
1	14 x 1.25	–	3522-14.00 x 3/4P
	UNC		
1	1/4 x 20	3532-1/4K	3532-1/4 x 1.5DP
1	5/16 x 18	3532-5/16K	3532-5/16 x 1.5DP
1	3/8 x 16	3532-3/8K	3532-3/8 x 1.5DP
1	3/8 x 16	–	3532-3/8 x 2.0DP
1	7/16 x 14	3532-7/16K	3532-7/16 x 1.5DP
1	1/2 x 13	3532-1/2K	3532-1/2 x 1.5DP
1	5/8 x 11	3532-5/8K	3532-5/8 x 1.5DP
1	3/4 x 10	3532-3/4K	3532-3/4 x 1.5DP
	UNF		
1	1/4 x 28	3534-1/4K	3534-1/4 x 1.5DP
1	5/16 x 24	3534-5/16K	3534-5/16 x 1.5DP
1	3/8 x 24	3534-3/8K	3534-3/8 x 1.5DP
1	7/16 x 20	3534-7/16K	3534-7/16 x 1.5DP
1	1/2 x 20	3534-1/2K	3534-1/2 x 1.5DP
	BSW		
1	1/2 x 12	3528-1/2K	3528-1/2 x 1.5DP

Picture is representative of merchandiser appearance.
Actual contents as listed.

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

MC

GROUP	–
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MERCHANDISER	$	PART #
POWERCOIL BENCH MERCHANDISER	**799.40**	3500-CS1

CONTENTS

#	MM / INCH	PART #	PART #
	METRIC COARSE		
1	5 x 0.8	3520-5.00K	3520-5.00 x 1.5DP
1	6 x 1.0	3520-6.00K	3520-6.00 x 1.0DP
1	6 x 1.0	–	3520-6.00 x 1.5DP
1	6 x 1.0	–	3520-6.00 x 2.0DP
1	8 x 1.25	3520-8.00K	3520-8.00 x 1.0DP
1	8 x 1.25	–	3520-8.00 x 1.5DP
1	8 x 1.25	–	3520-8.00 x 2.0DP
1	10 x 1.5	3520-10.00K	3520-10.00 x 1.5DP
1	10 x 1.5	–	3520-10.00 x 2.0DP
1	12 x 1.75	3520-12.00K	3520-12.00 x 1.5DP
1	16 x 2.0	3520-16.00K	3520-16.00 x 1.5DP
	SPARK PLUG		
1	14 x 1.25	3522-14.00K	3522-14.00 x 3/8P
1	14 x 1.25	–	3522-14.00 x 1/2P
1	14 x 1.25	–	3522-14.00 x 3/4P

MERCHANDISER	$	PART #
POWERCOIL HANG SELL MERCHANDISER	**784.18**	3500-CS2

CONTENTS

#	MM / INCH	PART #	PART #
	METRIC COARSE		
1	6 x 1.0	3520-6.00K	3520-6.00 x 1.0DP
1	6 x 1.0	–	3520-6.00 x 1.5DP
1	6 x 1.0	–	3520-6.00 x 2.0DP
1	8 x 1.25	3520-8.00K	3520-8.00 x 1.0DP
1	8 x 1.25	–	3520-8.00 x 1.5DP
1	8 x 1.25	–	3520-8.00 x 2.0DP
1	10 x 1.5	3520-10.00K	3520-10.00 x 1.5DP
1	12 x 1.75	3520-12.00K	3520-12.00 x 1.5DP
	UNC		
1	1/4 x 20	3532-1/4K	3532-1/4 x 1.5DP
1	5/16 x 18	3532-5/16K	3532-5/16 x 1.5DP
1	3/8 x 16	3532-3/8K	3532-3/8 x 1.5DP
1	3/8 x 16	–	3532-3/8 x 2.0DP
1	1/2 x 13	3532-1/2K	3532-1/2 x 1.5DP

PowerCoil bench merchandisers are double sided units that display thread repair kits on one side and replacement insert packets on the other.

GROUP	–
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MERCHANDISER	$	PART #
POWERCOIL DISPLAY BAY MERCHANDISER	**7,173.14**	3500-FD1

CONTENTS

#	MM / INCH	PART #	PART #
	METRIC COARSE		
1	2.5 x 0.45	3520-2.50K	3520-2.50X1.5DP
1	3 x 0.5	3520-3.00K	3520-3.00X1.5DP
1	4 x 0.7	3520-4.00K	3520-4.00X1.5DP
1	5 x 0.8	3520-5.00K	3520-5.00X1.5DP
1	6 x 1.0	3520-6.00K	3520-6.00X1.0DP
1	6 x 1.0	–	3520-6.00X1.5DP
1	6 x 1.0	–	3520-6.00X2.0DP
1	7 x 1.0	3520-7.00K	3520-7.00X1.5DP
1	8 x 1.25	3520-8.00K	3520-8.00X1.0DP
1	8 x 1.25	–	3520-8.00X1.5DP
1	8 x 1.25	–	3520-8.00X2.0DP
1	9 x 1.25	3520-9.00K	–
1	10 x 1.5	3520-10.00K	3520-10.00X1.0DP
1	10 x 1.5	–	3520-10.00X1.5DP
1	10 x 1.5	–	3520-10.00X2.0DP
1	11 x 1.5	3520-11.00K	–
1	12 x 1.75	3520-12.00K	3520-12.00X1.0DP
1	12 x 1.75	–	3520-12.00X1.5DP
1	12 x 1.75	–	3520-12.00X2.0DP
1	14 x 2.0	3520-14.00K	3520-14.00X1.5DP
1	16 x 2.0	3520-16.00K	3520-16.00X1.5DP
1	18 x 2.5	3520-18.00K	3520-18.00X1.5DP
1	20 x 2.5	3520-20.00K	3520-20.00X1.5DP
1	24 x 3.0	3520-24.00K	3520-24.00X1.5DP
	METRIC FINE		
1	8 x 1.0	3521-8.00K	3521-8.00X1.5DP
1	10 x 1.25	3521-10.00K	3521-10.00X1.5DP
1	10 x 1.0	3523-10.00K	3523-10.00X1.5DP
1	12 x 1.5	3521-12.00K	3521-12.00X1.5DP
1	12 x 1.25	3523-12.00K	3523-12.00X1.5DP
1	14 x 1.5	3521-14.00K	3521-14.00X1.5DP
1	16 x 1.5	3521-16.00K	3521-16.00X1.5DP
1	18 x 1.5	3523-18.00K	3523-18.00X1.5DP
1	20 x 1.5	3523-20.00K	3523-20.00X1.5DP
	SPARK PLUG		
1	12 x 1.25	3522-12.00K	3522-12.00 x 1/2P
1	12 x 1.25	–	3522-12.00 x 3/4P
1	14 x 1.25	3522-14.00K	3522-14.00 x 3/8P
1	14 x 1.25	–	3522-14.00 x 1/2P
1	14 x 1.25	–	3522-14.00 x 3/4P
	UNC		
1	4G x 40	3532-4GK	3532-4GX1.5DP
1	6G x 32	3532-6GK	3532-6GX1.5DP
1	8G x 32	3532-8GK	3532-8GX1.5DP
1	10G x 24	3532-10GK	3532-10GX1.5DP
1	12G x 24	3532-12GK	3532-12GX1.5DP
1	1/4 x 20	3532-1/4K	3532-1/4X1.5DP
1	5/16 x 18	3532-5/16K	3532-5/16X1.5DP
1	3/8 x 16	3532-3/8K	3532-3/8X1.5DP
1	7/16 x 14	3532-7/16K	3532-7/16X1.5DP
1	1/2 x 13	3532-1/2K	3532-1/2X1.5DP
1	9/16 x 12	3532-9/16K	3532-9/16X1.5DP
1	5/8 x 11	3532-5/8K	3532-5/8X1.5DP
1	3/4 x 10	3532-3/4K	3532-3/4X1.5DP
1	7/8 x 9	3532-7/8K	3532-7/8X1.5DP
1	1 x 8	3532-1K	3532-1X1.5DP
	UNF		
1	10G x 32	3534-10GK	3534-10GX1.5DP
1	1/4 x 28	3534-1/4K	3534-1/4X1.5DP
1	5/16 x 24	3534-5/16K	3534-5/16X1.5DP
	3/8 x 24	3534-3/8K	3534-3/8X1.5DP
	7/16 x 20	3534-7/16K	3534-7/16X1.5DP
	1/2 x 20	3534-1/2K	3534-1/2X1.5DP
	9/16 x 18	3534-9/16K	3534-9/16X1.5DP
1	5/8 x 18	3534-5/8K	3534-5/8X1.5DP
1	3/4 x 16	3534-3/4K	3534-3/4X1.5DP
	BSW		
1	1/2 x 12	3528-1/2K	3528-1/2 x 1.5DP
	BSP		
1	1/8 x 28	3546-1/8K	3546-1/8X1.5DP
1	1/4 x 19	3546-1/4K	3546-1/4X1.5DP

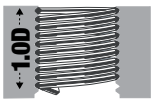
Picture is representative of merchandiser appearance.
Actual contents as listed.

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

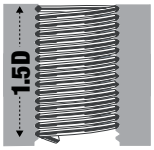
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MC



METRIC COARSE – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2.00	0.40	2.00	3520-2.00X1.0D	–	–	–	–	**0.841**	0.841	0.841	0.589	0.589	0.589	0.420	0.336	0.336	0.252
2.20	0.45	2.20	3520-2.20X1.0D	–	–	–	–	**0.758**	0.758	0.758	0.530	0.530	0.530	0.379	0.303	0.303	0.227
2.50	0.45	2.50	3520-2.50X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
3.00	0.50	3.00	3520-3.00X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
3.50	0.60	3.50	3520-3.50X1.0D	–	–	–	–	**0.729**	0.729	0.729	0.510	0.510	0.510	0.364	0.292	0.292	0.218
4.00	0.70	4.00	3520-4.00X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
5.00	0.80	5.00	3520-5.00X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
6.00	1.00	6.00	3520-6.00X1.0D	–	–	–	–	**0.753**	0.753	0.753	0.526	0.526	0.526	0.377	0.301	0.301	0.226
7.00	1.00	7.00	3520-7.00X1.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
8.00	1.25	8.00	3520-8.00X1.0D	–	–	–	–	**0.796**	0.796	0.796	0.557	0.557	0.557	0.399	0.319	0.319	0.239
9.00	1.25	9.00	3520-9.00X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
10.00	1.50	10.00	3520-10.00X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
11.00	1.50	11.00	3520-11.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
12.00	1.75	12.00	3520-12.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
13.00	1.75	13.00	3520-13.00X1.0D	–	–	–	**3.276**	3.276	3.276	2.293	2.293	2.293	1.638	1.310	1.310	0.983	0.983
14.00	2.00	14.00	3520-14.00X1.0D	–	–	–	**2.185**	2.185	2.185	1.530	1.530	1.530	1.093	0.874	0.874	0.655	0.655
15.00	2.00	15.00	3520-15.00X1.0D	–	–	–	**2.807**	2.807	2.807	1.965	1.965	1.965	1.403	1.122	1.122	0.842	0.842
16.00	2.00	16.00	3520-16.00X1.0D	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841	0.841
18.00	2.50	18.00	3520-18.00X1.0D	–	–	–	**4.008**	4.008	4.008	2.806	2.806	2.806	2.003	1.603	1.603	1.202	1.202
20.00	2.50	20.00	3520-20.00X1.0D	–	–	–	**5.602**	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681	1.681
22.00	2.50	22.00	3520-22.00X1.0D	–	–	–	**7.076**	7.076	4.953	4.953	4.953	3.539	2.831	2.831	2.123	2.123	2.123
24.00	3.00	24.00	3520-24.00X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653



METRIC COARSE – 1.5D BULK INSERTS

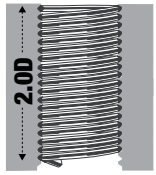
D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2.00	0.40	3.00	3520-2.00X1.5D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
2.20	0.45	3.30	3520-2.20X1.5D	–	–	–	–	**0.814**	0.814	0.814	0.570	0.570	0.570	0.407	0.326	0.326	0.245
2.50	0.45	3.75	3520-2.50X1.5D	–	–	–	–	**0.732**	0.732	0.732	0.512	0.512	0.512	0.365	0.293	0.293	0.219
3.00	0.50	4.50	3520-3.00X1.5D	–	–	–	–	**0.732**	0.732	0.732	0.512	0.512	0.512	0.365	0.293	0.293	0.219
3.50	0.60	5.25	3520-3.50X1.5D	–	–	–	–	**0.784**	0.784	0.784	0.549	0.549	0.549	0.392	0.313	0.313	0.235
4.00	0.70	6.00	3520-4.00X1.5D	–	–	–	–	**0.732**	0.732	0.732	0.512	0.512	0.512	0.365	0.293	0.293	0.219
5.00	0.80	7.50	3520-5.00X1.5D	–	–	–	–	**0.732**	0.732	0.732	0.512	0.512	0.512	0.365	0.293	0.293	0.219
6.00	1.00	9.00	3520-6.00X1.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
7.00	1.00	10.50	3520-7.00X1.5D	–	–	–	–	**0.902**	0.902	0.902	0.631	0.631	0.631	0.452	0.360	0.360	0.271
8.00	1.25	12.00	3520-8.00X1.5D	–	–	–	–	**0.902**	0.902	0.902	0.631	0.631	0.631	0.452	0.360	0.360	0.271
9.00	1.25	13.50	3520-9.00X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
10.00	1.50	15.00	3520-10.00X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
11.00	1.50	16.50	3520-11.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
12.00	1.75	18.00	3520-12.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
13.00	1.75	19.50	3520-13.00X1.5D	–	–	–	**4.194**	4.194	4.194	2.936	2.936	2.936	2.097	1.677	1.677	1.258	1.258
14.00	2.00	21.00	3520-14.00X1.5D	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841	0.841
15.00	2.00	22.50	3520-15.00X1.5D	–	–	–	**3.450**	3.450	3.450	2.415	2.415	2.415	1.725	1.381	1.381	1.035	1.035
16.00	2.00	24.00	3520-16.00X1.5D	–	–	–	**3.449**	3.449	3.449	2.414	2.414	2.414	1.725	1.381	1.381	1.035	1.035
18.00	2.50	27.00	3520-18.00X1.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
20.00	2.50	30.00	3520-20.00X1.5D	–	–	–	**6.487**	6.487	4.540	4.540	4.540	3.243	2.595	2.595	1.946	1.946	1.946
22.00	2.50	33.00	3520-22.00X1.5D	–	–	–	**8.108**	8.108	5.676	5.676	5.676	4.055	3.243	3.243	2.433	2.433	2.433
24.00	3.00	36.00	3520-24.00X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
27.00	3.00	40.50	3520-27.00X1.5D	–	–	**15.125**	15.125	10.588	10.588	7.563	6.050	6.050	6.050	4.537	4.537	4.537	4.537
30.00	3.50	45.00	3520-30.00X1.5D	–	–	**16.806**	16.806	11.764	11.764	8.403	6.722	6.722	6.722	5.042	5.042	5.042	5.042
33.00	3.50	49.50	3520-33.00X1.5D	–	–	**19.165**	19.165	13.415	13.415	9.582	7.666	7.666	7.666	5.750	5.750	5.750	5.750
36.00	4.00	54.00	3520-36.00X1.5D	–	–	**20.639**	20.639	14.447	14.447	10.319	8.255	8.255	8.255	6.192	6.192	6.192	6.192

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BORDO® INDUSTRIAL TOOLS

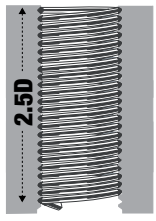
MC

METRIC COARSE – 2.0D BULK INSERTS



D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2.00	0.40	4.00	3520-2.00X2.0D	–	–	–	–	**0.983**	0.983	0.983	0.688	0.688	0.688	0.491	0.393	0.393	0.295
2.20	0.45	4.40	3520-2.20X2.0D	–	–	–	–	**0.841**	0.841	0.841	0.589	0.589	0.589	0.420	0.336	0.336	0.252
2.50	0.45	5.00	3520-2.50X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
3.00	0.50	6.00	3520-3.00X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
3.50	0.60	7.00	3520-3.50X2.0D	–	–	–	–	**0.841**	0.841	0.841	0.589	0.589	0.589	0.420	0.336	0.336	0.252
4.00	0.70	8.00	3520-4.00X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
5.00	0.80	10.00	3520-5.00X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
6.00	1.00	12.00	3520-6.00X2.0D	–	–	–	–	**0.870**	0.870	0.870	0.609	0.609	0.609	0.436	0.349	0.349	0.261
7.00	1.00	14.00	3520-7.00X2.0D	–	–	–	–	**0.993**	0.993	0.993	0.695	0.695	0.695	0.497	0.398	0.398	0.298
8.00	1.25	16.00	3520-8.00X2.0D	–	–	–	–	**0.993**	0.993	0.993	0.695	0.695	0.695	0.497	0.398	0.398	0.298
9.00	1.25	18.00	3520-9.00X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
10.00	1.50	20.00	3520-10.00X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
11.00	1.50	22.00	3520-11.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
12.00	1.75	24.00	3520-12.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
13.00	1.75	26.00	3520-13.00X2.0D	–	–	–	**5.252**	5.252	5.252	3.677	3.677	3.677	2.626	2.101	2.101	1.576	1.576
14.00	2.00	28.00	3520-14.00X2.0D	–	–	–	**3.503**	3.503	3.503	2.452	2.452	2.452	1.751	1.401	1.401	1.050	1.050
15.00	2.00	30.00	3520-15.00X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
16.00	2.00	32.00	3520-16.00X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
18.00	2.50	36.00	3520-18.00X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
20.00	2.50	40.00	3520-20.00X2.0D	–	–	–	**7.371**	7.371	7.371	5.160	5.160	5.160	3.686	2.948	2.948	2.211	2.211
22.00	2.50	44.00	3520-22.00X2.0D	–	–	–	**9.435**	9.435	6.605	6.605	6.605	4.718	3.774	3.774	2.831	2.831	2.831
24.00	3.00	48.00	3520-24.00X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449

METRIC COARSE – 2.5D BULK INSERTS



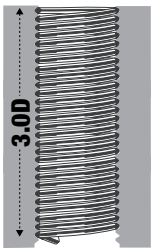
D			2.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2.00	0.40	5.00	3520-2.00X2.5D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
2.20	0.45	5.50	3520-2.20X2.5D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
2.50	0.45	6.25	3520-2.50X2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
3.00	0.50	7.50	3520-3.00X2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
3.50	0.60	8.75	3520-3.50X2.5D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
4.00	0.70	10.00	3520-4.00X2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
5.00	0.80	12.50	3520-5.00X2.5D	–	–	–	–	**0.870**	0.870	0.870	0.609	0.609	0.609	0.436	0.349	0.349	0.261
6.00	1.00	15.00	3520-6.00X2.5D	–	–	–	–	**0.944**	0.944	0.944	0.660	0.660	0.660	0.471	0.378	0.378	0.282
7.00	1.00	17.50	3520-7.00X2.5D	–	–	–	–	**1.236**	1.236	1.236	0.865	0.865	0.865	0.618	0.495	0.495	0.372
8.00	1.25	20.00	3520-8.00X2.5D	–	–	–	–	**1.236**	1.236	1.236	0.865	0.865	0.865	0.618	0.495	0.495	0.372
9.00	1.25	22.50	3520-9.00X2.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
10.00	1.50	25.00	3520-10.00X2.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
11.00	1.50	27.50	3520-11.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
12.00	1.75	30.00	3520-12.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
14.00	2.00	35.00	3520-14.00X2.5D	–	–	–	**4.344**	4.344	4.344	3.040	3.040	3.040	2.172	1.738	1.738	1.303	1.303
16.00	2.00	40.00	3520-16.00X2.5D	–	–	–	**5.307**	5.307	5.307	3.715	3.715	3.715	2.653	2.123	2.123	1.592	1.592
18.00	2.50	45.00	3520-18.00X2.5D	–	–	–	**7.666**	7.666	7.666	5.367	5.367	5.367	3.833	3.066	3.066	2.300	2.300
20.00	2.50	50.00	3520-20.00X2.5D	–	–	–	**8.124**	8.124	8.124	5.686	5.686	5.686	4.062	3.250	3.250	2.437	2.437
22.00	2.50	55.00	3520-22.00X2.5D	–	–	–	**11.066**	11.066	7.747	7.747	7.747	5.534	4.426	4.426	3.320	3.320	3.320
24.00	3.00	60.00	3520-24.00X2.5D	–	–	–	**13.858**	13.858	9.700	9.700	9.700	6.929	5.543	5.543	4.157	4.157	4.157

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

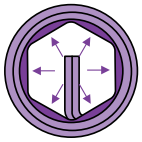
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MC



METRIC COARSE – 3.0D BULK INSERTS

D	MM	MM	3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2.00	0.40	6.00	3520-2.00X3.0D	–	–	–	–	**1.401**	1.401	1.401	0.981	0.981	0.981	0.701	0.561	0.561	0.420
2.20	0.45	6.60	3520-2.20X3.0D	–	–	–	–	**1.008**	1.008	1.008	0.706	0.706	0.706	0.504	0.403	0.403	0.302
2.50	0.45	7.50	3520-2.50X3.0D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
3.00	0.50	9.00	3520-3.00X3.0D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
3.50	0.60	10.50	3520-3.50X3.0D	–	–	–	–	**1.008**	1.008	1.008	0.706	0.706	0.706	0.504	0.403	0.403	0.302
4.00	0.70	12.00	3520-4.00X3.0D	–	–	–	–	**0.926**	0.926	0.926	0.648	0.648	0.648	0.463	0.371	0.371	0.277
5.00	0.80	15.00	3520-5.00X3.0D	–	–	–	–	**0.983**	0.983	0.983	0.688	0.688	0.688	0.491	0.393	0.393	0.295
6.00	1.00	18.00	3520-6.00X3.0D	–	–	–	–	**1.032**	1.032	1.032	0.722	0.722	0.722	0.517	0.413	0.413	0.310
7.00	1.00	21.00	3520-7.00X3.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
8.00	1.25	24.00	3520-8.00X3.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
9.00	1.25	27.00	3520-9.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
10.00	1.50	30.00	3520-10.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
11.00	1.50	33.00	3520-11.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
12.00	1.75	36.00	3520-12.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
14.00	2.00	42.00	3520-14.00X3.0D	–	–	–	**5.042**	5.042	5.042	3.529	3.529	3.529	2.521	2.017	2.017	1.512	1.512
16.00	2.00	48.00	3520-16.00X3.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
18.00	2.50	54.00	3520-18.00X3.0D	–	–	–	**9.140**	9.140	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742
20.00	2.50	60.00	3520-20.00X3.0D	–	–	–	**9.524**	9.524	9.524	6.666	6.666	6.666	4.762	3.809	3.809	2.857	2.857
22.00	2.50	66.00	3520-22.00X3.0D	–	–	–	**12.885**	12.885	9.018	9.018	9.018	6.443	5.154	5.154	3.866	3.866	3.866
24.00	3.00	72.00	3520-24.00X3.0D	–	–	–	**15.626**	15.626	10.939	10.939	10.939	7.813	6.251	6.251	4.688	4.688	4.688



Screw Locking Wire Thread Inserts

Screw locking (or prevailing torque) inserts are of particular value in applications subject to the effects of cyclic vibration or impact. In addition to the benefits afforded by free running inserts, PowerCoil screw locking inserts offer the additional security of prevailing locking torque. This is achieved by the action of one or more polygonal grip coils positioned within the insert's length, which exert radial pressure on the male thread. Each grip coil consists of a number of tangential locking chords that protrude inside the minor diameter of the normal free running coils. As the male thread passes through these grip coils, the locking flats are displaced thus exerting radial pressure or prevailing torque on the male thread. On removal of the male thread, the locking coils relax to their original form permitting repeated assembly whilst retaining a measurable level of prevailing torque.

Note: It is recommended that only close fit plated or lubricated bolts or screws are used with screw locking inserts.

Call for the latest pricing and availability.

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

METRIC FINE – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
6.00	0.75	6.00	3521-6.00X1.0D	–	–	–	–	**0.753**	0.753	0.753	0.526	0.526	0.526	0.377	0.301	0.301	0.226
8.00	1.00	8.00	3521-8.00X1.0D	–	–	–	–	**0.796**	0.796	0.796	0.557	0.557	0.557	0.399	0.319	0.319	0.239
8.00	0.75	8.00	3523-8.00X1.0D	–	–	–	–	**1.125**	1.125	1.125	0.788	0.788	0.788	0.563	0.449	0.449	0.337
9.00	1.00	9.00	3521-9.00X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
10.00	1.25	10.00	3521-10.00X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
10.00	1.00	10.00	3523-10.00X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
11.00	1.25	11.00	3521-11.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
11.00	1.00	11.00	3523-11.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
12.00	1.50	12.00	3521-12.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
12.00	1.25	12.00	3523-12.00X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
12.00	1.00	12.00	3524-12.00X1.0D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
13.00	1.50	13.00	3521-13.00X1.0D	–	–	–	**3.276**	3.276	3.276	2.293	2.293	2.293	1.638	1.310	1.310	0.983	0.983
13.00	1.25	13.00	3523-13.00X1.0D	–	–	–	**3.276**	3.276	3.276	2.293	2.293	2.293	1.638	1.310	1.310	0.983	0.983
14.00	1.50	14.00	3521-14.00X1.0D	–	–	–	**2.185**	2.185	2.185	1.530	1.530	1.530	1.093	0.874	0.874	0.655	0.655
14.00	1.25	14.00	3523-14.00X1.0D	–	–	–	**2.185**	2.185	2.185	1.530	1.530	1.530	1.093	0.874	0.874	0.655	0.655
14.00	1.00	14.00	3524-14.00X1.0D	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708	0.708
15.00	1.50	15.00	3521-15.00X1.0D	–	–	–	**2.807**	2.807	2.807	1.965	1.965	1.965	1.403	1.122	1.122	0.842	0.842
16.00	1.50	16.00	3521-16.00X1.0D	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841	0.841
18.00	2.00	18.00	3521-18.00X1.0D	–	–	–	**4.008**	4.008	4.008	2.806	2.806	2.806	2.003	1.603	1.603	1.202	1.202
18.00	1.50	18.00	3523-18.00X1.0D	–	–	–	**4.008**	4.008	4.008	2.806	2.806	2.806	2.003	1.603	1.603	1.202	1.202
20.00	2.00	20.00	3521-20.00X1.0D	–	–	–	**5.602**	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681	1.681
20.00	1.50	20.00	3523-20.00X1.0D	–	–	–	**5.602**	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681	1.681
22.00	2.00	22.00	3521-22.00X1.0D	–	–	–	**7.076**	7.076	4.953	4.953	4.953	3.539	2.831	2.831	2.123	2.123	2.123
22.00	1.50	22.00	3523-22.00X1.0D	–	–	–	**7.076**	7.076	4.953	4.953	4.953	3.539	2.831	2.831	2.123	2.123	2.123
24.00	2.00	24.00	3521-24.00X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653
24.00	1.50	24.00	3523-24.00X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653

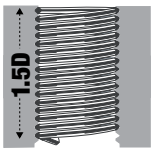
Strip Feed
Free Running Inserts
Page 46

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

MF

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**



METRIC FINE – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
6.00	0.75	9.00	3521-6.00X1.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
8.00	1.00	12.00	3521-8.00X1.5D	–	–	–	–	**0.902**	0.902	0.902	0.631	0.631	0.631	0.452	0.360	0.360	0.271
8.00	0.75	12.00	3523-8.00X1.5D	–	–	–	–	**1.266**	1.266	1.266	0.886	0.886	0.886	0.633	0.507	0.507	0.380
9.00	1.00	13.50	3521-9.00X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
10.00	1.25	15.00	3521-10.00X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
10.00	1.00	15.00	3523-10.00X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
11.00	1.25	16.50	3521-11.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
11.00	1.00	16.50	3523-11.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
12.00	1.50	18.00	3521-12.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
12.00	1.25	18.00	3523-12.00X1.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
12.00	1.00	18.00	3524-12.00X1.5D	–	–	–	–	**2.477**	2.477	2.477	1.735	1.735	1.735	1.238	0.990	0.990	0.742
13.00	1.50	19.50	3521-13.00X1.5D	–	–	–	**4.194**	4.194	4.194	2.936	2.936	2.936	2.097	1.677	1.677	1.258	1.258
13.00	1.25	19.50	3523-13.00X1.5D	–	–	–	**4.194**	4.194	4.194	2.936	2.936	2.936	2.097	1.677	1.677	1.258	1.258
14.00	1.50	21.00	3521-14.00X1.5D	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841	0.841
14.00	1.25	21.00	3523-14.00X1.5D	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841	0.841
14.00	1.00	21.00	3524-14.00X1.5D	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796	0.796
15.00	1.50	22.50	3521-15.00X1.5D	–	–	–	**3.450**	3.450	3.450	2.415	2.415	2.415	1.725	1.381	1.381	1.035	1.035
16.00	1.50	24.00	3521-16.00X1.5D	–	–	–	**3.449**	3.449	3.449	2.414	2.414	2.414	1.725	1.381	1.381	1.035	1.035
18.00	2.00	27.00	3521-18.00X1.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
18.00	1.50	27.00	3523-18.00X1.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
20.00	2.00	30.00	3521-20.00X1.5D	–	–	–	**6.487**	6.487	4.540	4.540	4.540	3.243	2.595	2.595	1.946	1.946	1.946
20.00	1.50	30.00	3523-20.00X1.5D	–	–	–	**6.487**	6.487	4.540	4.540	4.540	3.243	2.595	2.595	1.946	1.946	1.946
22.00	2.00	33.00	3521-22.00X1.5D	–	–	–	**8.108**	8.108	5.676	5.676	5.676	4.055	3.243	3.243	2.433	2.433	2.433
22.00	1.50	33.00	3523-22.00X1.5D	–	–	–	**8.108**	8.108	5.676	5.676	5.676	4.055	3.243	3.243	2.433	2.433	2.433
24.00	2.00	36.00	3521-24.00X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
24.00	1.50	36.00	3523-24.00X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
26.00	1.50	39.00	3523-26.00X1.5D	–	–	**15.125**	15.125	10.588	10.588	7.563	6.050	6.050	6.050	4.537	4.537	4.537	4.537
27.00	2.00	40.50	3521-27.00X1.5D	–	–	**15.125**	15.125	10.588	10.588	7.563	6.050	6.050	6.050	4.537	4.537	4.537	4.537
27.00	1.50	40.50	3523-27.00X1.5D	–	–	**15.125**	15.125	10.588	10.588	7.563	6.050	6.050	6.050	4.537	4.537	4.537	4.537
28.00	1.50	42.00	3523-28.00X1.5D	–	–	**15.332**	15.332	10.732	10.732	7.666	6.133	6.133	6.133	4.599	4.599	4.599	4.599
30.00	2.00	45.00	3521-30.00X1.5D	–	–	**16.806**	16.806	11.764	11.764	8.403	6.722	6.722	6.722	5.042	5.042	5.042	5.042
30.00	1.50	45.00	3523-30.00X1.5D	–	–	**16.806**	16.806	11.764	11.764	8.403	6.722	6.722	6.722	5.042	5.042	5.042	5.042
33.00	2.00	49.50	3521-33.00X1.5D	–	–	**19.165**	19.165	13.415	13.415	9.582	7.666	7.666	7.666	5.750	5.750	5.750	5.750
36.00	3.00	54.00	3521-36.00X1.5D	–	–	**20.639**	20.639	14.447	14.447	10.319	8.255	8.255	8.255	6.192	6.192	6.192	6.192
36.00	2.00	54.00	3523-36.00X1.5D	–	–	**20.639**	20.639	14.447	14.447	10.319	8.255	8.255	8.255	6.192	6.192	6.192	6.192
36.00	1.50	54.00	3524-36.00X1.5D	–	–	**20.639**	20.639	14.447	14.447	10.319	8.255	8.255	8.255	6.192	6.192	6.192	6.192

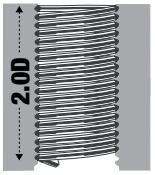
BORDO® INDUSTRIAL TOOLS

MF

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

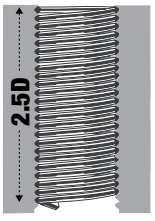
METRIC FINE – 2.0D BULK INSERTS

D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
6.00	0.75	12.00	3521-6.00X2.0D	–	–	–	–	**0.870**	0.870	0.870	0.609	0.609	0.609	0.436	0.349	0.349	0.261
8.00	1.00	16.00	3521-8.00X2.0D	–	–	–	–	**0.993**	0.993	0.993	0.695	0.695	0.695	0.497	0.398	0.398	0.298
8.00	0.75	16.00	3523-8.00X2.0D	–	–	–	–	**1.442**	1.442	1.442	1.009	1.009	1.009	0.720	0.576	0.576	0.433
9.00	1.00	18.00	3521-9.00X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
10.00	1.25	20.00	3521-10.00X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
10.00	1.00	20.00	3523-10.00X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
11.00	1.25	22.00	3521-11.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
11.00	1.00	22.00	3523-11.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
12.00	1.50	24.00	3521-12.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
12.00	1.25	24.00	3523-12.00X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
12.00	1.00	24.00	3524-12.00X2.0D	–	–	–	–	**3.125**	3.125	3.125	2.187	2.187	2.187	1.562	1.251	1.251	0.938
13.00	1.50	26.00	3521-13.00X2.0D	–	–	–	**5.252**	5.252	5.252	3.677	3.677	3.677	2.626	2.101	2.101	1.576	1.576
13.00	1.25	26.00	3523-13.00X2.0D	–	–	–	**5.252**	5.252	5.252	3.677	3.677	3.677	2.626	2.101	2.101	1.576	1.576
14.00	1.50	28.00	3521-14.00X2.0D	–	–	–	**3.503**	3.503	3.503	2.452	2.452	2.452	1.751	1.401	1.401	1.050	1.050
14.00	1.25	28.00	3523-14.00X2.0D	–	–	–	**4.128**	4.128	4.128	2.890	2.890	2.890	2.064	1.651	1.651	1.238	1.238
14.00	1.00	28.00	3524-14.00X2.0D	–	–	–	**4.128**	4.128	4.128	2.890	2.890	2.890	2.064	1.651	1.651	1.238	1.238
15.00	1.50	30.00	3521-15.00X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
16.00	1.50	32.00	3521-16.00X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
18.00	2.00	36.00	3521-18.00X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
18.00	1.50	36.00	3523-18.00X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
20.00	2.00	40.00	3523-20.00X2.0D	–	–	–	**7.371**	7.371	5.160	5.160	5.160	3.686	2.948	2.948	2.211	2.211	2.211
20.00	1.50	40.00	3521-20.00X2.0D	–	–	–	**7.371**	7.371	5.160	5.160	5.160	3.686	2.948	2.948	2.211	2.211	2.211
22.00	2.00	44.00	3521-22.00X2.0D	–	–	–	**9.435**	9.435	6.605	6.605	6.605	4.718	3.774	3.774	2.831	2.831	2.831
22.00	1.50	44.00	3523-22.00X2.0D	–	–	–	**9.435**	9.435	6.605	6.605	6.605	4.718	3.774	3.774	2.831	2.831	2.831
24.00	2.00	48.00	3521-24.00X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449
24.00	1.50	48.00	3523-24.00X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449



METRIC FINE – 2.5D BULK INSERTS

D			2.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
6.00	0.75	15.00	3521-6.00X2.5D	–	–	–	–	**0.944**	0.944	0.944	0.660	0.660	0.660	0.471	0.378	0.378	0.282
8.00	1.00	20.00	3521-8.00X2.5D	–	–	–	–	**1.236**	1.236	1.236	0.865	0.865	0.865	0.618	0.495	0.495	0.372
8.00	0.75	20.00	3523-8.00X2.5D	–	–	–	–	**1.737**	1.737	1.737	1.216	1.216	1.216	0.868	0.694	0.694	0.521
9.00	1.00	22.50	3521-9.00X2.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
10.00	1.25	25.00	3521-10.00X2.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
10.00	1.00	25.00	3523-10.00X2.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
11.00	1.25	27.50	3521-11.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
11.00	1.00	27.50	3523-11.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
12.00	1.50	30.00	3521-12.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
12.00	1.25	30.00	3523-12.00X2.5D	–	–	–	–	**2.653**	2.653	2.653	1.857	1.857	1.857	1.327	1.062	1.062	0.796
12.00	1.00	30.00	3524-12.00X2.5D	–	–	–	–	**3.715**	3.715	3.715	2.600	2.600	2.600	1.857	1.486	1.486	1.115
14.00	1.50	35.00	3521-14.00X2.5D	–	–	–	**4.344**	4.344	4.344	3.040	3.040	3.040	2.172	1.738	1.738	1.303	1.303
14.00	1.25	35.00	3523-14.00X2.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
14.00	1.00	35.00	3524-14.00X2.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
16.00	1.50	40.00	3521-16.00X2.5D	–	–	–	**5.307**	5.307	5.307	3.715	3.715	3.715	2.653	2.123	2.123	1.592	1.592
18.00	2.00	45.00	3521-18.00X2.5D	–	–	–	**7.666**	7.666	7.666	5.367	5.367	5.367	3.833	3.066	3.066	2.300	2.300
18.00	1.50	45.00	3523-18.00X2.5D	–	–	–	**7.666**	7.666	7.666	5.367	5.367	5.367	3.833	3.066	3.066	2.300	2.300
20.00	2.00	50.00	3521-20.00X2.5D	–	–	–	**8.124**	8.124	5.686	5.686	5.686	4.062	3.250	3.250	2.437	2.437	2.437
20.00	1.50	50.00	3523-20.00X2.5D	–	–	–	**8.124**	8.124	5.686	5.686	5.686	4.062	3.250	3.250	2.437	2.437	2.437
22.00	2.00	55.00	3521-22.00X2.5D	–	–	–	**11.066**	11.066	7.747	7.747	7.747	5.534	4.426	4.426	3.320	3.320	3.320
22.00	1.50	55.00	3523-22.00X2.5D	–	–	–	**11.066**	11.066	7.747	7.747	7.747	5.534	4.426	4.426	3.320	3.320	3.320
24.00	2.00	60.00	3521-24.00X2.5D	–	–	–	**13.858**	13.858	9.700	9.700	9.700	6.929	5.543	5.543	4.157	4.157	4.157
24.00	1.50	60.00	3523-24.00X2.5D	–	–	–	**13.858**	13.858	9.700	9.700	9.700	6.929	5.543	5.543	4.157	4.157	4.157

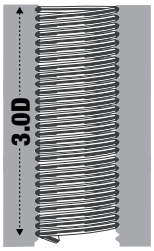


powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

MF



METRIC FINE – 3.0D BULK INSERTS

D	MM	MM	3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM	MM	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
6.00	0.75	18.00	3521-6.00X3.0D	–	–	–	–	**1.032**	1.032	1.032	0.722	0.722	0.722	0.517	0.413	0.413	0.310
8.00	1.00	24.00	3521-8.00X3.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
8.00	0.75	24.00	3523-8.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
9.00	1.00	27.00	3521-9.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
10.00	1.25	30.00	3521-10.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
10.00	1.00	30.00	3523-10.00X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
11.00	1.25	33.00	3521-11.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
11.00	1.00	33.00	3523-11.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
12.00	1.50	36.00	3521-12.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
12.00	1.25	36.00	3523-12.00X3.0D	–	–	–	–	**2.948**	2.948	2.948	2.064	2.064	2.064	1.474	1.179	1.179	0.884
12.00	1.00	36.00	3524-12.00X3.0D	–	–	–	–	**4.128**	4.128	4.128	2.890	2.890	2.890	2.064	1.651	1.651	1.238
14.00	1.50	42.00	3521-14.00X3.0D	–	–	–	**5.042**	5.042	5.042	3.529	3.529	3.529	2.521	2.017	2.017	1.512	1.512
14.00	1.25	42.00	3523-14.00X3.0D	–	–	–	**5.602**	5.602	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681
14.00	1.00	42.00	3524-14.00X3.0D	–	–	–	**5.602**	5.602	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681
16.00	1.50	48.00	3521-16.00X3.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
18.00	2.00	54.00	3521-18.00X3.0D	–	–	–	**9.140**	9.140	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742
18.00	1.50	54.00	3523-18.00X3.0D	–	–	–	**9.140**	9.140	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742
20.00	2.00	60.00	3521-20.00X3.0D	–	–	–	**9.524**	9.524	6.666	6.666	6.666	4.762	3.809	3.809	2.857	2.857	2.857
20.00	1.50	60.00	3523-20.00X3.0D	–	–	–	**9.524**	9.524	6.666	6.666	6.666	4.762	3.809	3.809	2.857	2.857	2.857
22.00	2.00	66.00	3521-22.00X3.0D	–	–	–	**12.885**	12.885	9.018	9.018	9.018	6.443	5.154	5.154	3.866	3.866	3.866
22.00	1.50	66.00	3523-22.00X3.0D	–	–	–	**12.885**	12.885	9.018	9.018	9.018	6.443	5.154	5.154	3.866	3.866	3.866
24.00	2.00	72.00	3521-24.00X3.0D	–	–	–	**15.626**	15.626	10.939	10.939	10.939	7.813	6.251	6.251	4.688	4.688	4.688
24.00	1.50	72.00	3523-24.00X3.0D	–	–	–	**15.626**	15.626	10.939	10.939	10.939	7.813	6.251	6.251	4.688	4.688	4.688

SPARK PLUG – BULK INSERTS

D	MM	MM		$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
MM	MM		PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
IMPERIAL LENGTH																	
10.00	1.00	0.339"	3522-10.00X.339	–	–	–	–	**1.145**	1.145	1.145	0.800	0.800	0.800	0.572	0.458	0.458	0.343
10.00	1.00	1/2"	3522-10.00X1/2	–	–	–	–	**1.296**	1.296	1.296	0.907	0.907	0.907	0.648	0.519	0.519	0.389
12.00	1.25	1/2"	3522-12.00X1/2	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
12.00	1.25	3/4"	3522-12.00X3/4	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
14.00	1.25	3/8"	3522-14.00X3/8	–	–	–	–	**1.250**	1.250	1.250	0.875	0.875	0.875	0.625	0.499	0.499	0.375
14.00	1.25	7/16"	3522-14.00X7/16	–	–	–	–	**0.978**	0.978	0.978	0.685	0.685	0.685	0.489	0.391	0.391	0.294
14.00	1.25	1/2"	3522-14.00X1/2	–	–	–	–	**1.490**	1.490	1.490	1.043	1.043	1.043	0.744	0.596	0.596	0.446
14.00	1.25	3/4"	3522-14.00X3/4	–	–	–	–	**1.957**	1.957	1.957	1.369	1.369	1.369	0.979	0.783	0.783	0.588
18.00	1.50	1/2"	3522-18.00X1/2	–	–	–	–	**2.768**	2.768	2.768	1.937	1.937	1.937	1.384	1.108	1.108	0.830
METRIC LENGTH																	
14.00	1.25	8.4MM	3522-14.00X8.4	–	–	–	–	**0.993**	0.993	0.993	0.695	0.695	0.695	0.497	0.398	0.398	0.298
14.00	1.25	12.4MM	3522-14.00X12.4	–	–	–	–	**1.534**	1.534	1.534	1.074	1.074	1.074	0.768	0.613	0.613	0.461
14.00	1.25	16.4MM	3522-14.00X16.4	–	–	–	–	**2.106**	2.106	2.106	1.474	1.474	1.474	1.053	0.843	0.843	0.632

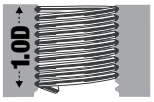
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

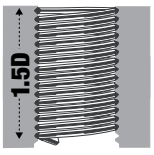
UNC – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2G	56	0.09	3532-2GX1.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
3G	48	0.10	3532-3GX1.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
4G	40	0.11	3532-4GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
5G	40	0.13	3532-5GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.204
6G	32	0.14	3532-6GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
8G	32	0.16	3532-8GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
10G	24	0.19	3532-10GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
12G	24	0.22	3532-12GX1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
1/4	20	0.25	3532-1/4X1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
5/16	18	0.31	3532-5/16X1.0D	–	–	–	–	**0.855**	0.855	0.855	0.599	0.599	0.599	0.428	0.342	0.342	0.256
3/8	16	0.38	3532-3/8X1.0D	–	–	–	–	**1.150**	1.150	1.150	0.804	0.804	0.804	0.575	0.460	0.460	0.345
7/16	14	0.44	3532-7/16X1.0D	–	–	–	–	**1.415**	1.415	1.415	0.990	0.990	0.990	0.708	0.566	0.566	0.425
1/2	13	0.50	3532-1/2X1.0D	–	–	–	–	**1.621**	1.621	1.621	1.136	1.136	1.136	0.812	0.649	0.649	0.487
9/16	12	0.56	3532-9/16X1.0D	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620	0.620
5/8	11	0.63	3532-5/8X1.0D	–	–	–	**2.772**	2.772	2.772	1.940	1.940	1.940	1.386	1.109	1.109	0.831	0.831
3/4	10	0.75	3532-3/4X1.0D	–	–	–	**3.981**	3.981	3.981	2.787	2.787	2.787	1.991	1.592	1.592	1.195	1.195
7/8	9	0.88	3532-7/8X1.0D	–	–	–	**6.781**	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035	2.035
1	8	1.00	3532-1X1.0D	–	–	–	**8.698**	8.698	6.089	6.089	6.089	4.349	3.479	3.479	2.610	2.610	2.610

UNC – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2G	56	0.14	3532-2GX1.5D	–	–	–	–	**0.959**	0.959	0.959	0.672	0.672	0.672	0.480	0.383	0.383	0.288
3G	48	0.15	3532-3GX1.5D	–	–	–	–	**1.594**	1.594	1.594	1.116	1.116	1.116	0.797	0.637	0.637	0.479
4G	40	0.17	3532-4GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
5G	40	0.20	3532-5GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
6G	32	0.21	3532-6GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
8G	32	0.24	3532-8GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
10G	24	0.29	3532-10GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
12G	24	0.33	3532-12GX1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
1/4	20	0.38	3532-1/4X1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
5/16	18	0.47	3532-5/16X1.5D	–	–	–	–	**0.900**	0.900	0.900	0.630	0.630	0.630	0.449	0.360	0.360	0.270
3/8	16	0.57	3532-3/8X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
7/16	14	0.66	3532-7/16X1.5D	–	–	–	–	**1.504**	1.504	1.504	1.053	1.053	1.053	0.753	0.602	0.602	0.452
1/2	13	0.75	3532-1/2X1.5D	–	–	–	–	**1.725**	1.725	1.725	1.208	1.208	1.208	0.863	0.690	0.690	0.518
9/16	12	0.84	3532-9/16X1.5D	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708	0.708
5/8	11	0.95	3532-5/8X1.5D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
3/4	10	1.13	3532-3/4X1.5D	–	–	–	**4.703**	4.703	4.703	3.293	3.293	3.293	2.352	1.882	1.882	1.411	1.411
7/8	9	1.32	3532-7/8X1.5D	–	–	–	**7.961**	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388	2.388
1	8	1.50	3532-1X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
1-1/8	7	1.70	3532-1.1/8X1.5D	–	–	**14.742**	14.742	10.319	10.319	7.371	5.897	5.897	5.897	4.423	4.423	4.423	4.423
1-1/4	7	1.88	3532-1.1/4X1.5D	–	–	**16.806**	16.806	11.764	11.764	8.403	6.722	6.722	6.722	5.042	5.042	5.042	5.042
1-3/8	6	2.07	3532-1.3/8X1.5D	–	–	**17.690**	17.690	12.384	12.384	8.845	7.076	7.076	7.076	5.307	5.307	5.307	5.307
1-1/2	6	2.25	3532-1.1/2X1.5D	–	–	**23.587**	23.587	16.511	16.511	11.794	9.435	9.435	9.435	7.076	7.076	7.076	7.076



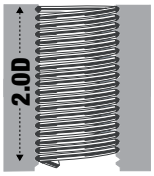


powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

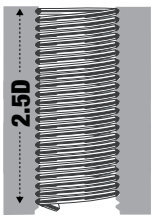
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNC



UNC – 2.0D BULK INSERTS

INCH	TPI	INCH	PART #	1 EACH	2 EACH	3 EACH	5 EACH	10 EACH	25 EACH	50 EACH	100 EACH	125 EACH	250 EACH	500 EACH	1000 EACH	2500 EACH	5000 EACH
2G	56	0.18	3532-2GX2.0D	–	–	–	–	**1.003**	1.003	1.003	0.702	0.702	0.702	0.501	0.401	0.401	0.300
3G	48	0.20	3532-3GX2.0D	–	–	–	–	**1.682**	1.682	1.682	1.177	1.177	1.177	0.841	0.673	0.673	0.504
4G	40	0.22	3532-4GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
5G	40	0.26	3532-5GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
6G	32	0.28	3532-6GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
8G	32	0.32	3532-8GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
10G	24	0.38	3532-10GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
12G	24	0.44	3532-12GX2.0D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
1/4	20	0.50	3532-1/4X2.0D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
5/16	18	0.62	3532-5/16X2.0D	–	–	–	–	**0.988**	0.988	0.988	0.692	0.692	0.692	0.495	0.395	0.395	0.297
3/8	16	0.76	3532-3/8X2.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
7/16	14	0.88	3532-7/16X2.0D	–	–	–	–	**1.681**	1.681	1.681	1.176	1.176	1.176	0.841	0.673	0.673	0.504
1/2	13	1.00	3532-1/2X2.0D	–	–	–	–	**1.946**	1.946	1.946	1.362	1.362	1.362	0.973	0.779	0.779	0.584
9/16	12	1.12	3532-9/16X2.0D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
5/8	11	1.26	3532-5/8X2.0D	–	–	–	**4.305**	4.305	4.305	3.012	3.012	3.012	2.153	1.722	1.722	1.292	1.292
3/4	10	1.50	3532-3/4X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
7/8	9	1.76	3532-7/8X2.0D	–	–	–	**9.140**	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742	2.742
1	8	2.00	3532-1X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449



UNC – 2.5D BULK INSERTS

INCH	TPI	INCH	PART #	1 EACH	2 EACH	3 EACH	5 EACH	10 EACH	25 EACH	50 EACH	100 EACH	125 EACH	250 EACH	500 EACH	1000 EACH	2500 EACH	5000 EACH
2G	56	0.23	3532-2GX2.5D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.530	0.425	0.425	0.319
4G	48	0.25	3532-4GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
5G	40	0.28	3532-5GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
6G	40	0.33	3532-6GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
8G	32	0.35	3532-8GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
10G	32	0.40	3532-10GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
12G	24	0.48	3532-12GX2.5D	–	–	–	–	**0.973**	0.973	0.973	0.681	0.681	0.681	0.487	0.389	0.389	0.292
1/4	20	0.55	3532-1/4X2.5D	–	–	–	–	**0.973**	0.973	0.973	0.681	0.681	0.681	0.487	0.389	0.389	0.292
5/16	18	0.63	3532-5/16X2.5D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
3/8	16	0.78	3532-3/8X2.5D	–	–	–	–	**1.681**	1.681	1.681	1.176	1.176	1.176	0.841	0.673	0.673	0.504
7/16	14	0.95	3532-7/16X2.5D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
1/2	13	1.10	3532-1/2X2.5D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
9/16	12	1.25	3532-9/16X2.5D	–	–	–	**4.276**	4.276	4.276	2.994	2.994	2.994	2.138	1.710	1.710	1.283	1.283
5/8	11	1.40	3532-5/8X2.5D	–	–	–	**5.189**	5.189	5.189	3.632	3.632	3.632	2.595	2.076	2.076	1.557	1.557
3/4	10	1.58	3532-3/4X2.5D	–	–	–	**7.547**	7.547	7.547	5.284	5.284	5.284	3.774	3.020	3.020	2.265	2.265
7/8	9	1.88	3532-7/8X2.5D	–	–	–	**10.319**	10.319	7.224	7.224	7.224	5.160	4.128	4.128	3.095	3.095	3.095
1	8	2.50	3532-1X2.5D	–	–	–	**13.563**	13.563	9.494	9.494	9.494	6.781	5.425	5.425	4.069	4.069	4.069

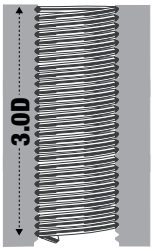
BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNC – 3.0D BULK INSERTS

D	TPI	INCH	3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
2G	56	0.27	3532-2GX3.0D	–	–	–	–	**1.166**	1.166	1.166	0.816	0.816	0.816	0.583	0.466	0.466	0.350
4G	40	0.33	3532-4GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
5G	40	0.39	3532-5GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
6G	32	0.42	3532-6GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
8G	32	0.48	3532-8GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
10G	24	0.57	3532-10GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
12G	24	0.66	3532-12GX3.0D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.530	0.425	0.425	0.319
1/4	20	0.75	3532-1/4X3.0D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.530	0.425	0.425	0.319
5/16	18	0.93	3532-5/16X3.0D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
3/8	16	1.14	3532-3/8X3.0D	–	–	–	–	**1.916**	1.916	1.916	1.342	1.342	1.342	0.959	0.767	0.767	0.575
7/16	14	1.32	3532-7/16X3.0D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
1/2	13	1.50	3532-1/2X3.0D	–	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841
9/16	12	1.68	3532-9/16X3.0D	–	–	–	**5.160**	5.160	5.160	3.612	3.612	3.612	2.581	2.064	2.064	1.549	1.549
5/8	11	1.89	3532-5/8X3.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
3/4	10	2.25	3532-3/4X3.0D	–	–	–	**8.845**	8.845	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653
7/8	9	2.64	3532-7/8X3.0D	–	–	–	**11.794**	11.794	8.255	8.255	8.255	5.897	4.718	4.718	3.539	3.539	3.539
1	8	3.00	3532-1X3.0D	–	–	–	**15.332**	15.332	10.732	10.732	10.732	7.666	6.133	6.133	4.599	4.599	4.599

UNC

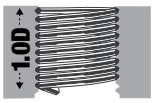


powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

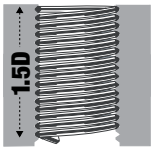
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNF



UNF – 1.0D BULK INSERTS

INCH	TPI	INCH	PART #	1.0D	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 5	$ EACH 10	$ EACH 25	$ EACH 50	$ EACH 100	$ EACH 125	$ EACH 250	$ EACH 500	$ EACH 1000	$ EACH 2500	$ EACH 5000
3G	56	0.10	3534-3GX1.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
4G	48	0.11	3534-4GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
6G	40	0.14	3534-6GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
8G	36	0.16	3534-8GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
10G	32	0.19	3534-10GX1.0D	–	–	–	–	**0.678**	0.678	0.678	0.475	0.475	0.475	0.339	0.271	0.271	0.203
12G	28	0.22	3534-12GX1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
1/4	28	0.25	3534-1/4X1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
5/16	24	0.31	3534-5/16X1.0D	–	–	–	–	**0.855**	0.855	0.855	0.599	0.599	0.599	0.428	0.342	0.342	0.256
3/8	24	0.38	3534-3/8X1.0D	–	–	–	–	**1.150**	1.150	1.150	0.804	0.804	0.804	0.575	0.460	0.460	0.345
7/16	16	0.44	3534-7/16-16X1.0D	–	–	–	–	**1.464**	1.464	1.464	1.025	1.025	1.025	0.732	0.585	0.585	0.439
7/16	20	0.44	3534-7/16X1.0D	–	–	–	–	**1.415**	1.415	1.415	0.990	0.990	0.990	0.708	0.566	0.566	0.425
1/2	20	0.50	3534-1/2X1.0D	–	–	–	–	**1.621**	1.621	1.621	1.136	1.136	1.136	0.812	0.649	0.649	0.487
9/16	18	0.56	3534-9/16X1.0D	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620	0.620
5/8	18	0.63	3534-5/8X1.0D	–	–	–	**2.772**	2.772	2.772	1.940	1.940	1.940	1.386	1.109	1.109	0.831	0.831
3/4	16	0.75	3534-3/4X1.0D	–	–	–	**3.981**	3.981	3.981	2.787	2.787	2.787	1.991	1.592	1.592	1.195	1.195
7/8	14	0.88	3534-7/8X1.0D	–	–	–	**6.781**	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035	2.035
1	12	1.00	3534-1X1.0D	–	–	–	**8.698**	8.698	6.089	6.089	6.089	4.349	3.479	3.479	2.610	2.610	2.610



UNF – 1.5D BULK INSERTS

INCH	TPI	INCH	PART #	1.5D	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 5	$ EACH 10	$ EACH 25	$ EACH 50	$ EACH 100	$ EACH 125	$ EACH 250	$ EACH 500	$ EACH 1000	$ EACH 2500	$ EACH 5000
3G	56	0.15	3534-3GX1.5D	–	–	–	–	**1.594**	1.594	1.594	1.116	1.116	1.116	0.797	0.637	0.637	0.479
4G	48	0.17	3534-4GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
6G	40	0.21	3534-6GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
8G	36	0.24	3534-8GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
10G	32	0.29	3534-10GX1.5D	–	–	–	–	**0.722**	0.722	0.722	0.506	0.506	0.506	0.361	0.290	0.290	0.217
12G	28	0.32	3534-12GX1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
1/4	28	0.38	3534-1/4X1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
5/16	24	0.47	3534-5/16X1.5D	–	–	–	–	**0.900**	0.900	0.900	0.630	0.630	0.630	0.449	0.360	0.360	0.270
3/8	24	0.57	3534-3/8X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
7/16	20	0.66	3534-7/16X1.5D	–	–	–	–	**1.504**	1.504	1.504	1.053	1.053	1.053	0.753	0.602	0.602	0.452
1/2	20	0.75	3534-1/2X1.5D	–	–	–	–	**1.725**	1.725	1.725	1.208	1.208	1.208	0.863	0.690	0.690	0.518
9/16	18	0.84	3534-9/16X1.5D	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708	0.708
5/8	18	0.95	3534-5/8X1.5D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
3/4	16	1.13	3534-3/4X1.5D	–	–	–	**4.703**	4.703	4.703	3.293	3.293	3.293	2.352	1.882	1.882	1.411	1.411
7/8	14	1.32	3534-7/8X1.5D	–	–	–	**7.961**	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388	2.388
1	12	1.50	3534-1X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
1	14	1.50	3535-1X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007
1-1/8	12	1.70	3534-1.1/8X1.5D	–	–	**14.742**	14.742	10.319	10.319	7.371	5.897	5.897	5.897	4.423	4.423	4.423	4.423
1-1/4	12	1.88	3534-1.1/4X1.5D	–	–	**16.806**	16.806	11.764	11.764	8.403	6.722	6.722	6.722	5.042	5.042	5.042	5.042
1-3/8	12	2.07	3534-1.3/8X1.5D	–	–	**17.690**	17.690	12.384	12.384	8.845	7.076	7.076	7.076	5.307	5.307	5.307	5.307
1-1/2	12	2.25	3534-1.1/2X1.5D	–	–	**23.587**	23.587	16.511	16.511	11.794	9.435	9.435	9.435	7.076	7.076	7.076	7.076

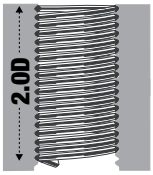
BORDO INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNF – 2.0D BULK INSERTS

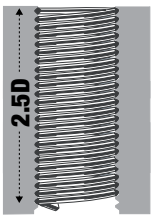
D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3G	56	0.20	3534-3GX2.0D	–	–	–	–	**1.682**	1.682	1.682	1.177	1.177	1.177	0.841	0.673	0.673	0.504
4G	48	0.22	3534-4GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
6G	40	0.28	3534-6GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
8G	36	0.32	3534-8GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
10G	32	0.38	3534-10GX2.0D	–	–	–	–	**0.767**	0.767	0.767	0.537	0.537	0.537	0.383	0.307	0.307	0.230
12G	28	0.43	3534-12GX2.0D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
1/4	28	0.50	3534-1/4X2.0D	–	–	–		**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
5/16	24	0.62	3534-5/16X2.0D	–	–	–		**0.988**	0.988	0.988	0.692	0.692	0.692	0.495	0.395	0.395	0.297
3/8	24	0.76	3534-3/8X2.0D	–	–	–		**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
7/16	20	0.88	3534-7/16X2.0D	–	–	–		**1.681**	1.681	1.681	1.176	1.176	1.176	0.841	0.673	0.673	0.504
1/2	20	1.00	3534-1/2X2.0D	–	–	–		**1.946**	1.946	1.946	1.362	1.362	1.362	0.973	0.779	0.779	0.584
9/16	18	1.12	3534-9/16X2.0D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
5/8	18	1.26	3534-5/8X2.0D	–	–	–	**4.305**	4.305	4.305	3.012	3.012	3.012	2.153	1.722	1.722	1.292	1.292
3/4	16	1.50	3534-3/4X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
7/8	14	1.76	3534-7/8X2.0D	–	–	–	**9.140**	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742	2.742
1	12	2.00	3534-1X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449

UNF



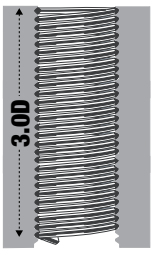
UNF – 2.5D BULK INSERTS

D			2.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
4G	48	0.28	3534-4GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
6G	40	0.35	3534-6GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
8G	36	0.40	3534-8GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
10G	32	0.48	3534-10GX2.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
12G	28	0.54	3534-12GX2.5D	–	–	–	–	**0.973**	0.973	0.973	0.681	0.681	0.681	0.487	0.389	0.389	0.292
1/4	28	0.63	3534-1/4X2.5D	–	–	–	–	**0.973**	0.973	0.973	0.681	0.681	0.681	0.487	0.389	0.389	0.292
5/16	24	0.78	3534-5/16X2.5D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
3/8	24	0.95	3534-3/8X2.5D	–	–	–	–	**1.681**	1.681	1.681	1.176	1.176	1.176	0.841	0.673	0.673	0.504
7/16	20	1.10	3534-7/16X2.5D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
1/2	20	1.25	3534-1/2X2.5D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
9/16	18	1.40	3534-9/16X2.5D	–	–	–	**4.276**	4.276	4.276	2.994	2.994	2.994	2.138	1.710	1.710	1.283	1.283
5/8	18	1.58	3534-5/8X2.5D	–	–	–	**5.189**	5.189	5.189	3.632	3.632	3.632	2.595	2.076	2.076	1.557	1.557
3/4	16	1.88	3534-3/4X2.5D	–	–	–	**7.547**	7.547	7.547	5.284	5.284	5.284	3.774	3.020	3.020	2.265	2.265
7/8	14	2.20	3534-7/8X2.5D	–	–	–	**10.319**	10.319	7.224	7.224	7.224	5.160	4.128	4.128	3.095	3.095	3.095
1	12	2.50	3534-1X2.5D	–	–	–	**13.563**	13.563	9.494	9.494	9.494	6.781	5.425	5.425	4.069	4.069	4.069



UNF – 3.0D BULK INSERTS

D			3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
4G	48	0.33	3534-4GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
6G	40	0.42	3534-6GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
8G	36	0.48	3534-8GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
10G	32	0.57	3534-10GX3.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
12G	28	0.65	3534-12GX3.0D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.53	0.425	0.425	0.319
1/4	28	0.75	3534-1/4X3.0D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.530	0.425	0.425	0.319
5/16	24	0.93	3534-5/16X3.0D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
3/8	24	1.14	3534-3/8X3.0D	–	–	–	–	**1.916**	1.916	1.916	1.342	1.342	1.342	0.959	0.767	0.767	0.575
7/16	20	1.32	3534-7/16X3.0D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
1/2	20	1.50	3534-1/2X3.0D	–	–	–	–	**2.801**	2.801	2.801	1.961	1.961	1.961	1.401	1.120	1.120	0.841
9/16	18	1.68	3534-9/16X3.0D	–	–	–	**5.160**	5.160	5.160	3.612	3.612	3.612	2.581	2.064	2.064	1.549	1.549
5/8	18	1.89	3534-5/8X3.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
3/4	16	2.25	3534-3/4X3.0D	–	–	–	**8.845**	8.845	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653
7/8	14	2.64	3534-7/8X3.0D	–	–	–	**11.794**	11.794	8.255	8.255	8.255	5.897	4.718	4.718	3.539	3.539	3.539
1	12	3.00	3534-1X3.0D	–	–	–	**15.332**	15.332	10.732	10.732	10.732	7.666	6.133	6.133	4.599	4.599	4.599

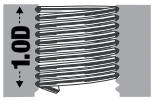


powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

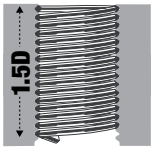
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSW



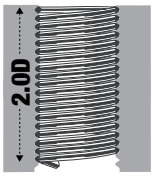
BSW – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	40	0.13	3528-1/8X1.0D	–	–	–	–	**0.796**	0.796	0.796	0.557	0.557	0.557	0.399	0.319	0.319	0.239
3/16	24	0.19	3528-3/16X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
1/4	20	0.25	3528-1/4X1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
5/16	18	0.31	3528-5/16X1.0D	–	–	–	–	**0.796**	0.796	0.796	0.557	0.557	0.557	0.399	0.319	0.319	0.239
3/8	16	0.38	3528-3/8X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
7/16	14	0.44	3528-7/16X1.0D	–	–	–	–	**1.386**	1.386	1.386	0.970	0.970	0.970	0.693	0.554	0.554	0.416
1/2	12	0.50	3528-1/2X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
9/16	12	0.56	3528-9/16X1.0D	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620	0.620
5/8	11	0.63	3528-5/8X1.0D	–	–	–	**2.772**	2.772	2.772	1.940	1.940	1.940	1.386	1.109	1.109	0.831	0.831
3/4	10	0.75	3528-3/4X1.0D	–	–	–	**3.981**	3.981	3.981	2.787	2.787	2.787	1.991	1.592	1.592	1.195	1.195
7/8	9	0.88	3528-7/8X1.0D	–	–	–	**6.781**	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035	2.035
1	8	1.00	3528-1X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653



BSW – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	40	0.20	3528-1/8X1.5D	–	–	–	–	**0.825**	0.825	0.825	0.578	0.578	0.578	0.413	0.330	0.330	0.248
3/16	24	0.29	3528-3/16X1.5D	–	–	–	–	**0.729**	0.729	0.729	0.510	0.510	0.510	0.364	0.292	0.292	0.218
1/4	20	0.38	3528-1/4X1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
5/16	18	0.47	3528-5/16X1.5D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
3/8	16	0.57	3528-3/8X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
7/16	14	0.66	3528-7/16X1.5D	–	–	–	–	**1.504**	1.504	1.504	1.053	1.053	1.053	0.753	0.602	0.602	0.452
1/2	12	0.75	3528-1/2X1.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
9/16	12	0.84	3528-9/16X1.5D	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708	0.708
5/8	11	0.95	3528-5/8X1.5D	–	–	–	**3.539**	3.539	3.539	2.477	2.477	2.477	1.769	1.415	1.415	1.062	1.062
3/4	10	1.13	3528-3/4X1.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
7/8	9	1.32	3528-7/8X1.5D	–	–	–	**7.961**	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388	2.388
1	8	1.50	3528-1X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007



BSW – 2.0D BULK INSERTS

D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	40	0.26	3528-1/8X2.0D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
3/16	24	0.38	3528-3/16X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
1/4	20	0.50	3528-1/4X2.0D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
5/16	18	0.62	3528-5/16X2.0D	–	–	–	–	**1.091**	1.091	1.091	0.763	0.763	0.763	0.546	0.437	0.437	0.328
3/8	16	0.76	3528-3/8X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
7/16	14	0.88	3528-7/16X2.0D	–	–	–	–	**1.651**	1.651	1.651	1.155	1.155	1.155	0.825	0.660	0.660	0.496
1/2	12	1.00	3528-1/2X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
9/16	12	1.12	3528-9/16X2.0D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
5/8	11	1.26	3528-5/8X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
3/4	10	1.50	3528-3/4X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
7/8	9	1.76	3528-7/8X2.0D	–	–	–	**9.140**	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742	2.742
1	8	2.00	3528-1X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449

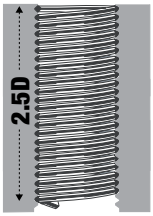
BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSW – 2.5D BULK INSERTS

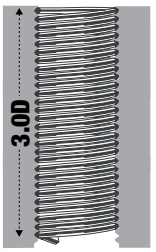
D			2.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	40	0.33	3528-1/8X2.5D	–	–	–	–	**1.062**	1.062	1.062	0.742	0.742	0.742	0.530	0.425	0.425	0.319
3/16	24	0.48	3528-3/16X2.5D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
1/4	20	0.63	3528-1/4X2.5D	–	–	–	–	**0.959**	0.959	0.959	0.672	0.672	0.672	0.480	0.383	0.383	0.288
5/16	18	0.78	3528-5/16X2.5D	–	–	–	–	**1.327**	1.327	1.327	0.929	0.929	0.929	0.664	0.530	0.530	0.399
3/8	16	0.95	3528-3/8X2.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
7/16	14	1.10	3528-7/16X2.5D	–	–	–	–	**1.916**	1.916	1.916	1.342	1.342	1.342	0.959	0.767	0.767	0.575
1/2	12	1.25	3528-1/2X2.5D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
9/16	12	1.40	3528-9/16X2.5D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
5/8	11	1.58	3528-5/8X2.5D	–	–	–	**5.602**	5.602	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681
3/4	10	1.88	3528-3/4X2.5D	–	–	–	**7.961**	7.961	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388
7/8	9	2.20	3528-7/8X2.5D	–	–	–	**10.910**	10.910	7.637	7.637	7.637	5.455	4.364	4.364	3.273	3.273	3.273
1	8	2.50	3528-1X2.5D	–	–	–	**14.152**	14.152	9.907	9.907	9.907	7.076	5.661	5.661	4.246	4.246	4.246

BSW



BSW – 3.0D BULK INSERTS

D			3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	40	0.39	3528-1/8X3.0D	–	–	–	–	**1.179**	1.179	1.179	0.825	0.825	0.825	0.590	0.471	0.471	0.354
3/16	24	0.57	3528-3/16X3.0D	–	–	–	–	**1.003**	1.003	1.003	0.702	0.702	0.702	0.501	0.401	0.401	0.300
1/4	20	0.75	3528-1/4X3.0D	–	–	–	–	**1.091**	1.091	1.091	0.763	0.763	0.763	0.546	0.437	0.437	0.328
5/16	18	0.93	3528-5/16X3.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
3/8	16	1.14	3528-3/8X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
7/16	14	1.32	3528-7/16X3.0D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
1/2	12	1.50	3528-1/2X3.0D	–	–	–	–	**3.243**	3.243	3.243	2.270	2.270	2.270	1.621	1.298	1.298	0.973
9/16	12	1.68	3528-9/16X3.0D	–	–	–	**5.307**	5.307	5.307	3.715	3.715	3.715	2.653	2.123	2.123	1.592	1.592
5/8	11	1.89	3528-5/8X3.0D	–	–	–	**6.781**	6.781	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035
3/4	10	2.25	3528-3/4X3.0D	–	–	–	**9.435**	9.435	9.435	6.605	6.605	6.605	4.718	3.774	3.774	2.831	2.831
7/8	9	2.64	3528-7/8X3.0D	–	–	–	**12.384**	12.384	8.669	8.669	8.669	6.192	4.953	4.953	3.715	3.715	3.715
1	8	3.00	3528-1X3.0D	–	–	–	**16.216**	16.216	11.352	11.352	11.352	8.108	6.487	6.487	4.865	4.865	4.865

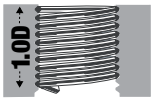


powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

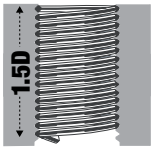
GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSF



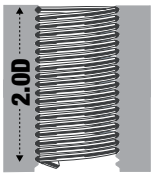
BSF – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3/16	32	0.19	3530-3/16X1.0D	–	–	–	–	**0.688**	0.688	0.688	0.482	0.482	0.482	0.344	0.275	0.275	0.207
1/4	26	0.25	3530-1/4X1.0D	–	–	–	–	**0.782**	0.782	0.782	0.547	0.547	0.547	0.391	0.312	0.312	0.235
5/16	22	0.31	3530-5/16X1.0D	–	–	–	–	**0.796**	0.796	0.796	0.557	0.557	0.557	0.399	0.319	0.319	0.239
3/8	20	0.38	3530-3/8X1.0D	–	–	–	–	**1.120**	1.120	1.120	0.784	0.784	0.784	0.561	0.447	0.447	0.336
7/16	18	0.44	3530-7/16X1.0D	–	–	–	–	**1.386**	1.386	1.386	0.970	0.970	0.970	0.693	0.554	0.554	0.416
1/2	16	0.50	3530-1/2X1.0D	–	–	–	–	**1.637**	1.637	1.637	1.146	1.146	1.146	0.819	0.655	0.655	0.491
9/16	16	0.56	3530-9/16X1.0D	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620	0.620
5/8	14	0.63	3530-5/8X1.0D	–	–	–	**2.772**	2.772	2.772	1.940	1.940	1.940	1.386	1.109	1.109	0.831	0.831
3/4	12	0.75	3530-3/4X1.0D	–	–	–	**3.981**	3.981	3.981	2.787	2.787	2.787	1.991	1.592	1.592	1.195	1.195
7/8	11	0.88	3530-7/8X1.0D	–	–	–	**6.781**	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035	2.035
1	10	1.00	3530-1X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653



BSF – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3/16	32	0.29	3530-3/16X1.5D	–	–	–	–	**0.729**	0.729	0.729	0.510	0.510	0.510	0.364	0.292	0.292	0.218
1/4	26	0.38	3530-1/4X1.5D	–	–	–	–	**0.812**	0.812	0.812	0.568	0.568	0.568	0.406	0.324	0.324	0.244
5/16	22	0.47	3530-5/16X1.5D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
3/8	20	0.57	3530-3/8X1.5D	–	–	–	–	**1.267**	1.267	1.267	0.888	0.888	0.888	0.634	0.507	0.507	0.380
7/16	18	0.66	3530-7/16X1.5D	–	–	–	–	**1.504**	1.504	1.504	1.053	1.053	1.053	0.753	0.602	0.602	0.452
1/2	16	0.75	3530-1/2X1.5D	–	–	–	–	**1.740**	1.740	1.740	1.218	1.218	1.218	0.870	0.695	0.695	0.522
9/16	16	0.84	3530-9/16X1.5D	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708	0.708
5/8	14	0.95	3530-5/8X1.5D	–	–	–	**3.539**	3.539	3.539	2.477	2.477	2.477	1.769	1.415	1.415	1.062	1.062
3/4	12	1.13	3530-3/4X1.5D	–	–	–	**4.718**	4.718	4.718	3.302	3.302	3.302	2.358	1.887	1.887	1.415	1.415
7/8	11	1.32	3530-7/8X1.5D	–	–	–	**7.961**	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388	2.388
1	10	1.50	3530-1X1.5D	–	–	–	**10.024**	10.024	7.017	7.017	7.017	5.013	4.010	4.010	3.007	3.007	3.007



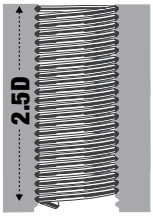
BSF – 2.0D BULK INSERTS

D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3/16	32	0.38	3530-3/16X2.0D	–	–	–	–	**0.770**	0.770	0.770	0.540	0.540	0.540	0.385	0.308	0.308	0.231
1/4	26	0.50	3530-1/4X2.0D	–	–	–	–	**0.914**	0.914	0.914	0.639	0.639	0.639	0.458	0.365	0.365	0.274
5/16	22	0.62	3530-5/16X2.0D	–	–	–	–	**1.091**	1.091	1.091	0.763	0.763	0.763	0.546	0.437	0.437	0.328
3/8	20	0.76	3530-3/8X2.0D	–	–	–	–	**1.445**	1.445	1.445	1.011	1.011	1.011	0.722	0.578	0.578	0.434
7/16	18	0.88	3530-7/16X2.0D	–	–	–	–	**1.651**	1.651	1.651	1.155	1.155	1.155	0.825	0.660	0.660	0.496
1/2	16	1.00	3530-1/2X2.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
9/16	16	1.12	3530-9/16X2.0D	–	–	–	**3.390**	3.390	3.390	2.374	2.374	2.374	1.696	1.357	1.357	1.017	1.017
5/8	14	1.26	3530-5/8X2.0D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
3/4	12	1.50	3530-3/4X2.0D	–	–	–	**6.192**	6.192	6.192	4.334	4.334	4.334	3.095	2.477	2.477	1.857	1.857
7/8	11	1.76	3530-7/8X2.0D	–	–	–	**9.140**	9.140	6.398	6.398	6.398	4.570	3.656	3.656	2.742	2.742	2.742
1	10	2.00	3530-1X2.0D	–	–	–	**11.499**	11.499	8.049	8.049	8.049	5.750	4.599	4.599	3.449	3.449	3.449

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BORDO® INDUSTRIAL TOOLS

BSF

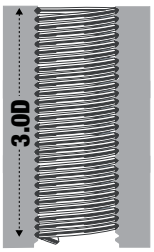


BSF – 2.5D BULK INSERTS

D			2.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3/16	32	0.48	3530-3/16X2.5D	–	–	–	–	**0.884**	0.884	0.884	0.620	0.620	0.620	0.442	0.354	0.354	0.266
1/4	26	0.63	3530-1/4X2.5D	–	–	–	–	**0.959**	0.959	0.959	0.672	0.672	0.672	0.480	0.383	0.383	0.288
5/16	22	0.78	3530-5/16X2.5D	–	–	–	–	**1.327**	1.327	1.327	0.929	0.929	0.929	0.664	0.530	0.530	0.399
3/8	20	0.95	3530-3/8X2.5D	–	–	–	–	**1.769**	1.769	1.769	1.238	1.238	1.238	0.884	0.708	0.708	0.530
7/16	18	1.10	3530-7/16X2.5D	–	–	–	–	**1.916**	1.916	1.916	1.342	1.342	1.342	0.959	0.767	0.767	0.575
1/2	16	1.25	3530-1/2X2.5D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
9/16	16	1.40	3530-9/16X2.5D	–	–	–	**4.423**	4.423	4.423	3.095	3.095	3.095	2.211	1.769	1.769	1.327	1.327
5/8	14	1.58	3530-5/8X2.5D	–	–	–	**5.602**	5.602	5.602	3.922	3.922	3.922	2.801	2.241	2.241	1.681	1.681
3/4	12	1.88	3530-3/4X2.5D	–	–	–	**7.961**	7.961	7.961	5.572	5.572	5.572	3.981	3.185	3.185	2.388	2.388
7/8	11	2.20	3530-7/8X2.5D	–	–	–	**10.910**	10.910	7.637	7.637	7.637	5.455	4.364	4.364	3.273	3.273	3.273
1	10	2.50	3530-1X2.5D	–	–	–	**14.152**	14.152	9.907	9.907	9.907	7.076	5.661	5.661	4.246	4.246	4.246

BSF – 3.0D BULK INSERTS

D			3.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
3/16	32	0.57	3530-3/16X3.0D	–	–	–	–	**1.003**	1.003	1.003	0.702	0.702	0.702	0.501	0.401	0.401	0.300
1/4	26	0.75	3530-1/4X3.0D	–	–	–	–	**1.091**	1.091	1.091	0.763	0.763	0.763	0.546	0.437	0.437	0.328
5/16	22	0.93	3530-5/16X3.0D	–	–	–	–	**1.474**	1.474	1.474	1.032	1.032	1.032	0.737	0.590	0.590	0.442
3/8	20	1.14	3530-3/8X3.0D	–	–	–	–	**2.064**	2.064	2.064	1.445	1.445	1.445	1.032	0.825	0.825	0.620
7/16	18	1.32	3530-7/16X3.0D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
1/2	16	1.50	3530-1/2X3.0D	–	–	–	–	**3.243**	3.243	3.243	2.270	2.270	2.270	1.621	1.298	1.298	0.973
9/16	16	1.68	3530-9/16X3.0D	–	–	–	**5.307**	5.307	5.307	3.715	3.715	3.715	2.653	2.123	2.123	1.592	1.592
5/8	14	1.89	3530-5/8X3.0D	–	–	–	**6.781**	6.781	6.781	4.747	4.747	4.747	3.390	2.712	2.712	2.035	2.035
3/4	12	2.25	3530-3/4X3.0D	–	–	–	**9.435**	9.435	9.435	6.605	6.605	6.605	4.718	3.774	3.774	2.831	2.831
7/8	11	2.64	3530-7/8X3.0D	–	–	–	**12.384**	12.384	8.669	8.669	8.669	6.192	4.953	4.953	3.715	3.715	3.715
1	10	3.00	3530-1X3.0D	–	–	–	**16.216**	16.216	11.352	11.352	11.352	8.108	6.487	6.487	4.865	4.865	4.865



powercoil® wire thread insert system

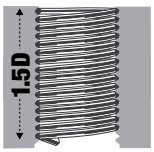
BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BSP

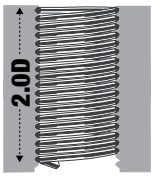
BSP – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	28	0.13	3546-1/8X1.0D	–	–	–	–	**1.649**	1.649	1.649	1.154	1.154	1.154	0.824	0.659	0.659	0.495
1/4	19	0.25	3546-1/4X1.0D	–	–	–	–	**2.358**	2.358	2.358	1.651	1.651	1.651	1.179	0.944	0.944	0.708
3/8	19	0.38	3546-3/8X1.0D	–	–	–	–	**2.599**	2.599	2.599	1.820	1.820	1.820	1.300	1.040	1.040	0.780
1/2	14	0.50	3546-1/2X1.0D	–	–	–	–	**4.597**	4.597	4.597	3.218	3.218	3.218	2.298	1.839	1.839	1.380
5/8	14	0.63	3546-5/8X1.0D	–	–	–	**6.836**	6.836	6.836	4.785	4.785	4.785	3.418	2.734	2.734	2.051	2.051
3/4	14	0.75	3546-3/4X1.0D	–	–	–	**7.076**	7.076	7.076	4.953	4.953	4.953	3.539	2.831	2.831	2.123	2.123
7/8	14	0.88	3546-7/8X1.0D	–	–	–	**8.496**	8.496	5.947	5.947	5.947	4.248	3.398	3.398	2.548	2.548	2.548
1	11	1.00	3546-1X1.0D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653



BSP – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	28	0.20	3546-1/8X1.5D	–	–	–	–	**1.934**	1.934	1.934	1.355	1.355	1.355	0.967	0.773	0.773	0.580
1/4	19	0.38	3546-1/4X1.5D	–	–	–	–	**2.831**	2.831	2.831	1.981	1.981	1.981	1.415	1.132	1.132	0.849
3/8	19	0.57	3546-3/8X1.5D	–	–	–	–	**3.539**	3.539	3.539	2.477	2.477	2.477	1.769	1.415	1.415	1.062
1/2	14	0.75	3546-1/2X1.5D	–	–	–	–	**5.779**	5.779	5.779	4.045	4.045	4.045	2.890	2.312	2.312	1.735
5/8	14	0.95	3546-5/8X1.5D	–	–	–	**8.255**	8.255	8.255	5.779	5.779	5.779	4.128	3.302	3.302	2.477	2.477
3/4	14	1.13	3546-3/4X1.5D	–	–	–	**8.491**	8.491	8.491	5.944	5.944	5.944	4.246	3.396	3.396	2.547	2.547
7/8	14	1.32	3546-7/8X1.5D	–	–	–	**8.845**	8.845	6.192	6.192	6.192	4.423	3.539	3.539	2.653	2.653	2.653
1	11	1.50	3546-1X1.5D	–	–	–	**11.204**	11.204	7.842	7.842	7.842	5.602	4.481	4.481	3.361	3.361	3.361



BSP – 2.0D BULK INSERTS

D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/8	28	0.26	3546-1/8X2.0D	–	–	–	–	**2.599**	2.599	2.599	1.820	1.820	1.820	1.300	1.040	1.040	0.780
1/4	19	0.50	3546-1/4X2.0D	–	–	–	–	**3.778**	3.778	3.778	2.645	2.645	2.645	1.889	1.511	1.511	1.134
3/8	19	0.76	3546-3/8X2.0D	–	–	–	–	**4.958**	4.958	4.958	3.470	3.470	3.470	2.479	1.983	1.983	1.487
1/2	14	1.00	3546-1/2X2.0D	–	–	–	–	**7.545**	7.545	7.545	5.282	5.282	5.282	3.773	3.019	3.019	2.264
5/8	14	1.26	3546-5/8X2.0D	–	–	–	**10.374**	10.374	10.374	7.262	7.262	7.262	5.187	4.150	4.150	3.112	3.112
3/4	14	1.50	3546-3/4X2.0D	–	–	–	**10.855**	10.855	10.855	7.598	7.598	7.598	5.427	4.342	4.342	3.256	3.256
7/8	14	1.76	3546-7/8X2.0D	–	–	–	**13.442**	13.442	9.410	9.410	9.410	6.721	5.377	5.377	4.033	4.033	4.033
1	11	2.00	3546-1X2.0D	–	–	–	**13.683**	13.683	9.578	9.578	9.578	6.842	5.473	5.473	4.104	4.104	4.104

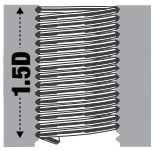
BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

NPT – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/16	27	0.271	3552-1/16X1.5D	–	–	–	–	**1.933**	1.933	1.933	1.353	1.353	1.353	0.966	0.773	0.773	0.580
1/8	27	0.273	3552-1/8X1.5D	–	–	–	–	**1.933**	1.933	1.933	1.353	1.353	1.353	0.966	0.773	0.773	0.580
1/4	18	0.394	3552-1/4X1.5D	–	–	–	–	**2.829**	2.829	2.829	1.980	1.980	1.980	1.414	1.131	1.131	0.848
3/8	18	0.407	3552-3/8X1.5D	–	–	–	–	**3.539**	3.539	3.539	2.477	2.477	2.477	1.769	1.415	1.415	1.062
1/2	14	0.534	3552-1/2X1.5D	–	–	–	**5.777**	5.777	4.044	4.044	4.044	2.889	2.311	2.311	1.733	1.733	1.733
3/4	14	0.553	3552-3/4X1.5D	–	–	–	**8.496**	8.496	5.947	5.947	5.947	4.248	3.398	3.398	2.548	2.548	2.548
1	11.5	0.661	3552-1X1.5D	–	–	–	**11.204**	11.204	7.842	7.842	7.842	5.602	4.481	4.481	3.361	3.361	3.361

NPT



powercoil® wire thread insert system

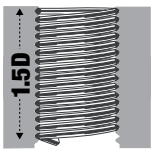
BORDO® INDUSTRIAL TOOLS

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

8-UN

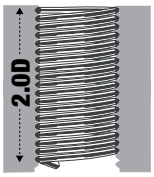
8-UN – 1.0D BULK INSERTS

D			1.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1-1/8	8	1.13	3570-1.1/8X1.0D	–	–	–	**12.023**	8.416	8.416	6.011	4.809	4.809	4.809	3.607	3.607	3.607	3.607
1-1/4	8	1.25	3570-1.1/4X1.0D	–	–	–	**13.608**	9.526	9.526	6.804	5.443	5.443	5.443	4.082	4.082	4.082	4.082
1-3/8	8	1.38	3570-1.3/8X1.0D	–	–	–	**15.876**	11.113	11.113	7.938	6.350	6.350	6.350	4.763	4.763	4.763	4.763
1-1/2	8	1.50	3570-1.1/2X1.0D	–	–	–	**18.144**	12.701	12.701	9.072	7.258	7.258	7.258	5.443	5.443	5.443	5.443
1-5/8	8	1.63	3570-1.5/8X1.0D	–	–	–	**31.752**	22.226	22.226	15.876	12.701	12.701	12.701	9.526	9.526	9.526	9.526
1-3/4	8	1.75	3570-1.3/4X1.0D	–	–	–	**31.752**	22.226	22.226	15.876	12.701	12.701	12.701	9.526	9.526	9.526	9.526
1-7/8	8	1.88	3570-1.7/8X1.0D	–	–	–	**36.288**	25.402	25.402	18.144	14.515	14.515	14.515	10.886	10.886	10.886	10.886
2	8	2.00	3570-2X1.0D	–	–	–	**38.556**	26.989	26.989	19.278	15.422	15.422	15.422	11.567	11.567	11.567	11.567



8-UN – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1-1/8	8	1.69	3570-1.1/8X1.5D	–	–	–	**14.060**	9.842	9.842	7.030	5.624	5.624	5.624	4.218	4.218	4.218	4.218
1-1/4	8	1.88	3570-1.1/4X1.5D	–	–	–	**15.876**	11.113	11.113	7.938	6.350	6.350	6.350	4.763	4.763	4.763	4.763
1-3/8	8	2.06	3570-1.3/8X1.5D	–	–	–	**17.693**	12.385	12.385	8.846	7.077	7.077	7.077	5.308	5.308	5.308	5.308
1-1/2	8	2.25	3570-1.1/2X1.5D	–	–	–	**21.095**	14.766	14.766	10.547	8.438	8.438	8.438	6.328	6.328	6.328	6.328
1-5/8	8	2.44	3570-1.5/8X1.5D	–	–	–	**35.154**	24.608	24.608	17.577	14.062	14.062	14.062	10.546	10.546	10.546	10.546
1-3/4	8	2.63	3570-1.3/4X1.5D	–	–	–	**39.690**	27.783	27.783	19.845	15.876	15.876	15.876	11.907	11.907	11.907	11.907
1-7/8	8	2.81	3570-1.7/8X1.5D	–	–	–	**45.360**	31.752	31.752	22.680	18.144	18.144	18.144	13.608	13.608	13.608	13.608
2	8	3.00	3570-2X1.5D	–	–	–	**49.896**	34.927	34.927	24.948	19.958	19.958	19.958	14.969	14.969	14.969	14.969



8-UN – 2.0D BULK INSERTS

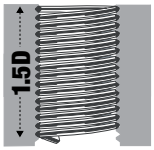
D			2.0D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1-1/8	8	2.25	3570-1.1/8X2.0D	–	–	–	**16.107**	11.275	11.275	8.054	6.443	6.443	6.443	4.832	4.832	4.832	4.832
1-1/4	8	2.50	3570-1.1/4X2.0D	–	–	–	**20.412**	14.288	14.288	10.206	8.165	8.165	8.165	6.124	6.124	6.124	6.124
1-3/8	8	2.75	3570-1.3/8X2.0D	–	–	–	**22.680**	15.876	15.876	11.340	9.072	9.072	9.072	6.804	6.804	6.804	6.804
1-1/2	8	3.00	3570-1.1/2X2.0D	–	–	–	**27.216**	19.051	19.051	13.608	10.886	10.886	10.886	8.165	8.165	8.165	8.165
1-5/8	8	3.25	3570-1.5/8X2.0D	–	–	–	**45.360**	31.752	31.752	22.680	18.144	18.144	18.144	13.608	13.608	13.608	13.608
1-3/4	8	3.50	3570-1.3/4X2.0D	–	–	–	**49.896**	34.927	34.927	24.948	19.958	19.958	19.958	14.969	14.969	14.969	14.969
1-7/8	8	3.75	3570-1.7/8X2.0D	–	–	–	**56.700**	39.690	39.690	28.350	22.680	22.680	22.680	17.010	17.010	17.010	17.010
2	8	4.00	3570-2X2.0D	–	–	–	**63.504**	44.453	44.453	31.752	25.402	25.402	25.402	19.051	19.051	19.051	19.051

GROUP	PCWI
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BA – 1.5D BULK INSERTS

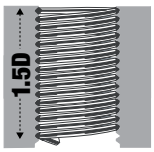
D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
	INCH	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
0	0.0394	0.24	3544-0X1.5D	–	–	–	–	**12.384**	12.384	12.384	8.669	8.669	8.669	6.192	4.953	4.953	3.715
2	0.0319	0.19	3544-2X1.5D	–	–	–	–	**1.300**	1.300	1.300	0.909	0.909	0.909	0.650	0.520	0.520	0.390
4	0.0260	0.14	3544-4X1.5D	–	–	–	–	**1.300**	1.300	1.300	0.909	0.909	0.909	0.650	0.520	0.520	0.390
6	0.0209	0.11	3544-6X1.5D	–	–	–	–	**8.255**	8.255	8.255	5.779	5.779	5.779	4.128	3.302	3.302	2.477

BA
BSC



BSC(B) – 1.5D BULK INSERTS

D			1.5D	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH	$ EACH
INCH	TPI	INCH	PART #	1	2	3	5	10	25	50	100	125	250	500	1000	2500	5000
1/4	26	0.38	3560-1/4X1.5D	–	–	–	–	**1.082**	1.082	1.082	0.757	0.757	0.757	0.541	0.433	0.433	0.324
5/16	26	0.47	3560-5/16X1.5D	–	–	–	–	**1.407**	1.407	1.407	0.985	0.985	0.985	0.704	0.563	0.563	0.422
3/8	26	0.56	3560-3/8X1.5D	–	–	–	–	**1.638**	1.638	1.638	1.147	1.147	1.147	0.819	0.655	0.655	0.491
7/16	26	0.66	3560-7/16x1.5D	–	–	–	–	**2.268**	2.268	2.268	1.588	1.588	1.588	1.134	0.907	0.907	0.680
1/2	26	0.75	3560-1/2X1.5D	–	–	–	–	**3.778**	3.778	3.778	2.645	2.645	2.645	1.889	1.511	1.511	1.134

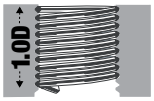


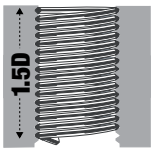
powercoil® wire thread insert system

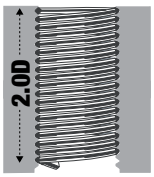
GROUP	PCIR
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

BORDO® INDUSTRIAL TOOLS

MC
MF







METRIC

D					1.0D		1.5D		2.0D	
MM	MM	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
2.20	0.45	**1.0D**	2.20MM	1000	**0.38**	3520-2.20X1.0DIR	–	–	–	–
2.20	0.45	**1.5D**	3.30MM	1000	–	–	**0.41**	3520-2.20X1.5DIR	–	–
2.20	0.45	**2.0D**	4.40MM	1000	–	–	–	–	**0.42**	3520-2.20X2.0DIR
2.50	0.45	**1.0D**	2.50MM	1000	**0.35**	3520-2.50X1.0DIR	–	–	–	–
2.50	0.45	**1.5D**	3.75MM	1000	–	–	**0.37**	3520-2.50X1.5DIR	–	–
2.50	0.45	**2.0D**	5.00MM	1000	–	–	–	–	**0.39**	3520-2.50X2.0DIR
3.00	0.50	**1.0D**	3.00MM	1000	**0.35**	3520-3.00X1.0DIR	–	–	–	–
3.00	0.50	**1.5D**	4.50MM	1000	–	–	**0.37**	3520-3.00X1.5DIR	–	–
3.00	0.50	**2.0D**	6.00MM	1000	–	–	–	–	**0.39**	3520-3.00X2.0DIR
4.00	0.70	**1.0D**	4.00MM	1000	**0.35**	3520-4.00X1.0DIR	–	–	–	–
4.00	0.70	**1.5D**	6.00MM	1000	–	–	**0.37**	3520-4.00X1.5DIR	–	–
4.00	0.70	**2.0D**	8.00MM	1000	–	–	–	–	**0.39**	3520-4.00X2.0DIR
5.00	0.80	**1.0D**	5.00MM	1000	**0.44**	3520-5.00X1.0DIR	–	–	–	–
5.00	0.80	**1.5D**	7.50MM	1000	–	–	**0.46**	3520-5.00X1.5DIR	–	–
5.00	0.80	**2.0D**	10.00MM	1000	–	–	–	–	**0.48**	3520-5.00X2.0DIR
6.00	1.00	**1.0D**	6.00MM	500	**0.47**	3520-6.00X1.0DIR	–	–	–	–
6.00	1.00	**1.5D**	9.00MM	500	–	–	**0.51**	3520-6.00X1.5DIR	–	–
6.00	1.00	**2.0D**	12.00MM	500	–	–	–	–	**0.55**	3520-6.00X2.0DIR
8.00	1.00	**1.0D**	8.00MM	250	**0.69**	3521-8.00X1.0DIR	–	–	–	–
8.00	1.00	**1.5D**	12.00MM	250	–	–	**0.79**	3521-8.00X1.5DIR	–	–
8.00	1.00	**2.0D**	16.00MM	250	–	–	–	–	**0.87**	3521-8.00X2.0DIR
8.00	1.25	**1.0D**	8.00MM	250	**0.69**	3520-8.00X1.0DIR	–	–	–	–
8.00	1.25	**1.5D**	12.00MM	250	–	–	**0.79**	3520-8.00X1.5DIR	–	–
8.00	1.25	**2.0D**	16.00MM	250	–	–	–	–	**0.87**	3520-8.00X2.0DIR
10.00	1.50	**1.0D**	10.00MM	250	**0.98**	3520-10.00X1.0DIR	–	–	–	–
10.00	1.50	**1.5D**	15.00MM	250	–	–	**1.11**	3520-10.00X1.5DIR	–	–
10.00	1.50	**2.0D**	20.00MM	250	–	–	–	–	**1.27**	3520-10.00X2.0DIR
12.00	1.75	**1.0D**	12.00MM	125	**1.43**	3520-12.00X1.0DIR	–	–	–	–
12.00	1.75	**1.5D**	18.00MM	125	–	–	**1.54**	3520-12.00X1.5DIR	–	–
12.00	1.75	**2.0D**	24.00MM	125	–	–	–	–	**1.81**	3520-12.00X2.0DIR

GROUP	PCIR
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	**FREE RUNNING**

UNC

					1.0D		1.5D		2.0D	
INCH	TPI	INSTALLED LENGTH		#	$	PART #	$	PART #	$	PART #
2G	56	**1.0D**	0.09"	1000	**0.44**	3532-2GX1.0DIR	–	–	–	–
2G	56	**1.5D**	0.13"	1000	–	–	**0.48**	3532-2GX1.5DIR	–	–
2G	56	**2.0D**	0.17"	1000	–	–	–	–	**0.50**	3532-2GX2.0DIR
4G	40	**1.0D**	0.11"	1000	**0.34**	3532-4GX1.0DIR	–	–	–	–
4G	40	**1.5D**	0.17"	1000	–	–	**0.36**	3532-4GX1.5DIR	–	–
4G	40	**2.0D**	0.22"	1000	–	–	–	–	**0.39**	3532-4GX2.0DIR
5G	40	**1.0D**	0.13"	1000	**0.34**	3532-5GX1.0DIR	–	–	–	–
5G	40	**1.5D**	0.19"	1000	–	–	**0.36**	3532-5GX1.5DIR	–	–
5G	40	**2.0D**	0.25"	1000	–	–	–	–	**0.39**	3532-5GX2.0DIR
6G	32	**1.0D**	0.14"	1000	**0.34**	3532-6GX1.0DIR	–	–	–	–
6G	32	**1.5D**	0.21"	1000	–	–	**0.36**	3532-6GX1.5DIR	–	–
6G	32	**2.0D**	0.28"	1000	–	–	–	–	**0.39**	3532-6GX2.0DIR
8G	32	**1.0D**	0.16"	1000	**0.34**	3532-8GX1.0DIR	–	–	–	–
8G	32	**1.5D**	0.25"	1000	–	–	**0.36**	3532-8GX1.5DIR	–	–
8G	32	**2.0D**	0.33"	1000	–	–	–	–	**0.39**	3532-8GX2.0DIR
10G	24	**1.0D**	0.19"	1000	**0.34**	3532-10GX1.0DIR	–	–	–	–
10G	24	**1.5D**	0.29"	1000	–	–	**0.45**	3532-10GX1.5DIR	–	–
10G	24	**2.0D**	0.38"	1000	–	–	–	–	**0.48**	3532-10GX2.0DIR
12G	24	**1.0D**	0.22"	500	**0.42**	3532-12Gx1.0DIR	–	–	–	–
12G	24	**1.5D**	0.32"	500	–	–	**0.44**	3532-12GX1.5DIR	–	–
12G	24	**2.0D**	0.43"	500	–	–	–	–	**0.46**	3532-12GX2.0DIR
1/4	20	**1.0D**	0.25"	500	**0.49**	3532-1/4X1.0DIR	–	–	–	–
1/4	20	**1.5D**	0.38"	500	–	–	**0.50**	3532-1/4X1.5DIR	–	–
1/4	20	**2.0D**	0.50"	500	–	–	–	–	**0.57**	3532-1/4X2.0DIR
5/16	18	**1.0D**	0.31"	250	**0.75**	3532-5/16X1.0DIR	–	–	–	–
5/16	18	**1.5D**	0.47"	250	–	–	**0.79**	3532-5/16X1.5DIR	–	–
5/16	18	**2.0D**	0.62"	250	–	–	–	–	**0.86**	3532-5/16X2.0DIR
3/8	16	**1.0D**	0.38"	250	**1.01**	3532-3/8X1.0DIR	–	–	–	–
3/8	16	**1.5D**	0.57"	250	–	–	**1.11**	3532-3/8X1.5DIR	–	–
3/8	16	**2.0D**	0.76"	250	–	–	–	–	**1.29**	3532-3/8X2.0DIR
UNF										
4G	48	**1.0D**	0.11"	1000	**0.34**	3534-4GX1.0DIR	–	–	–	–
4G	48	**1.5D**	0.17"	1000	–	–	**0.36**	3534-4GX1.5DIR	–	–
4G	48	**2.0D**	0.22"	1000	–	–	–	–	**0.39**	3534-4GX2.0DIR
6G	40	**1.0D**	0.14"	1000	**0.34**	3534-6GX1.0DIR	–	–	–	–
6G	40	**1.5D**	0.21"	1000	–	–	**0.36**	3534-6GX1.5DIR	–	–
6G	40	**2.0D**	0.28"	1000	–	–	–	–	**0.39**	3534-6GX2.0DIR
8G	36	**1.0D**	0.16"	1000	**0.34**	3534-8GX1.0DIR	–	–	–	–
8G	36	**1.5D**	0.25"	1000	–	–	**0.36**	3534-8GX1.5DIR	–	–
8G	36	**2.0D**	0.33"	1000	–	–	–	–	**0.39**	3534-8GX2.0DIR
10G	32	**1.0D**	0.19"	1000	**0.34**	3534-10GX1.0DIR	–	–	–	–
10G	32	**1.5D**	0.29"	1000	–	–	**0.45**	3534-10GX1.5DIR	–	–
10G	32	**2.0D**	0.38"	1000	–	–	–	–	**0.48**	3534-10GX2.0DIR
1/4	28	**1.0D**	0.25"	500	**0.49**	3534-1/4X1.0DIR	–	–	–	–
1/4	28	**1.5D**	0.38"	500	–	–	**0.50**	3534-1/4X1.5DIR	–	–
1/4	28	**2.0D**	0.50"	500	–	–	–	–	**0.57**	3534-1/4X2.0DIR
5/16	24	**1.0D**	0.31"	250	**0.75**	3534-5/16X1.0DIR	–	–	–	–
5/16	24	**1.5D**	0.47"	250	–	–	**0.79**	3534-5/16X1.5DIR	–	–
5/16	24	**2.0D**	0.62"	250	–	–	–	–	**0.86**	3534-5/16X2.0DIR
3/8	24	**1.0D**	0.38"	250	**1.01**	3534-3/8X1.0DIR	–	–	–	–
3/8	24	**1.5D**	0.57"	250	–	–	**1.11**	3534-3/8X1.5DIR	–	–
3/8	24	**2.0D**	0.76"	250	–	–	–	–	**1.28**	3534-3/8X2.0DIR

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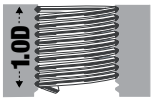
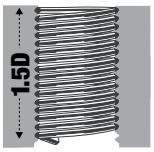
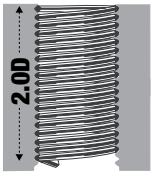






powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCTP	PCTP
MATERIAL	HSS	HSSE
TOLERANCE	4H5H	4H5H
TYPE	**STI**	**STI**

METRIC COARSE – STI TAPS

D				60° 6-8	60° 4-5	60° 2-3		60°	60°
MM	MM	MM	$	PART #	PART #	PART #	$	PART #	PART #
2.00	0.40	44.50	**56.61**	3520-2.00T	3520-2.00I	3520-2.00B	**71.95**	3520-2.00SP	3520-2.00SF
2.20	0.45	44.50	**56.61**	3520-2.20T	3520-2.20I	3520-2.20B	**71.95**	3520-2.20SP	3520-2.20SF
2.50	0.45	48.00	**41.28**	3520-2.50T	3520-2.50I	3520-2.50B	**47.47**	3520-2.50SP	3520-2.50SF
3.00	0.50	53.00	**35.39**	3520-3.00T	3520-3.00I	3520-3.00B	**47.18**	3520-3.00SP	3520-3.00SF
3.50	0.60	53.00	**41.28**	3520-3.50T	3520-3.50I	3520-3.50B	**47.47**	3520-3.50SP	3520-3.50SF
4.00	0.70	58.00	**33.02**	3520-4.00T	3520-4.00I	3520-4.00B	**41.28**	3520-4.00SP	3520-4.00SF
5.00	0.80	66.00	**33.02**	3520-5.00T	3520-5.00I	3520-5.00B	**41.28**	3520-5.00SP	3520-5.00SF
6.00	1.00	72.00	**33.02**	3520-6.00T	3520-6.00I	3520-6.00B	**44.81**	3520-6.00SP	3520-6.00SF
7.00	1.00	72.00	**41.28**	3520-7.00T	3520-7.00I	3520-7.00B	**44.81**	3520-7.00SP	3520-7.00SF
8.00	1.25	80.00	**38.92**	3520-8.00T	3520-8.00I	3520-8.00B	**48.35**	3520-8.00SP	3520-8.00SF
9.00	1.25	85.00	**58.97**	3520-9.00T	3520-9.00I	3520-9.00B	–	–	–
10.00	1.50	89.00	**47.18**	3520-10.00T	3520-10.00I	3520-10.00B	**53.07**	3520-10.00SP	3520-10.00SF
11.00	1.50	89.00	**64.87**	3520-11.00T	3520-11.00I	3520-11.00B	**77.84**	3520-11.00SP	3520-11.00SF
12.00	1.75	95.00	**64.87**	3520-12.00T	3520-12.00I	3520-12.00B	**76.66**	3520-12.00SP	3520-12.00SF
13.00	1.75	95.00	**106.14**	3520-13.00T	3520-13.00I	3520-13.00B	–	–	–
14.00	2.00	102.00	**76.66**	3520-14.00T	3520-14.00I	3520-14.00B	**94.35**	3520-14.00SP	3520-14.00SF
15.00	2.00	112.00	**94.35**	3520-15.00T	3520-15.00I	3520-15.00B	–	–	–
16.00	2.00	112.00	**88.45**	3520-16.00T	3520-16.00I	3520-16.00B	**106.14**	3520-16.00SP	3520-16.00SF
18.00	2.50	118.00	**141.52**	3520-18.00T	3520-18.00I	3520-18.00B	**212.29**	3520-18.00SP	3520-18.00SF
20.00	2.50	118.00	**153.32**	3520-20.00T	3520-20.00I	3520-20.00B	**176.90**	3520-20.00SP	3520-20.00SF
22.00	2.50	130.00	**176.90**	3520-22.00T	3520-22.00I	3520-22.00B	**187.13**	3520-22.00SP	3520-22.00SF
24.00	3.00	138.00	**212.29**	3520-24.00T	3520-24.00I	3520-24.00B	**224.08**	3520-24.00SP	3520-24.00SF
27.00	3.00	151.00	**229.97**	–	3520-27.00I	–	–	–	–
30.00	3.50	162.00	**306.63**	–	3520-30.00I	–	**342.02**	3520-30.00SP	3520-30.00SF
33.00	3.50	162.00	**306.63**	–	3520-33.00I	–	**409.50**	3520-33.00SP	3520-33.00SF
36.00	4.00	170.00	**342.02**	–	3520-36.00I	–	–	–	–

GROUP	PCTP	PCTP
MATERIAL	HSS	HSSE
TOLERANCE	4H5H	4H5H
TYPE	**STI**	**STI**

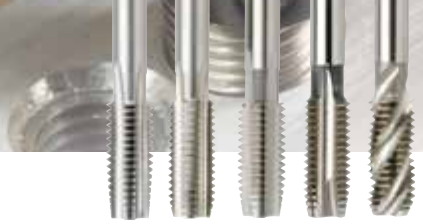
METRIC FINE – STI TAPS

D				60° 6-8	60° 4-5	60° 2-3		60°	60°
MM	MM	MM	$	PART #	PART #	PART #	$	PART #	PART #
8.00	1.00	80.00	**41.28**	3521-8.00T	3521-8.00I	3521-8.00B	**47.18**	3521-8.00SP	3521-8.00SF
10.00	1.25	85.00	**47.18**	3521-10.00T	3521-10.00I	3521-10.00B	**58.97**	3521-10.00SP	3521-10.00SF
10.00	1.00	85.00	**53.07**	3523-10.00T	3523-10.00I	3523-10.00B	**58.97**	3523-10.00SP	3523-10.00SF
11.00	1.25	88.00	**64.87**	3521-11.00T	3521-11.00I	3521-11.00B	–	–	–
11.00	1.00	88.00	**82.55**	3523-11.00T	3523-11.00I	3523-11.00B	–	–	–
12.00	1.50	95.00	**64.87**	3521-12.00T	3521-12.00I	3521-12.00B	**82.55**	3521-12.00SP	3521-12.00SF
12.00	1.25	95.00	**70.76**	3523-12.00T	3523-12.00I	3523-12.00B	**82.55**	3523-12.00SP	3523-12.00SF
12.00	1.00	95.00	**112.04**	3524-12.00T	3524-12.00I	3524-12.00B	–	–	–
13.00	1.25	95.00	**106.14**	3523-13.00T	3523-13.00I	3523-13.00B	–	–	–
14.00	1.50	102.00	**76.66**	3521-14.00T	3521-14.00I	3521-14.00B	**106.14**	3521-14.00SP	3521-14.00SF
14.00	1.25	102.00	**80.20**	3523-14.00T	3523-14.00I	3523-14.00B	**106.14**	3523-14.00SP	3523-14.00SF
14.00	1.00	102.00	**80.20**	3524-14.00T	3524-14.00I	3524-14.00B	–	–	–
15.00	1.50	104.00	**106.14**	3521-15.00T	3521-15.00I	3521-15.00B	–	–	–
16.00	1.50	104.00	**94.35**	3521-16.00T	3521-16.00I	3521-16.00B	–	–	–
18.00	2.00	104.00	**153.32**	3521-18.00T	3521-18.00I	3521-18.00B	–	–	–
18.00	1.50	104.00	**141.52**	3523-18.00T	3523-18.00I	3523-18.00B	–	–	–
20.00	2.00	113.00	**165.11**	3521-20.00T	3521-20.00I	3521-20.00B	–	–	–
20.00	1.50	113.00	**159.21**	3523-20.00T	3523-20.00I	3523-20.00B	–	–	–
22.00	2.00	120.00	**188.70**	3521-22.00T	3521-22.00I	3521-22.00B	–	–	–
22.00	1.50	120.00	**176.90**	3523-22.00T	3523-22.00I	3523-22.00B	–	–	–
24.00	2.00	127.00	**224.08**	3521-24.00T	3521-24.00I	3521-24.00B	–	–	–
24.00	1.50	120.00	**212.29**	3523-24.00T	3523-24.00I	3523-24.00B	–	–	–
26.00	1.50	127.00	**229.97**	3523-26.00T	3523-26.00I	3523-26.00B	–	–	–
27.00	2.00	127.00	**229.97**	3521-27.00T	3521-27.00I	3521-27.00B	–	–	–
27.00	1.50	127.00	**229.97**	3523-27.00T	3523-27.00I	3523-27.00B	–	–	–
28.00	1.50	127.00	**306.63**	3523-28.00T	3523-28.00I	3523-28.00B	–	–	–
30.00	2.00	137.00	**306.63**	3521-30.00T	3521-30.00I	3521-30.00B	–	–	–
30.00	1.50	137.00	**306.63**	3523-30.00T	3523-30.00I	3523-30.00B	–	–	–
33.00	2.00	144.00	**306.63**	3521-33.00T	3521-33.00I	3521-33.00B	–	–	–
36.00	3.00	170.00	**342.02**	3521-36.00T	3521-36.00I	3521-36.00B	–	–	–
36.00	2.00	150.00	**342.02**	3523-36.00T	3523-36.00I	3523-36.00B	–	–	–
36.00	1.50	150.00	**342.02**	3524-36.00T	3524-36.00I	3524-36.00B	–	–	–

SPARK PLUG – PILOT NOSE STI TAPS

D			60°	
MM	MM	MM	$	PART #
6.00	1.00	70.00	**47.18**	3520-6.00PN
8.00	1.25	75.00	**58.97**	3520-8.00PN
10.00	1.50	80.00	**64.87**	3520-10.00PN
10.00	1.00	74.00	**76.66**	3522-10.00PN
12.00	1.25	75.00	**82.55**	3522-12.00PN
14.00	1.25	90.00	**91.99**	3522-14.00PN
18.00	1.50	116.00	**176.90**	3522-18.00PN

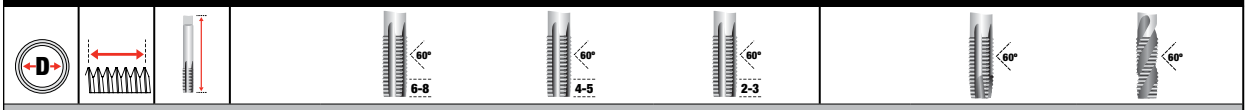
powercoil® wire thread insert system



BORDO® INDUSTRIAL TOOLS

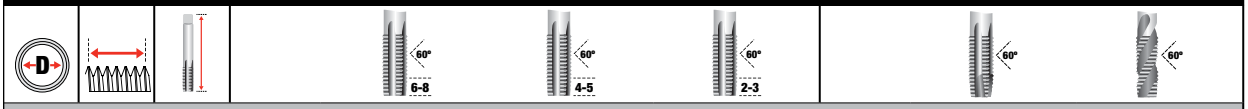
GROUP	PCTP	PCTP
MATERIAL	HSS	HSSE
TOLERANCE	3B	3B
TYPE	**STI**	**STI**

UNC – STI TAPS



INCH	TPI	MM	$	PART #	PART #	PART #	$	PART #	PART #
2G	56	48.00	**37.74**	3532-2GT	3532-2GI	3532-2GB	**44.81**	3532-2GSP	3532-2GSF
3G	48	48.00	**58.97**	3532-3GT	3532-3GI	3532-3GB	**70.76**	3532-3GSP	3532-3GSF
4G	40	53.00	**37.74**	3532-4GT	3532-4GI	3532-4GB	**44.81**	3532-4GSP	3532-4GSF
5G	40	53.00	**41.28**	3532-5GT	3532-5GI	3532-5GB	**47.18**	3532-5GSP	3532-5GSF
6G	32	58.00	**33.02**	3532-6GT	3532-6GI	3532-6GB	**41.28**	3532-6GSP	3532-6GSF
8G	32	62.00	**35.39**	3532-8GT	3532-8GI	3532-8GB	**41.28**	3532-8GSP	3532-8GSF
10G	24	66.00	**35.39**	3532-10GT	3532-10GI	3532-10GB	**41.28**	3532-10GSP	3532-10GSF
12G	24	66.00	**37.74**	3532-12GT	3532-12GI	3532-12GB	**47.18**	3532-12GSP	3532-12GSF
1/4	20	72.00	**35.39**	3532-1/4T	3532-1/4I	3532-1/4B	**44.81**	3532-1/4SP	3532-1/4SF
5/16	18	80.00	**38.92**	3532-5/16T	3532-5/16I	3532-5/16B	**47.18**	3532-5/16SP	3532-5/16SF
3/8	16	85.00	**42.46**	3532-3/8T	3532-3/8I	3532-3/8B	**53.07**	3532-3/8SP	3532-3/8SF
7/16	14	95.00	**56.61**	3532-7/16T	3532-7/16I	3532-7/16B	**70.76**	3532-7/16SP	3532-7/16SF
1/2	13	102.00	**63.68**	3532-1/2T	3532-1/2I	3532-1/2B	**79.01**	3532-1/2SP	3532-1/2SF
9/16	12	112.00	**76.66**	3532-9/16T	3532-9/16I	3532-9/16B	–	–	–
5/8	11	112.00	**88.45**	3532-5/8T	3532-5/8I	3532-5/8B	**106.14**	3532-5/8SP	3532-5/8SF
3/4	10	118.00	**135.63**	3532-3/4T	3532-3/4I	3532-3/4B	**155.97**	3532-3/4SP	3532-3/4SF
7/8	9	130.00	**171.00**	3532-7/8T	3532-7/8I	3532-7/8B	**212.29**	3532-7/8SP	3532-7/8SF
1	8	138.00	**212.29**	3532-1T	3532-1I	3532-1B	**233.75**	3532-1SP	3532-1SF
1-1/8	7	151.00	**212.29**	3532-1.1/8T	3532-1.1/8I	3532-1.1/8B	–	–	–
1-1/4	7	162.00	**253.56**	3532-1.1/4T	3532-1.1/4I	3532-1.1/4B	–	–	–
1-3/8	6	170.00	**312.53**	3532-1.3/8T	3532-1.3/8I	3532-1.3/8B	–	–	–
1-1/2	6	187.00	**412.78**	3532-1.1/2T	3532-1.1/2I	3532-1.1/2B	–	–	–

UNF – STI TAPS



INCH	TPI	MM	$	PART #	PART #	PART #	$	PART #	PART #
3G	56	48.00	**58.97**	3534-3GT	3534-3GI	3534-3GB	**70.76**	3534-3GSP	3534-3GSF
4G	48	53.00	**58.97**	3534-4GT	3534-4GI	3534-4GB	**70.76**	3534-4GSP	3534-4GSF
6G	40	53.00	**58.97**	3534-6GT	3534-6GI	3534-6GB	**70.76**	3534-6GSP	3534-6GSF
8G	36	62.00	**58.97**	3534-8GT	3534-8GI	3534-8GB	**70.76**	3534-8GSP	3534-8GSF
10G	32	66.00	**35.39**	3534-10GT	3534-10GI	3534-10GB	**41.28**	3534-10GSP	3534-10GSF
12G	28	66.00	**39.69**	3534-12GT	3534-12GI	3534-12GB	**56.70**	3534-12GSP	3534-12GSF
1/4	28	69.00	**35.39**	3534-1/4T	3534-1/4I	3534-1/4B	**44.81**	3534-1/4SP	3534-1/4SF
5/16	24	76.00	**38.92**	3534-5/16T	3534-5/16I	3534-5/16B	**47.18**	3534-5/16SP	3534-5/16SF
3/8	24	82.00	**42.46**	3534-3/8T	3534-3/8I	3534-3/8B	**53.07**	3534-3/8SP	3534-3/8SF
7/16	20	84.00	**56.61**	3534-7/16T	3534-7/16I	3534-7/16B	**70.76**	3534-7/16SP	3534-7/16SF
1/2	20	90.00	**63.68**	3534-1/2T	3534-1/2I	3534-1/2B	**79.01**	3534-1/2SP	3534-1/2SF
9/16	18	104.00	**76.66**	3534-9/16T	3534-9/16I	3534-9/16B	**92.82**	3534-9/16SP	3534-9/16SF
5/8	18	104.00	**88.45**	3534-5/8T	3534-5/8I	3534-5/8B	**106.14**	3534-5/8SP	3534-5/8SF
3/4	16	104.00	**135.63**	3534-3/4T	3534-3/4I	3534-3/4B	**158.34**	3534-3/4SP	3534-3/4SF
7/8	14	120.00	**171.00**	3534-7/8T	3534-7/8I	3534-7/8B	**212.29**	3534-7/8SP	3534-7/8SF
1	12	127.00	**212.29**	3534-1T	3534-1I	3534-1B	**233.75**	3534-1SP	3534-1SF
1	14	127.00	**224.08**	3535-1T	3535-1I	3535-1B	**267.54**	3535-1SP	3535-1SF
1-1/8	12	137.00	**212.29**	3534-1.1/8T	3534-1.1/8I	3534-1.1/8B	–	–	–
1-1/4	12	144.00	**253.56**	3534-1.1/4T	3534-1.1/4I	3534-1.1/4B	–	–	–
1-3/8	12	150.00	**312.53**	3534-1.3/8T	3534-1.3/8I	3534-1.3/8B	–	–	–
1-1/2	12	150.00	**412.78**	3534-1.1/2T	3534-1.1/2I	3534-1.1/2B	–	–	–

BORDO® INDUSTRIAL TOOLS

GROUP	PCTP
MATERIAL	HSS
TOLERANCE	3B
TYPE	**STI**

BSW – STI TAPS

INCH	TPI	MM	$	PART #	PART #	PART #
1/8	40	53.00	**58.97**	3528-1/8T	3528-1/8I	3528-1/8B
3/16	24	56.00	**41.28**	3528-3/16T	3528-3/16I	3528-3/16B
1/4	20	72.00	**38.92**	3528-1/4T	3528-1/4I	3528-1/4B
5/16	18	80.00	**41.28**	3528-5/16T	3528-5/16I	3528-5/16B
3/8	16	85.00	**47.18**	3528-3/8T	3528-3/8I	3528-3/8B
7/16	14	95.00	**61.33**	3528-7/16T	3528-7/16I	3528-7/16B
1/2	12	102.00	**68.41**	3528-1/2T	3528-1/2I	3528-1/2B
9/16	12	102.00	**88.45**	3528-9/16T	3528-9/16I	3528-9/16B
5/8	11	112.00	**100.24**	3528-5/8T	3528-5/8I	3528-5/8B
11/16	11	112.00	**113.40**	3528-11/16T	3528-11/16I	3528-11/16B
3/4	10	118.00	**147.42**	3528-3/4T	3528-3/4I	3528-3/4B
7/8	9	130.00	**182.81**	3528-7/8T	3528-7/8I	3528-7/8B
1	8	138.00	**235.87**	3528-1T	3528-1I	3528-1B

BSF – STI TAPS

INCH	TPI	MM	$	PART #	PART #	PART #
3/16	32	66.00	**53.07**	3530-3/16T	3530-3/16I	3530-3/16B
1/4	26	72.00	**53.07**	3530-1/4T	3530-1/4I	3530-1/4B
5/16	22	80.00	**56.61**	3530-5/16T	3530-5/16I	3530-5/16B
3/8	20	85.00	**64.87**	3530-3/8T	3530-3/8I	3530-3/8B
7/16	18	89.00	**88.45**	3530-7/16T	3530-7/16I	3530-7/16B
1/2	16	95.00	**94.35**	3530-1/2T	3530-1/2I	3530-1/2B
9/16	16	102.00	**106.14**	3530-9/16T	3530-9/16I	3530-9/16B
5/8	14	112.00	**129.73**	3530-5/8T	3530-5/8I	3530-5/8B
11/16	14	112.00	**158.76**	3530-11/16T	3530-11/16I	3530-11/16B
3/4	12	118.00	**200.49**	3530-3/4T	3530-3/4I	3530-3/4B
7/8	11	130.00	**218.18**	3530-7/8T	3530-7/8I	3530-7/8B
1	10	138.00	**300.74**	3530-1T	3530-1I	3530-1B

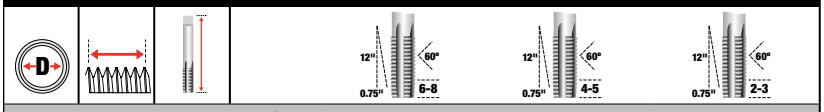
BSP – STI TAPS

INCH	TPI	MM	$	PART #	PART #	PART #
1/8	28	59.00	**53.07**	3546-1/8T	3546-1/8I	3546-1/8B
1/4	19	67.00	**67.81**	3546-1/4T	3546-1/4I	3546-1/4B
3/8	19	75.00	**88.45**	3546-3/8T	3546-3/8I	3546-3/8B
1/2	14	87.00	**135.63**	3546-1/2T	3546-1/2I	3546-1/2B
5/8	14	91.00	**165.11**	3546-5/8T	3546-5/8I	3546-5/8B
3/4	14	96.00	**182.81**	3546-3/4T	3546-3/4I	3546-3/4B
7/8	14	96.00	**260.82**	3546-7/8T	3546-7/8I	3546-7/8B
1	11	109.00	**271.26**	3546-1T	3546-1I	3546-1B

BORDO® INDUSTRIAL TOOLS

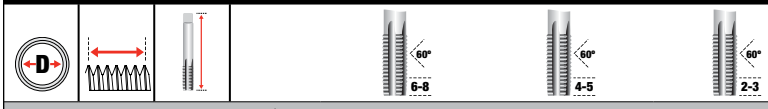
GROUP	PCTP
MATERIAL	HSS
TOLERANCE	3B
TYPE	**STI**

NPT – STI TAPS



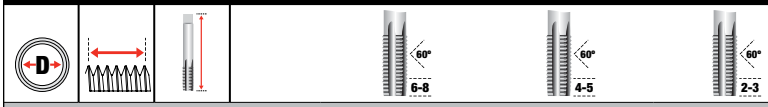
INCH	TPI	MM	$	PART #	PART #	PART #
1/8	27	54.00	**53.07**	3552-1/8T	3552-1/8I	3552-1/8B
1/4	18	62.00	**67.81**	3552-1/4T	3552-1/4I	3552-1/4B
3/8	18	65.00	**88.45**	3552-3/8T	3552-3/8I	3552-3/8B
1/2	14	80.00	**135.63**	3552-1/2T	3552-1/2I	3552-1/2B
3/4	14	83.00	**182.81**	3552-3/4T	3552-3/4I	3552-3/4B
1	11.5	95.00	**271.26**	3552-1T	3552-1I	3552-1B

8-UN – STI TAPS



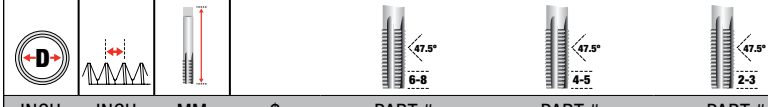
INCH	TPI	MM	$	PART #	PART #	PART #
1-1/8	8	151.00	**340.20**	3570-1.1/8T	3570-1.1/8I	3570-1.1/8B
1-1/4	8	162.00	**396.90**	3570-1.1/4T	3570-1.1/4I	3570-1.1/4B
1-3/8	8	170.00	**510.30**	3570-1.3/8T	3570-1.3/8I	3570-1.3/8B
1-1/2	8	170.00	**396.90**	3570-1.1/2T	3570-1.1/2I	3570-1.1/2B
1-5/8	8	187.00	**612.36**	3570-1.5/8T	3570-1.5/8I	3570-1.5/8B
1-3/4	8	187.00	**680.40**	3570-1.3/4T	3570-1.3/4I	3570-1.3/4B
1-7/8	8	200.00	**793.80**	3570-1.7/8T	3570-1.7/8I	3570-1.7/8B
2	8	200.00	**850.50**	3570-2T	3570-2I	3570-2B

BSC – STI TAPS



INCH	TPI	MM	$	PART #	PART #	PART #
1/4	26	69.00	**45.36**	3560-1/4T	3560-1/4I	3560-1/4B
5/16	26	76.00	**56.70**	3560-5/16T	3560-5/16I	3560-5/16B
3/8	26	82.00	**68.04**	3560-3/8T	3560-3/8I	3560-3/8B
7/16	26	84.00	**85.05**	3560-7/16T	3560-7/16I	3560-7/16B
1/2	26	90.00	**106.14**	3560-1/2T	3560-1/2I	3560-1/2B

BA – STI TAPS



INCH	INCH	MM	$	PART #	PART #	PART #
0	0.0394	66.00	**70.76**	3544-0T	3544-0I	3544-0B
2	0.0319	66.00	**70.76**	3544-2T	3544-2I	3544-2B
4	0.0260	53.00	**70.76**	3544-4T	3544-4I	3544-4B
6	0.0209	50.00	**70.76**	3544-6T	3544-6I	3544-6B

GROUP	PCIT
USAGE	GENERAL
INSERT TYPE	WIRE THREAD
INSERT STYLE	**FREE RUNNING**
APPLICATION	**LOW VOLUME**

HAND INSTALLATION TOOLS – HIT

MC	MF	SPARK	UNC	UNF	BSW	BSF	BA	BSC	NPT	BSP	UN-8	$	PART #
2X0.40	–	–	–	–	–	–	–	–	–	–	–	**18.87**	3500-HIT2
2.20X0.45	–	–	2GX56	–	–	–	–	–	–	–	–	**18.87**	3500-HIT2
2.50X0.45	–	–	3GX48	3GX56	–	–	#6	–	–	–	–	**18.87**	3500-HIT3
3X0.50	–	–	4GX40	4GX48	1/8X40	–	–	–	–	–	–	**18.87**	3500-HIT4
–	–	–	5GX40	–	–	–	–	–	–	–	–	**18.87**	3500-HIT4
3.50X0.60	–	–	6GX32	6GX40	–	–	#4		–	–	–	**18.87**	3500-HIT5
4X0.70	–	–	8GX32	8GX36	–	–	–	–	–	–	–	**12.98**	3500-HIT6
5X0.80	–	–	12GX24	10GX32	–	3/16X32	#1	–	–	–	–	**12.98**	3500-HIT8
6X1.00	–	–	1/4X20	1/4X28	1/4X20	1/4X26	#0	1/4X26	–	–	–	**12.98**	3500-HIT9
7X1.00	–	–	5/16X18	–	5/16X18	–	–	–	1/16X27	–	–	**12.98**	3500-HIT10
8X1.25	8X1.00	–	–	5/16X24	3/8X16	5/16X22	–	5/16X26	–	–	–	**12.98**	3500-HIT11
9X1.25	10X1.25	10X1.00	3/8X16	3/8X24	–	3/8X20	–	3/8X26	–	–	–	**12.98**	3500-HIT13
9X1.00	10X1.00	–	–	–	–	–	–	–	–	–	–	**12.98**	3500-HIT13
10X1.50	–	–	–	–	–	–	–	–	1/8X27	–	–	**12.98**	3500-HIT13
11X1.50	11X1.25	–	7/16X14	7/16X20	7/16X14	7/16X18	–	7/16X26	–	1/8X28	–	**14.15**	3500-HIT14
–	11X1.00	–	–	–	–	–	–	–	–	–	–	**14.15**	3500-HIT14
12X1.75	12X1.50	10X1.25	1/2X13	1/2X20	1/2X12	1/2X16	–	1/2X26	–	–	–	**15.33**	3500-HIT15
12X1.00	12X1.25	–	–	–	–	–	–	–	–	–	–	**15.33**	3500-HIT15
14X2.00	14X1.00	–	9/16X12	9/16X18	9/16X12	9/16X16	–	–	–	1/4X19	–	**16.51**	3500-HIT16
15X2.00	14X1.50	–	–	–	–	–	–	–	1/4X18	–	–	**16.51**	3500-HIT16
–	–	14X1.25	–	–	–	–	–	–	–	–	–	**16.51**	3500-HIT17
16X2.00	16X1.50	–	5/8X11	5/8X18	5/8X11	5/8X14	–	–	3/8X18	–	–	**16.51**	3500-HIT18
18X2.50	18X2.00	18X1.50	3/4X10	–	3/4X10	3/4X12	–	–	–	3/8X19	–	**16.51**	3500-HIT20
–	18X1.50	–	–	–	–	–	–	–	–	–	–	**16.51**	3500-HIT20
20X2.50	20X2.00	–	–	3/4X16	–	–	–	–	–	–	–	**21.23**	3500-HIT21
–	20X1.50	–	–	–	–	–	–	–	–	–	–	**21.23**	3500-HIT21
22X2.50	22X2.00	–	7/8X9	7/8X14	7/8X9	7/8X11	–	–	1/2X14	–	–	**23.58**	3500-HIT22
–	22X1.50	–	–	–	–	–	–	–	–	–	–	**23.58**	3500-HIT22
24X3.00	24X2.00	–	1X8	1X12	1X8	1X10	–	–	–	1/2X14	–	**41.28**	3500-HIT23
–	24X1.50	–	–	1X14	–	–	–	–	–	5/8X14	–	**41.28**	3500-HIT23
27X3.00	26X1.50	–	–	–	–	–	–	–	3/4X14	3/4X14	–	**39.69**	3500-HIT24
30X3.00	–	–	1.1/8-7	1.1/8-12	–	–	–	–	–	–	1.1/8X8	**39.69**	3500-HIT25
33X3.50	30X2.00	–	1.1/4-7	1.1/4-12	–	–	–	–	–	–	1.1/4X8	**56.70**	3500-HIT26
–	–	–	1.3/8-6	1.3/8-12	–	–	–	–	1X11.5	7/8X14	1.3/8X8	**56.70**	3500-HIT27
–	–	–	–	–	–	–	–	–	–	1X11	–	**56.70**	3500-HIT27
36X4.00	36X2.00		1.1/2-6	1.1/2-12	–	–	–	–	–	–	1.1/2X8	**56.70**	3500-HIT28
–	–	–	–	–	–	–	–	–	–	–	1.5/8X8	**56.70**	3500-HIT28
–	–	–	–	–	–	–	–	–	–	–	1.3/4X8	**56.70**	3500-HIT28
–	–	–	–	–	–	–	–	–	–	–	1.7/8X8	**79.38**	3500-HIT30
–	–	–	–	–	–	–	–	–	–	–	2X8	**79.38**	3500-HIT30

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

GROUP	PCIT
USAGE	GENERAL
INSERT TYPE	WIRE THREAD
INSERT STYLE	**ALL**
APPLICATION	**LOW VOLUME**

TANG BREAK TOOLS – TB : INSERT REMOVAL TOOLS – RT

MC	MF	SPARK	UNC	UNF	BSW	BSF	BA	BSC	$	PART #	$	PART #
2X0.40	–	–	–	–	–	–	–	–	**8.84**	3500-TB1	**19.85**	3500-RT1
2.20X0.45	–	–	2GX56	–	–	–	–	–	**8.84**	3500-TB2	**19.85**	3500-RT1
2.50X0.45	–	–	3GX48	3GX56	–	–	#6	–	**8.84**	3500-TB3	**19.85**	3500-RT1
–	–	–	4GX40	4GX48	1/8X40	–	–	–	**8.84**	3500-TB4	**19.85**	3500-RT1
3X0.50	–	–	–	4GX48	–	–	–	–	**8.84**	3500-TB4	**22.41**	3500-RT2
–	–	–	5GX40	–	–	–	–	–	**8.84**	3500-TB4	**19.85**	3500-RT1
3.50X0.60	–	–	–	–	–	–	–	–	**8.84**	3500-TB5	**22.41**	3500-RT2
–	–	–	6GX32	6GX40	–	–	#4	–	**8.84**	3500-TB5	**19.85**	3500-RT1
4X0.70	–	–	–	–	–	3/16X32	–	–	**8.84**	3500-TB6	**22.41**	3500-RT2
–	–	–	8GX32	8GX36	–	–	–	–	**8.84**	3500-TB6	**19.85**	3500-RT1
5X0.80	–	–	10GX24	10GX32	3/16X24	–	#2	–	**8.84**	3500-TB8	**22.41**	3500-RT2
–	–	–	12GX24	12GX28	–	–	–	–	**8.84**	3500-TB8	**22.41**	3500-RT2
6X1.00	–	–	1/4X20	1/4X28	1/4X20	1/4X26	–	1/4X26	**8.84**	3500-TB9	**22.41**	3500-RT2
7X1.00	–	–	–	–	5/16X18	5/16X22	#0	–	**9.96**	3500-TB11	**22.41**	3500-RT2
8X1.25	8X1.00	–	5/16X18	5/16X24	–	–	–	5/16X26	**9.96**	3500-TB12	**22.41**	3500-RT2
9X1.25	9X1.00	10X1.00	–	–	–	–	–	–	**9.96**	3500-TB12	**22.41**	3500-RT2
–	–	–	3/8X16	–	3/8X16	3/8X20	–	–	**9.96**	3500-TB12	**24.77**	3500-RT3
10X1.50	10X1.25	–	–	–	–	–	–	–	**9.96**	3500-TB13	**22.41**	3500-RT2
–	–	–	–	3/8X24	–	–	–	3/8X26	**9.96**	3500-TB13	**24.77**	3500-RT3
–	10X1.00	–	–	–	–	–	–	–	**9.96**	3500-TB13	**22.41**	3500-RT2
11X1.50	11X1.25	–	7/16X14	7/16X20	7/16X14	7/16X18	–	7/16X26	**12.03**	3500-TB14	**24.77**	3500-RT3
–	11X1.00	–	–	–	–	–	–	–	**12.03**	3500-TB14	**24.77**	3500-RT3
12X1.75	12X1.50	10X1.25	1/2X13	1/2X20	1/2X12	1/2X16	–	1/2X26	**12.03**	3500-TB15	**24.77**	3500-RT3
–	12X1.00	12X1.25	–	–	–	–	–	–	**12.03**	3500-TB15	**24.77**	3500-RT3
13X1.75	13X1.50	–	–	–	–	–	–	–	**12.03**	3500-TB15	**24.77**	3500-RT3
–	13X1.25	–	–	–	–	–	–	–	–	–	**24.77**	3500-RT3
14X2.00	14X1.50	14X1.25	9/16X12	9/16X18	9/16X12	9/16X16	–	–	–	–	**24.77**	3500-RT3
–	14X1.00	–	–	–	–	–	–	–	–	–	**24.77**	3500-RT3
15X2.00	15X1.50	–	–	–	–	–	–	–	–	–	**24.77**	3500-RT3
16X2.00	16X1.50	–	5/8X11	5/8X18	5/8X11	5/8X14	–	–	–	–	**24.77**	3500-RT3
18X2.50	18X2.00	18X1.50	3/4X10	–	3/4X10	3/4X12	–	–	–	–	**24.77**	3500-RT3
20X2.50	20X2.00	–	–	3/4X16	–	–	–	–	–	–	**24.77**	3500-RT3
–	20X1.50	–	–	–	–	–	–	–	–	–	**24.77**	3500-RT3
22X2.50	22X2.00	–	7/8X9	7/8X14	7/8X9	7/8X11	–	–	–	–	**24.77**	3500-RT3
–	22X1.50	–	–	–	–	–	–	–	–	–	**24.77**	3500-RT3
24X3.00	24X2.00	–	1X8	1X12	1X8	1X10	–	–	–	–	**24.77**	3500-RT3
–	24X1.50	–	–	1X14	–	–	–	–	–	–	**24.77**	3500-RT3
–	26X1.50	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4
27X3.00	27X2.00	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4
–	27X1.50	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4
–	28X1.50	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4
30X3.50	30X2.00	–	1.1/8X7	1.1/8X12	–	–	–	–	–	–	**58.97**	3500-RT4
–	30X1.50	–	1.1/4X7	1.1/4X12	–	–	–	–	–	–	**58.97**	3500-RT4
33X3.50	33X2.00	–	1.3/8X6	1.3/8X12	–	–	–	–	–	–	**58.97**	3500-RT4
36X4.00	36X3.00	–	1.1/2X6	1.1/2X12	–	–	–	–	–	–	**58.97**	3500-RT4
–	36X2.00	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4
–	36X1.50	–	–	–	–	–	–	–	–	–	**58.97**	3500-RT4

Note: For larger insert sizes, where a TB (Tang Break) tool is not listed, the tang break operation is performed using the HIT (Hand Installation Tool).

GROUP	PCIT
USAGE	GENERAL
INSERT TYPE	WIRE THREAD
INSERT STYLE	**ALL**
APPLICATION	**MED. VOLUME**

MACHINE INSTALLATION TOOLS – MIT : PREWINDER TOOLS – HIP : SPRING LOADED TANG BREAK TOOLS – STB

								
MC	MF	SPARK	$	PART #	$	PART #	$	PART #
2X0.40	–	–	**39.69**	3520-2.00MIT	**283.05**	3520-2.00HIP	**119.07**	3500-STB1
2.20X0.45	–	–	**39.69**	3520-2.20MIT	**283.05**	3520-2.20HIP	**119.07**	3500-STB1
2.50X0.45	–	–	**39.69**	3520-2.50MIT	**235.87**	3520-2.50HIP	**119.07**	3500-STB2
3X0.50	–	–	**29.48**	3520-3.00MIT	**235.87**	3520-3.00HIP	**119.07**	3500-STB4
3.50X0.60	–	–	**29.48**	3520-3.50MIT	**235.87**	3520-3.50HIP	**119.07**	3500-STB4
4X0.70	–	–	**29.48**	3520-4.00MIT	**235.87**	3520-4.00HIP	**119.07**	3500-STB5
5X0.80	–	–	**29.48**	3520-5.00MIT	**235.87**	3520-5.00HIP	**119.07**	3500-STB6
6X1.00	–	–	**29.48**	3520-6.00MIT	**235.87**	3520-6.00HIP	**119.07**	3500-STB8
7X1.00	–	–	**36.20**	3520-7.00MIT	**235.87**	3520-7.00HIP	**–**	–
8X1.25	–	–	**36.20**	3520-8.00MIT	**235.87**	3520-8.00HIP	**181.44**	3500-STB9
–	8X1.00	–	**34.82**	3521-8.00MIT	**235.87**	3521-8.00HIP	**181.44**	3500-STB9
10X1.50	–	–	**39.92**	3520-10.00MIT	**235.87**	3520-10.00HIP	**181.44**	3500-STB10
–	10X1.25	–	**38.39**	3521-10.00MIT	**235.87**	3521-10.00HIP	**181.44**	3500-STB10
–	10X1.00	–	**38.39**	3523-10.00MIT	**235.87**	3523-10.00HIP	**181.44**	3500-STB10
11X1.50	–	–	**44.34**	3520-11.00MIT	**377.39**	3520-11.00HIP	**–**	–
12X1.75	–	–	**44.34**	3520-12.00MIT	**235.87**	3520-12.00HIP	**249.48**	3500-STB12
–	12X1.50	–	**42.64**	3521-12.00MIT	**235.87**	3521-12.00HIP	**249.48**	3500-STB12
–	–	12X1.25	**42.64**	3523-12.00MIT	**235.87**	3523-12.00HIP	**249.48**	3500-STB12
–	12X1.00	–	**–**	–	**–**	–	**249.48**	3500-STB12
14X2.00	–	–	**51.03**	3520-14.00MIT	**377.39**	3520-14.00HIP	**–**	–
–	14X1.50	–	**51.03**	3521-14.00MIT	**566.10**	3521-14.00HIP	**–**	–
–	–	14X1.25	**51.03**	3523-14.00MIT	**377.39**	3523-14.00HIP	**–**	–
16X2.00	–	–	**62.37**	3520-16.00MIT	**471.74**	3520-16.00HIP	**–**	–
–	16X1.50	–	**62.37**	3521-16.00MIT	**613.26**	3521-16.00HIP	**–**	–

PowerCoil Installation and Extraction Tools

HIT Hand Installation Tool
The most flexible and cost effective installation tool for small volume applications – free running inserts only.

TB Tang Break Tool
Used to break the tang off inserts up to M13 or 1/2". Over these sizes and up to M24 or 1" the HIT tool is used to both install and break the tang.

RT Removal Tool
A quick and simple way to remove inserts up to M36 or 1.1/2" in diameter.

MIT Machine Installation Tool
1/4" hex shank tool suitable for use with electric and cordless tools. Ideal for medium volume installation using bulk free running and screw locking inserts.

HIP Hand Installation Prewinder Tool
For simplfied installation of bulk free running and screw locking inserts in low to medium volume applications.
HIP tools are ideal for installing MIL spec inserts.

STB Spring Loaded Tang Break Tool
Spring loaded tang break tools increase the efficiency of the tang break procedure in medium to high volume applications.

MIP Machine Installation (Front End Assemblies) – Pneumatic
The use of Front End Assemblies (nozzle and mandrel combination) with Pneumatic Tools provides maximum efficiency in high volume applications when using strip feed free running and screw locking inserts.

powercoil® wire thread insert system

GROUP	PCIT
USAGE	GENERAL
INSERT TYPE	WIRE THREAD
INSERT STYLE	**ALL**
APPLICATION	**MED. VOLUME**

MACHINE INSTALLATION TOOLS – MIT : PREWINDER TOOLS – HIP : SPRING LOADED TANG BREAK TOOLS – STB

							
UNC	UNF	$	PART #	$	PART #	$	PART #
2GX56	–	**39.69**	3532-2GMIT	**283.05**	3532-2GHIP	**113.40**	3500-STB1
3GX48	–	**–**	–	**283.05**	3532-3GHIP	**–**	–
–	3GX56	**–**	–	**207.56**	3534-3GHIP	**–**	–
4GX40	–	**39.69**	3532-4GMIT	**188.70**	3532-4GHIP	**119.07**	3500-STB3
–	4GX48	**39.69**	3534-4GMIT	**207.56**	3534-4GHIP	**119.07**	3500-STB3
5GX40	–	**39.69**	3532-5GMIT	**188.70**	3532-5GHIP	**119.07**	3500-STB3
6GX32	–	**28.35**	3532-6GMIT	**188.70**	3532-6GHIP	**119.07**	3500-STB4
–	6GX40	**28.35**	3534-6GMIT	**207.56**	3534-6GHIP	**119.07**	3500-STB4
8GX32	–	**28.35**	3532-8GMIT	**188.70**	3532-8GHIP	**119.07**	3500-STB5
–	8GX36	**28.35**	3534-8GMIT	**207.56**	3534-8GHIP	**119.07**	3500-STB5
10GX24	–	**28.35**	3532-10GMIT	**188.70**	3532-10GHIP	**119.07**	3500-STB6
–	10GX32	**28.35**	3534-10GMIT	**207.56**	3534-10GHIP	**119.07**	3500-STB6
12GX24	–	**28.35**	3532-12GMIT	**188.70**	3532-12GHIP	**119.07**	3500-STB7
–	12GX28	**–**	–	**207.56**	3534-12GHIP	**119.07**	3500-STB7
1/4X20	–	**28.35**	3532-1/4MIT	**188.70**	3532-1/4HIP	**119.07**	3500-STB8
–	1/4X28	**28.35**	3534-1/4MIT	**207.56**	3534-1/4HIP	**119.07**	3500-STB8
5/16X18	–	**34.82**	3532-5/16MIT	**207.56**	3532-5/16HIP	**181.44**	3500-STB9
–	5/16X24	**34.82**	3534-5/16MIT	**207.56**	3534-5/16HIP	**181.44**	3500-STB9
3/8X16	–	**38.39**	3532-3/8MIT	**217.00**	3532-3/8HIP	**181.44**	3500-STB10
–	3/8X24	**38.39**	3534-3/8MIT	**207.56**	3534-3/8HIP	**181.44**	3500-STB10
7/16X14	–	**42.64**	3532-7/16MIT	**217.00**	3532-7/16HIP	**238.14**	3500-STB11
–	7/16X20	**42.64**	3534-7/16MIT	**235.87**	3534-7/16HIP	**238.14**	3500-STB11
1/2X13	–	**42.64**	3532-1/2MIT	**235.87**	3532-1/2HIP	**249.48**	3500-STB12
–	1/2X20	**42.64**	3534-1/2MIT	**235.87**	3534-1/2HIP	**249.48**	3500-STB12

GROUP	PCIT
USAGE	GENERAL
INSERT TYPE	WIRE THREAD
INSERT STYLE	**ALL**
APPLICATION	**HIGH VOLUME**


FRONT END ASSEMBLY – FEA


FEA MANDREL


FEA NOZZLE


PNEUMATIC INSTALLATION TOOL

PNEUMATIC TOOLS AND FRONT END ASSEMBLIES



MC	MF	$	PART #	$	PART #	$	PART #	$	PART #
2X0.40	–	**422.27**	3520-2.20MIP	**147.35**	3520-2.20MIPM	**281.60**	3520-2.20MIPN	**1786.05**	3500-MIP1
2.50X0.45	–	**422.27**	3520-2.50MIP	**147.35**	3520-2.50MIPM	**281.60**	3520-2.50MIPN	**1786.05**	3500-MIP1
3X0.50	–	**406.02**	3520-3.00MIP	**147.35**	3520-3.00MIPM	**281.60**	3520-3.00MIPN	**1786.05**	3500-MIP1
3.50X0.60	–	**406.02**	3520-3.50MIP	**147.35**	3520-3.50MIPM	**281.60**	3520-3.50MIPN	**1786.05**	3500-MIP1
4X0.70	–	**406.02**	3520-4.00MIP	**147.35**	3520-4.00MIPM	**281.60**	3520-4.00MIPN	**1786.05**	3500-MIP1
5X0.80	–	**422.27**	3520-5.00MIP	**147.35**	3520-5.00MIPM	**281.60**	3520-5.00MIPN	**1786.05**	3500-MIP1
6X1.00	–	**406.02**	3520-6.00MIP	**147.35**	3520-6.00MIPM	**281.60**	3520-6.00MIPN	**1786.05**	3500-MIP1
8X1.25	–	**689.37**	3520-8.00MIP	**261.95**	3520-8.00MIPM	**435.50**	3520-8.00MIPN	**2083.73**	3500-MIP2
–	8X1.00	**697.45**	3521-8.00MIP	**261.95**	3521-8.00MIPM	**435.50**	3521-8.00MIPN	**2083.73**	3500-MIP2
10X1.50	–	**689.37**	3520-10.00MIP	**261.95**	3520-10.00MIPM	**435.50**	3520-10.00MIPN	**2083.73**	3500-MIP2
–	10X1.25	**697.45**	3521-10.00MIP	**261.95**	3521-10.00MIPM	**435.50**	3521-10.00MIPN	**2083.73**	3500-MIP2
–	10X1.00	**725.35**	3523-10.00MIP	**261.95**	3523-10.00MIPM	**435.50**	3523-10.00MIPN	**2083.73**	3500-MIP2
12X1.75	–	**689.37**	3520-12.00MIP	**261.95**	3520-12.00MIPM	**435.50**	3520-12.00MIPN	**2083.73**	3500-MIP2
–	12X1.50	**726.93**	3521-12.00MIP	**301.25**	3521-12.00MIPM	**435.50**	3521-12.00MIPN	**2083.73**	3500-MIP2
–	12X1.25	**726.93**	3523-12.00MIP	**301.25**	3523-12.00MIPM	**435.50**	3523-12.00MIPN	**2083.73**	3500-MIP2

PNEUMATIC TOOLS AND FRONT END ASSEMBLIES



UNC	UNF	$	PART #	$	PART #	$	PART #	$	PART #
2GX56	–	**406.02**	3532-2GMIP	**147.35**	3532-2GMIPM	**273.15**	3532-2GMIPN	**1786.05**	3500-MIP1
4GX40	–	**406.02**	3532-4GMIP	**147.35**	3532-4GMIPM	**273.15**	3532-4GMIPN	**1786.05**	3500-MIP1
5GX40	–	**406.02**	3532-5GMIP	**147.35**	3532-5GMIPM	**273.15**	3532-5GMIPN	**1786.05**	3500-MIP1
6GX32	–	**406.02**	3532-6GMIP	**147.35**	3532-6GMIPM	**273.15**	3532-6GMIPN	**1786.05**	3500-MIP1
–	6GX40	**470.33**	3534-6GMIP	**207.13**	3534-6GMIPM	**273.15**	3534-6GMIPN	**1786.05**	3500-MIP1
8GX32	–	**406.02**	3532-8GMIP	**147.35**	3532-8GMIPM	**273.15**	3532-8GMIPN	**1786.05**	3500-MIP1
–	8GX36	**470.33**	3534-8GMIP	**207.13**	3534-8GMIPM	**273.15**	3534-8GMIPN	**1786.05**	3500-MIP1
10GX24	–	**406.02**	3532-10GMIP	**147.35**	3532-10GMIPM	**273.15**	3532-10GMIPN	**1786.05**	3500-MIP1
–	10GX32	**406.02**	3534-10GMIP	**143.13**	3534-10GMIPM	**273.15**	3534-10GMIPN	**1786.05**	3500-MIP1
12GX24	–	**470.33**	3532-12GMIP	**261.95**	3532-12GMIPM	**281.60**	3532-12GMIPN	**1786.05**	3500-MIP1
1/4X20	–	**470.33**	3532-1/4MIP	**261.95**	3532-1/4MIPM	**281.60**	3532-1/4MIPN	**1786.05**	3500-MIP1
–	1/4X28	**422.27**	3534-1/4MIP	**156.26**	3534-1/4MIPM	**281.60**	3534-1/4MIPN	**1786.05**	3500-MIP1
5/16X18	–	**470.33**	3532-5/16MIP	**261.95**	3532-5/16MIPM	**281.60**	3532-5/16MIPN	**2083.73**	3500-MIP2
–	5/16X24	**470.33**	3534-5/16MIP	**261.95**	3534-5/16MIPM	**281.60**	3534-5/16MIPN	**2083.73**	3500-MIP2
3/8X16	–	**470.33**	3532-3/8MIP	**261.95**	3532-3/8MIPM	**281.60**	3532-3/8MIPN	**2083.73**	3500-MIP2
–	3/8X24	**470.33**	3534-3/8MIP	**261.95**	3534-3/8MIPM	**281.60**	3534-3/8MIPN	**2083.73**	3500-MIP2
7/16X14	–	**697.45**	3532-7/16MIP	**267.47**	3532-7/16MIPM	**435.50**	3532-7/16MIPN	**2083.73**	3500-MIP2
–	7/16X20	**697.45**	3534-7/16MIP	**267.47**	3534-7/16MIPM	**435.50**	3534-7/16MIPN	**2083.73**	3500-MIP2
1/2X13	–	**697.45**	3532-1/2MIP	**267.47**	3532-1/2MIPM	**435.50**	3532-1/2MIPN	**2083.73**	3500-MIP2
–	1/2X20	**697.45**	3534-1/2MIP	**267.47**	3534-1/2MIPM	**435.50**	3534-1/2MIPN	**2083.73**	3500-MIP2

Front End Assemblies (MIP) include the Mandrel (MIPM), Nozzle (MIPN), spacers to suit 1.0D, 1.5D and 2.0D inserts plus a set of shim washers for fine adjustment of installation depth.

powercoil® wire thread insert system

BORDO® INDUSTRIAL TOOLS

Pneumatic Wire Thread Installation Tools and Front End Assemblies Overview

Detailed instructions are included with every Pneumatic Tool and Front End Assembly.

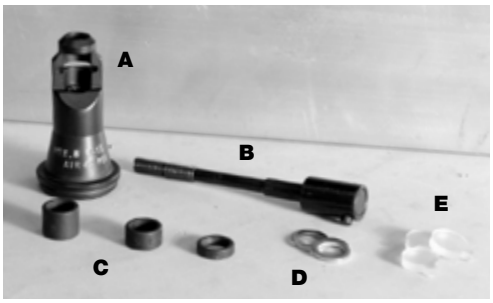
You will need

- A front-end assembly appropriate to the Wire Thread Inserts you wish to install and the applicable pneumatic tool.
- An air supply providing air pressure up to 100psi (7 bar) incorporating a filtered and lubricated air regulator. Your air supply should also incorporate an isolating switch to stop the air supply to the tool and connectors/couplings.
- PTFE tape should be wound around the threaded end of the air connector prior to screwing into air tool to ensure a good seal.
- If a tool is to be used with a work arm assembly please ensure that the instructions supplied with that equipment are read in conjunction with these instructions.

Front-end assembly

The front-end assembly is used in conjunction with the pneumatic installation tool to aid the installation of Wire Thread Inserts. The front-end assembly winds a mandrel through the insert (1.0D, 1.5D or 2.0D) and through the pre-winder nozzle. When the insert emerges from the nozzle the diameter has been reduced (pre-wound) to facilitate easy entry into the prepared and threaded hole in the parent material.

The front-end assembly consists of two main components • Nozzle • Mandrel



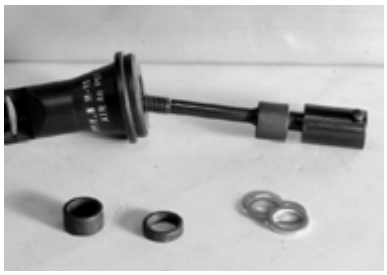
A Nozzle
B Mandrel
C Thickness spacers
D Shim washers
E Cushions
(for use in the adaptor of an ARO® brand pneumatic tool only)

Three different mandrel types are used depending on the size of the inserts being installed.

Check that the front-end assembly pack also contains 2 or 3 thickness spacers (to suit different length inserts) and at least 3 shim washers. Wire Thread Inserts should be installed 3/4 to 1-1/2 pitches below the surface of a countersunk hole or 1/4 to 1/2 coil below the surface of a flush hole. The Wire Thread Insert must be fully engaged with the thread in the hole throughout its length.

Separate mandrel from nozzle by rotating the mandrel anti-clockwise until the mandrel disengages. You can now assemble the correct combination of spacers and shims (if necessary) between the clutch seat and nozzle.

Identify the length of the insert to be installed and select spacers to adjust insertion depth eg: for 1.0D inserts select the longest spacer - the longer the insert the shorter the required spacer. Once the spacers and shims have been positioned on the shaft of the mandrel lubricate the mandrel thread with light machine oil and wind the mandrel through the nozzle. Locate the mandrel pin in the slot of the driving spline (inside the adaptor case) and slide the front end assembly into the case. Tighten the retaining ring (anti-clockwise) finger tight only - over tightening will restrict free movement of the mandrel, possibly resulting in damage. ***The mandrel should always be wound through the nozzle so that the threaded section is fully disengaged prior to assembling the tool.***

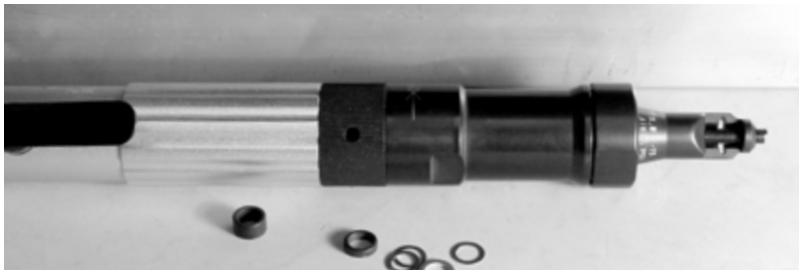


Front end assembly with longest spacer to suit 1.0D insert.

Front end assembly with longest spacer to suit 1.0D insert and shim washer.

Finished front end asembly with mandrel wound through the pre-winder nozzle.

Locate mandrel pin in the slot of the driving spline and slide the front end assembly into the case.



Ensure the front end assembly insert chamber opening is aligned with the trigger of the air motor. Final adjustments may still need to be made (using shim washers) to ensure that the inserts are installed to the optimum depth.

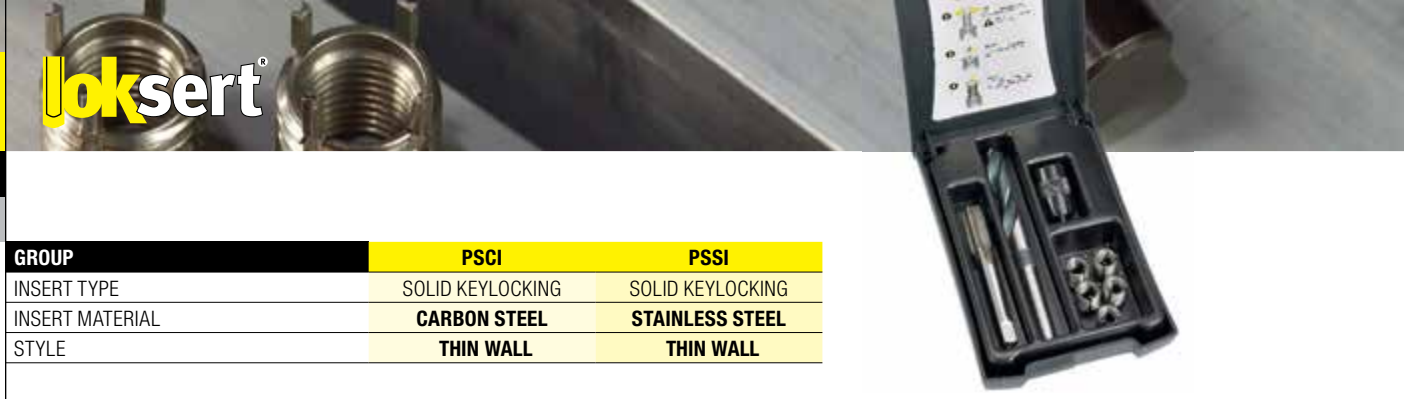
Recommended air pressures

Insert size – inch	#2	#3	#6	#8	#10	1/4"	5/16"	3/8"	7/16"	1/2"
Insert size – metric	M2.0-2.2	M2.5	M3.0	M3.5	M4.0-4.5	M6.0-7.0	M8.0	M10.0	M11.0	M12.0
Recommended pressure – psi	25	25-30	25-30	40	45	50-60	60	70	70-80	90
Recommended pressure – bar	1.7	1.7-2.0	1.7-2.0	2.8	3.0	3.5-4.1	4.1	4.8	4.8-5.5	6.2

Detailed usage manuals, instructions and exploded diagrams are available for download at powercoil.com.au

BORDO
INDUSTRIAL TOOLS

loksert®



BORDO INDUSTRIAL TOOLS

MC
MF
UNC
UNF

Loksert

Loksert solid keylocking inserts are an easily installed thread assembly that is ideal for replacing damaged or worn threads in virtually any material – ferrous, non-ferrous and non-metallic.

They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

GROUP	PSCI	PSSI
INSERT TYPE	SOLID KEYLOCKING	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON STEEL**	**STAINLESS STEEL**
STYLE	**THIN WALL**	**THIN WALL**

METRIC COARSE

MM	MM	MM X MM	MM	$	PART #	$	PART #	#	MM	PART #	PART #	MM
5.00	**0.80**	8.00 X 1.25	8.00	**81.44**	3620-5.00TWK	**124.86**	3720-5.00TWK	5	6.9	3620-8.00I	3600-190T	8.25*
6.00	**1.00**	10.00 X 1.25	10.00	**108.51**	3620-6.00TWK	**150.51**	3720-6.00TWK	5	8.8	3621-10.00I	3600-250T	10.25*
8.00	**1.25**	12.00 X 1.25	12.00	**133.49**	3620-8.00TWK	**173.75**	3720-8.00TWK	5	10.8	3622-12.00I	3600-312T	12.25*
10.00	**1.50**	14.00 X 1.50	14.00	**170.53**	3620-10.00TWK	**202.77**	3720-10.00TWK	5	12.8	3621-14.00I	3600-375T	14.25*
12.00	**1.75**	16.00 X 1.50	16.00	**196.76**	3620-12.00TWK	**222.27**	3720-12.00TWK	5	14.75	3621-16.00I	3600-500T	16.25*

METRIC FINE

MM	MM	MM X MM	MM	$	PART #	$	PART #	#	MM	PART #	PART #	MM
8.00	**1.00**	12.00 X 1.25	12.00	**133.49**	3621-8.00TWK	**173.75**	3721-8.00TWK	5	10.8	3622-12.00I	3600-312T	12.25*
10.00	**1.25**	14.00 X 1.50	14.00	**170.53**	3621-10.00TWK	**202.77**	3721-10.00TWK	5	12.8	3621-14.00I	3600-375T	14.25*
12.00	**1.25**	16.00 X 1.50	16.00	**196.76**	3621-12.00TWK	**222.27**	3721-12.00TWK	5	14.75	3621-16.00I	3600-500T	16.25*

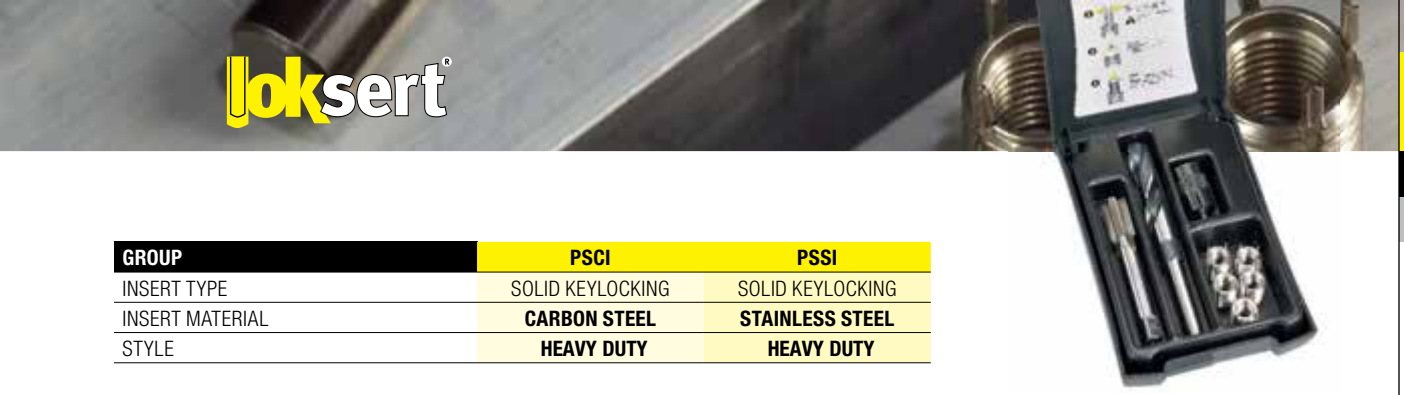
UNC

INCH	TPI	INCH X TPI	INCH	$	PART #	$	PART #	#	INCH	PART #	PART #	INCH
10G	**24**	5/16 X 18	0.31	**66.60**	3632-10GTWK	**82.14**	3732-10GTWK	5	I	3632-5/16I	3600-190T	0.32*
1/4	**20**	3/8 X 16	0.37	**75.59**	3632-1/4TWK	**91.76**	3732-1/4TWK	5	Q	3632-3/8I	3600-250T	0.38*
5/16	**18**	7/16 X 14	0.43	**91.78**	3632-5/16TWK	**131.37**	3732-5/16TWK	5	X	3632-7/16I	3600-312T	0.44*
3/8	**16**	1/2 X 13	0.50	**104.82**	3632-3/8TWK	**157.11**	3732-3/8TWK	5	29/64	3632-1/2I	3600-375T	0.51*
7/16	**14**	9/16 X 12	0.56	**144.98**	3632-7/16TWK	**228.04**	3732-7/16TWK	5	33/64	3632-9/16I	3600-375T	0.57*
1/2	**13**	5/8 X 11	0.62	**168.06**	3632-1/2TWK	**252.64**	3732-1/2TWK	5	37/64	3632-5/8I	3600-500T	0.63*

UNF

INCH	TPI	INCH X TPI	INCH	$	PART #	$	PART #	#	INCH	PART #	PART #	INCH
10G	**32**	5/16 X 18	0.31	**66.60**	3634-10GTWK	**82.14**	3734-10GTWK	5	I	3632-5/16I	3600-190T	0.32*
1/4	**28**	3/8 X 16	0.37	**75.59**	3634-1/4TWK	**91.76**	3734-1/4TWK	5	Q	3632-3/8I	3600-250T	0.38*
5/16	**24**	7/16 X 14	0.43	**93.73**	3634-5/16TWK	**133.32**	3734-5/16TWK	5	X	3632-7/16I	3600-312T	0.44*
3/8	**24**	1/2 X 13	0.50	**104.82**	3634-3/8TWK	**157.11**	3734-3/8TWK	5	29/64	3632-1/2I	3600-375T	0.51*
7/16	**20**	9/16 X 12	0.56	**144.98**	3634-7/16TWK	**228.04**	3734-7/16TWK	5	33/64	3632-9/16I	3600-375T	0.57*
1/2	**20**	5/8 X 11	0.62	**168.06**	3634-1/2TWK	**252.64**	3734-1/2TWK	5	37/64	3632-5/8I	3600-500T	0.63*

* Countersink not included in kit.



GROUP	PSCI	PSSI
INSERT TYPE	SOLID KEYLOCKING	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON STEEL**	**STAINLESS STEEL**
STYLE	**HEAVY DUTY**	**HEAVY DUTY**

METRIC COARSE

MM	MM	MM X MM	MM	$	PART #	$	PART #	#	MM	PART #	PART #	MM
5.00	**0.80**	10.00 X 1.25	10.00	**103.53**	3620-5.00HDK	**168.89**	3720-5.00HDK	5	8.80	3621-10.00I	3600-190T	10.25*
6.00	**1.00**	12.00 X 1.25	12.00	**128.27**	3620-6.00HDK	**195.05**	3720-6.00HDK	5	10.80	3622-12.00I	3600-250T	12.25*
8.00	**1.25**	14.00 X 1.50	14.00	**157.92**	3620-8.00HDK	**226.07**	3720-8.00HDK	5	12.80	3621-14.00I	3600-312T	14.25*
10.00	**1.50**	16.00 X 1.50	16.00	**176.36**	3620-10.00HDK	**239.52**	3720-10.00HDK	5	14.75	3621-16.00I	3600-375T	16.25*
12.00	**1.75**	18.00 X 1.50	18.00	**279.13**	3620-12.00HDK	**331.32**	3720-12.00HDK	5	16.75	3622-18.00I	3600-500T	18.25*
16.00	**2.00**	22.00 X 1.50	22.00	**357.29**	3620-16.00HDK	**437.25**	3720-16.00HDK	5	20.50	3621-22.00I	3600-625T	20.25*

METRIC FINE

MM	MM	MM X MM	MM	$	PART #	$	PART #	#	MM	PART #	PART #	MM
8.00	**1.00**	14.00 X 1.50	14.00	**157.92**	3621-8.00HDK	**226.07**	3721-8.00HDK	5	12.80	3621-14.00I	3600-312T	14.25*
10.00	**1.25**	16.00 X 1.50	16.00	**176.36**	3621-10.00HDK	**239.52**	3721-10.00HDK	5	14.75	3621-16.00I	3600-375T	16.25*
12.00	**1.25**	18.00 X 1.50	18.00	**196.76**	3621-12.00HDK	**248.94**	3721-12.00HDK	5	16.75	3622-18.00I	3600-500T	18.25*
16.00	**1.50**	22.00 X 1.50	22.00	**383.78**	3621-16.00HDK	**463.73**	3721-16.00HDK	5	20.50	3621-22.00I	3600-625T	20.25*

UNC

INCH	TPI	INCH X TPI	INCH	$	PART #	$	PART #	#	INCH	PART #	PART #	INCH
10G	**24**	3/8 X 16	0.31	**73.50**	3632-10GHDK	**90.98**	3732-10GHDK	5	Q	3632-3/8I	3600-190T	0.32*
1/4	**20**	7/16 X 14	0.37	**87.61**	3632-1/4HDK	**107.35**	3732-1/4HDK	5	X	3632-7/16I	3600-250T	0.38*
5/16	**18**	1/2 X 13	0.43	**99.67**	3632-5/16HDK	**138.94**	3732-5/16HDK	5	29/64	3632-1/2I	3600-312T	0.44*
3/8	**16**	9/16 X 12	0.50	**135.53**	3632-3/8HDK	**182.89**	3732-3/8HDK	5	33/64	3632-9/16I	3600-375T	0.51*
7/16	**14**	5/8 X 11	0.56	**157.11**	3632-7/16HDK	**232.97**	3732-7/16HDK	5	37/64	3632-5/8I	3600-375T	0.57*
1/2	**13**	3/4 X 16	0.62	**226.58**	3632-1/2HDK	**321.29**	3732-1/2HDK	5	45/64	3632-3/4I	3600-500T	0.63*
9/16	**12**	3/4 X 16	0.81	**244.06**	3632-9/16HDK	**330.00**	3732-9/16HDK	5	45/64	3632-3/4I	3600-500T	0.82*
5/8	**11**	7/8 X 14	0.87	**306.98**	3632-5/8HDK	**419.80**	3732-5/8HDK	5	53/64	3632-7/8I	3600-625T	0.88*

UNF

INCH	TPI	INCH X TPI	INCH	$	PART #	$	PART #	#	INCH	PART #	PART #	INCH
10G	**32**	3/8 X 16	0.31	**73.50**	3634-10GHDK	**90.98**	3734-10GHDK	5	Q	3632-3/8I	3600-190T	0.32*
1/4	**28**	7/16 X 14	0.37	**87.61**	3634-1/4HDK	**107.35**	3734-1/4HDK	5	X	3632-7/16I	3600-250T	0.38*
5/16	**24**	1/2 X 13	0.43	**99.67**	3634-5/16HDK	**138.94**	3734-5/16HDK	5	29/64	3632-1/2I	3600-312T	0.44*
3/8	**24**	9/16 X 12	0.50	**135.53**	3634-3/8HDK	**182.89**	3734-3/8HDK	5	33/64	3632-9/16I	3600-375T	0.51*
7/16	**20**	5/8 X 11	0.56	**157.11**	3634-7/16HDK	**232.97**	3734-7/16HDK	5	37/64	3632-5/8I	3600-375T	0.57*
1/2	**20**	3/4 X 16	0.62	**226.58**	3634-1/2HDK	**321.29**	3734-1/2HDK	5	45/64	3632-3/4I	3600-500T	0.63*
9/16	**18**	3/4 X 16	0.81	**244.06**	3634-9/16HDK	**330.00**	3734-9/16HDK	5	45/64	3632-3/4I	3600-500T	0.82*
5/8	**18**	7/8 X 14	0.87	**306.98**	3634-5/8HDK	**419.80**	3734-5/8HDK	5	53/64	3632-7/8I	3600-625T	0.88*

* Countersink not included in kit.

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UNF

Loksert Features and Benefits

- Solid bushing utilising locking keys provides positive mechanical lock against rotation.
- High strength and reliability provides maximum pullout strength.
- Installed using standard drills and taps.
- Simple installation - no special skills required.
- Suitable for use in a wide range of parent materials.
- Impossible to cross thread during installation.
- Simple removal process if required.
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- Available in metric sizes and inch sizes.
- Available in Thinwall and Heavy Duty.

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GROUP	PSCI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	CARBON STEEL
STYLE	**THIN WALL**

METRIC COARSE

MM	MM	MM X MM	MM	#	$	PART #
5.00	**0.80**	8.00 X 1.25	8.00	5	**37.98**	3620-5.00TWP
6.00	**1.00**	10.00 X 1.25	10.00	5	**42.16**	3620-6.00TWP
8.00	**1.25**	12.00 X 1.25	12.00	5	**46.41**	3620-8.00TWP
10.00	**1.50**	14.00 X 1.50	14.00	5	**57.08**	3620-10.00TWP
12.00	**1.75**	16.00 X 1.50	16.00	5	**73.65**	3620-12.00TWP

METRIC FINE

MM	MM	MM X MM	MM	#	$	PART #
8.00	**1.00**	12.00 X 1.25	12.00	5	**46.41**	3621-8.00TWP
10.00	**1.25**	14.00 X 1.50	14.00	5	**57.08**	3621-10.00TWP
12.00	**1.25**	16.00 X 1.50	16.00	5	**73.65**	3621-12.00TWP

UNC

INCH	TPI	INCH X TPI	INCH	#	$	PART #
10G	**24**	5/16 X 18	0.31	5	**24.35**	3632-10GTWP
1/4	**20**	3/8 X 16	0.37	5	**25.65**	3632-1/4TWP
5/16	**18**	7/16 X 14	0.43	5	**28.90**	3632-5/16TWP
3/8	**16**	1/2 X 13	0.50	5	**31.78**	3632-3/8TWP
7/16	**14**	9/16 X 12	0.56	5	**41.22**	3632-7/16TWP
1/2	**13**	5/8 X 11	0.62	5	**47.70**	3632-1/2TWP

UNF

INCH	TPI	INCH X TPI	INCH	#	$	PART #
10G	**32**	5/16 X 18	0.31	5	**24.35**	3634-10GTWP
1/4	**28**	3/8 X 16	0.37	5	**25.65**	3634-1/4TWP
5/16	**24**	7/16 X 14	0.43	5	**28.90**	3634-5/16TWP
3/8	**24**	1/2 X 13	0.50	5	**31.78**	3634-3/8TWP
7/16	**20**	9/16 X 12	0.56	5	**41.22**	3634-7/16TWP
1/2	**20**	5/8 X 11	0.62	5	**47.70**	3634-1/2TWP

GROUP	PSCI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	CARBON STEEL
STYLE	**THIN WALL**

MERCHANDISER

	$	PART #
LOKSERT HANG SELL MERCHANDISER	**1084.52**	3600-D1

#		PART #
2	M6.00 x 1.00	3620-6.00TWP
2	M8.00 x 1.25	3620-8.00TWP
1	M10.00 x 1.50	3620-10.00TWP
1	M12.00 x 1.75	3620-12.00TWP
1	UNC 1/4 x 20	3632-1/4TWP
1	UNC 5/16 x 18	3632-5/16TWP
1	UNC 3/8 x 16	3632-3/8TWP
1	UNC 1/2 x 13	3632-1/2TWP
1	UNF1/4 x 28	3634-1/4TWP
1	UNF 3/8 x 24	3634-3/8TWP
1	HSS DRILL 8.8mm	3620-8.8
1	HSS DRILL 10.8mm	3620-10.8
1	HSS DRILL 12.8mm	3620-12.8
1	HSS DRILL 14.75mm	3620-14.75
1	HSS DRILL Q(8.43/0.332)	3632-Q
1	HSS DRILL X(10.0/0.397)	3632-X
1	HSS DRILL 29/64	3632-29/64
1	HSS DRILL 37/64	3632-37/64
1	TAP INTER 10.00 x 1.25	3621-10.00I
1	TAP INTER 12.00 x 1.25	3622-12.00I
1	TAP INTER 14.00 x 1.5	3621-14.00I
1	TAP INTER 16.00 x 1.5	3621-16.00I
1	TAP INTER 3/8 x 16	3632-3/8I
1	TAP INTER 7/16 x 14	3632-7/16I
1	TAP INTER 1/2 x 13	3632-1/2I
1	TAP INTER 5/8 x 11	3632-5/8I
1	UNIVERSAL TOOL	3600-250T
1	UNIVERSAL TOOL	3600-312T
1	UNIVERSAL TOOL	3600-375T
1	UNIVERSAL TOOL	3600-500T

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Impossible to cross thread during installation.

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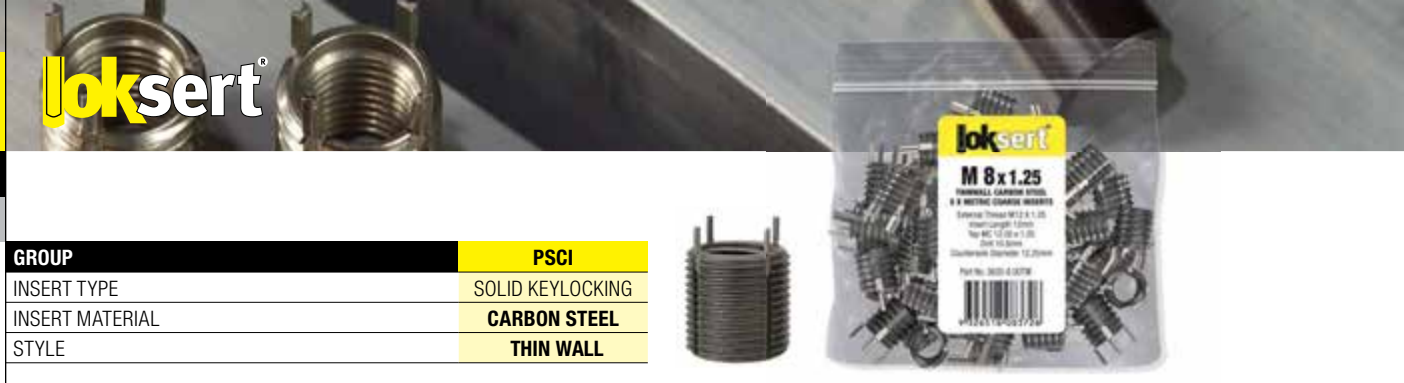
Available in Thinwall and Heavy Duty.



GROUP	PSCI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON STEEL**
STYLE	**THIN WALL**

MC
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Loksert

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METRIC COARSE – THIN WALL CARBON STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
5.00	**0.80**	8.00 X 1.25	8.00	6.9	3620-5.00TW	–	–	–	**7.595**	6.076	5.468	5.194
6.00	**1.00**	10.00 X 1.25	10.00	8.8	3620-6.00TW	–	–	–	**8.433**	6.746	6.071	5.768
8.00	**1.25**	12.00 X 1.25	12.00	10.8	3620-8.00TW	–	–	–	**9.282**	7.426	6.683	6.349
10.00	**1.50**	14.00 X 1.50	14.00	12.8	3620-10.00TW	–	–	–	**11.416**	9.134	8.219	7.809
12.00	**1.75**	16.00 X 1.50	16.00	14.75	3620-12.00TW	–	–	–	**14.730**	11.784	10.605	10.076

METRIC FINE – THIN WALL CARBON STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8.00	**1.00**	12.00 X 1.25	12.00	10.8	3621-8.00TW	–	–	–	**9.282**	7.426	6.683	6.349
10.00	**1.25**	14.00 X 1.50	14.00	12.8	3621-10.00TW	–	–	–	**11.416**	9.134	8.219	7.809
12.00	**1.25**	16.00 X 1.50	16.00	14.75	3621-12.00TW	–	–	–	**14.730**	11.784	10.605	10.076

UNC – THIN WALL CARBON STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**24**	5/16 X 18	0.31	I	3632-10GTW	–	–	–	**4.870**	3.897	3.506	3.332
1/4	**20**	3/8 X 16	0.37	Q	3632-1/4TW	–	–	–	**5.130**	4.103	3.694	3.509
5/16	**18**	7/16 X 14	0.43	X	3632-5/16TW	–	–	–	**5.779**	4.623	4.160	3.953
3/8	**16**	1/2 X 13	0.50	29/64	3632-3/8TW	–	–	–	**6.357**	5.085	4.577	4.348
7/16	**14**	9/16 X 12	0.56	33/64	3632-7/16TW	–	–	–	**8.244**	6.595	5.935	5.640
1/2	**13**	5/8 X 11	0.62	37/64	3632-1/2TW	–	–	–	**9.540**	7.634	6.870	6.526

UNF – THIN WALL CARBON STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**32**	5/16 X 18	0.31	I	3634-10GTW	–	–	–	**4.870**	3.897	3.506	3.332
1/4	**28**	3/8 X 16	0.37	Q	3634-1/4TW	–	–	–	**5.130**	4.103	3.694	3.509
5/16	**24**	7/16 X 14	0.43	X	3634-5/16TW	–	–	–	**5.779**	4.623	4.160	3.953
3/8	**24**	1/2 X 13	0.50	29/64	3634-3/8TW	–	–	–	**6.357**	5.085	4.577	4.348
7/16	**20**	9/16 X 12	0.56	33/64	3634-7/16TW	–	–	–	**8.244**	6.595	5.935	5.640
1/2	**20**	5/8 X 11	0.62	37/64	3634-1/2TW	–	–	–	**9.540**	7.634	6.870	6.526

GROUP	PSSI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**STAINLESS STEEL**
STYLE	**THIN WALL**

METRIC COARSE – THIN WALL STAINLESS STEEL BULK INSERTS

MM	MM	MM X MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
5.00	**0.80**	8.00 X 1.25	8.00	6.9	3720-5.00TW	–	**16.275**	16.275	13.834	11.759	10.583	10.583
6.00	**1.00**	10.00 X 1.25	10.00	8.8	3720-6.00TW	–	**16.829**	16.829	14.305	12.159	10.943	10.943
8.00	**1.25**	12.00 X 1.25	12.00	10.8	3720-8.00TW	–	**17.337**	17.337	14.737	12.525	11.273	11.273
10.00	**1.50**	14.00 X 1.50	14.00	12.8	3720-10.00TW	–	**17.855**	17.855	15.178	12.901	11.610	11.610
12.00	**1.75**	16.00 X 1.50	16.00	14.75	3720-12.00TW	–	**19.838**	19.838	16.862	14.333	12.898	12.898

METRIC FINE – THIN WALL STAINLESS STEEL BULK INSERTS

MM	MM	MM X MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8.00	**1.00**	12.00 X 1.25	12.00	10.8	3721-8.00TW	–	**17.337**	17.337	14.737	12.525	11.273	11.273
10.00	**1.25**	14.00 X 1.50	14.00	12.8	3721-10.00TW	–	**17.855**	17.855	15.178	12.901	11.610	11.610
12.00	**1.25**	16.00 X 1.50	16.00	14.75	3721-12.00TW	–	**19.838**	19.838	16.862	14.333	12.898	12.898

UNC – THIN WALL STAINLESS STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**24**	5/16 X 18	0.31	I	3732-10GTW	–	–	–	**7.984**	6.387	5.749	5.461
1/4	**20**	3/8 X 16	0.37	Q	3732-1/4TW	–	–	–	**8.374**	6.698	6.029	5.728
5/16	**18**	7/16 X 14	0.43	X	3732-5/16TW	–	–	**13.693**	13.693	10.954	9.858	9.366
3/8	**16**	1/2 X 13	0.50	29/64	3732-3/8TW	–	–	**16.806**	16.806	13.444	12.100	11.495
7/16	**14**	9/16 X 12	0.56	33/64	3732-7/16TW	–	**24.849**	24.849	19.879	17.891	16.997	16.997
1/2	**13**	5/8 X 11	0.62	37/64	3732-1/2TW	–	**26.464**	26.464	21.172	19.054	18.102	18.102

UNF – THIN WALL STAINLESS STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**32**	5/16 X 18	0.31	I	3734-10GTW	–	–	–	**7.984**	6.387	5.749	5.461
1/4	**28**	3/8 X 16	0.37	Q	3734-1/4TW	–	–	–	**8.374**	6.698	6.029	5.728
5/16	**24**	7/16 X 14	0.43	X	3734-5/16TW	–	–	**13.693**	13.693	10.954	9.858	9.366
3/8	**24**	1/2 X 13	0.50	29/64	3734-3/8TW	–	–	**16.806**	16.806	13.444	12.100	11.495
7/16	**20**	9/16 X 12	0.56	33/64	3734-7/16TW	–	**24.849**	24.849	19.879	17.891	16.997	16.997
1/2	**20**	5/8 X 11	0.62	37/64	3734-1/2TW	–	**26.464**	26.464	21.172	19.054	18.102	18.102

BORDO® INDUSTRIAL TOOLS

MC
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Loksert Features and Benefits

Solid bushing utilising locking keys provides positive mechanical lock against rotation.

High strength and reliability provides maximum pullout strength.

Installed using standard drills and taps.

Simple installation - no special skills required.

Suitable for use in a wide range of parent materials.

Impossible to cross thread during installation.

Simple removal process if required.

No tang to break and remove.

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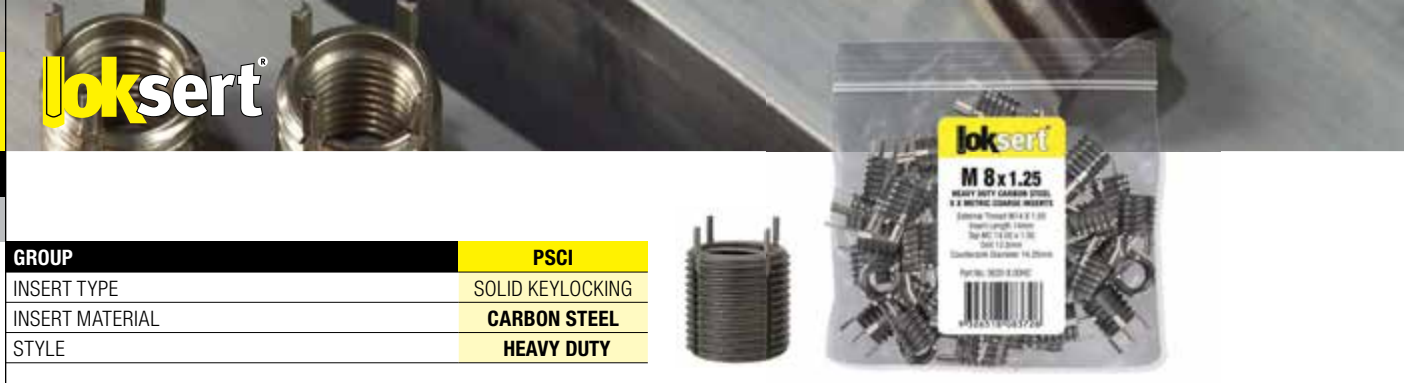
Available in Thinwall and Heavy Duty.



GROUP	PSCI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON STEEL**
STYLE	**HEAVY DUTY**

METRIC COARSE – HEAVY DUTY CARBON STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
4.00	**0.70**	8.00 X 1.25	8.00	6.9	3620-4.00HD	–	–	–	**15.049**	12.039	10.835	10.293
5.00	**0.80**	10.00 X 1.25	10.00	8.8	3620-5.00HD	–	–	–	**7.595**	6.076	5.468	5.194
6.00	**1.00**	12.00 X 1.25	12.00	10.8	3620-6.00HD	–	–	–	**8.433**	6.746	6.071	5.768
8.00	**1.25**	14.00 X 1.50	14.00	12.8	3620-8.00HD	–	–	–	**9.282**	7.426	6.683	6.349
10.00	**1.50**	16.00 X 1.50	16.00	14.75	3620-10.00HD	–	–	–	**11.416**	9.134	8.219	7.809
12.00	**1.75**	18.00 X 1.50	18.00	16.75	3620-12.00HD	–	–	–	**14.730**	11.784	10.605	10.076
14.00	**2.00**	20.00 X 1.50	20.00	18.75	3620-14.00HD	–	–	**17.773**	17.773	14.218	12.796	12.157
16.00	**2.00**	22.00 X 1.50	22.00	20.5	3620-16.00HD	–	–	**21.086**	16.869	15.182	14.423	14.423
20.00	**2.50**	30.00 X 2.00	30.00	28.0	3620-20.00HD	–	**36.843**	36.843	29.475	29.475	29.475	29.475
24.00	**3.00**	33.00 X 2.00	33.00	31.0	3620-24.00HD	**59.676**	59.676	59.676	47.740	47.740	47.740	47.740

METRIC FINE – HEAVY DUTY CARBON STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8.00	**1.00**	14.00 X 1.5	8.00	12.8	3621-8.00HD	–	–	–	**9.282**	7.426	6.683	6.349
10.00	**1.25**	16.00 X 1.5	16.00	14.75	3621-10.00HD	–	–	–	**11.416**	9.134	8.219	7.809
12.00	**1.25**	18.00 X 1.5	18.00	16.75	3621-12.00HD	–	–	–	**14.730**	11.784	10.605	10.076
14.00	**1.50**	20.00 X 1.5	20.00	18.75	3621-14.00HD	–	–	**17.773**	17.773	14.218	12.796	12.157
16.00	**1.50**	22.00 X 1.5	22.00	20.5	3621-16.00HD	–	–	**21.086**	16.869	15.182	14.423	14.423
18.00	**1.50**	24.00 X 1.5	24.00	22.5	3621-18.00HD	–	**31.465**	31.465	31.465	25.173	22.655	21.522
20.00	**1.50**	30.00 X 2.0	30.00	28.0	3621-20.00HD	–	**36.843**	36.843	29.475	29.475	29.475	29.475
22.00	**1.50**	32.00 X 2.0	32.00	30.0	3621-22.00HD	**44.497**	44.497	44.497	35.598	35.598	35.598	35.598
24.00	**2.00**	33.00 X 2.0	33.00	31.0	3621-24.00HD	**59.676**	59.676	59.676	47.740	47.740	47.740	47.740

MC
MF

Loksert

Loksert solid keylocking inserts are an easily installed thread assembly that is ideal for replacing damaged or worn threads in virtually any material – ferrous, non-ferrous and non-metallic.

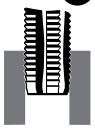
They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

INSTALLATION

1 DRILL

Drill to clear the damaged thread with a standard twist drill. Chamfer the hole with a standard countersink (82° - 100°)

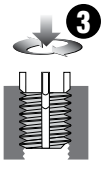
Note: Drill is oversize to accomodate external thread. Check technical charts for correct drill sizes.



2 TAP

Create new thread using a standard tap. Check technical charts for correct tap size.

Note: Use of a suitable lubricant is essential during all tapping procedures.



3 INSERT

Screw the insert into the threaded hole until slightly below the surface of the parent material.

4 DRIVE

Select the correct size installation tool and place over the insert. Drive locking keys down using several hammer taps on end of installation tool.

GROUP	PSCI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON STEEL**
STYLE	**HEAVY DUTY**

BORDO® INDUSTRIAL TOOLS

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UNC – HEAVY DUTY CARBON STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8G	**32**	5/16 X 18	0.31	I	3632-8GHD	–	–	–	**8.113**	6.491	5.842	5.549
10G	**24**	3/8 X 16	0.31	Q	3632-10GHD	–	–	–	**4.870**	3.897	3.506	3.332
1/4	**20**	7/16 X 14	0.37	X	3632-1/4HD	–	–	–	**5.130**	4.103	3.694	3.509
5/16	**18**	1/2 X 13	0.43	29/64	3632-5/16HD	–	–	–	**5.708**	4.566	4.111	3.904
3/8	**16**	9/16 X 12	0.5	33/64	3632-3/8HD	–	–	–	**6.357**	5.085	4.577	4.348
7/16	**14**	5/8 X 11	0.62	37/64	3632-7/16HD	–	–	–	**8.113**	6.491	5.842	5.549
1/2	**13**	3/4 X 16	0.62	45/64	3632-1/2HD	–	–	–	**9.540**	7.634	6.870	6.526
9/16	**12**	3/4 X 16	0.81	45/64	3632-9/16HD	–	–	**13.044**	13.044	10.435	9.391	8.922
5/8	**11**	7/8 X 14	0.87	53/64	3632-5/8HD	–	–	**15.378**	15.378	12.304	11.073	10.519
3/4	**10**	1-1/8 X 12	1.12	1-1/16	3632-3/4HD	–	**21.924**	21.924	21.924	17.539	15.786	14.996
7/8	**9**	1-1/4 X 12	1.25	1-3/16	3632-7/8HD	–	**28.670**	28.670	28.670	22.936	20.642	19.610
1	**8**	1-3/8 X 12	1.37	1-5/16	3632-1HD	**58.119**	58.119	58.119	58.119	46.495	41.846	39.753
1-1/8	**7**	1-1/2 X 12	1.62	1-7/16	3632-1.1/8HD	**140.108**	140.108	140.108	140.108	112.086	112.086	112.086
1-1/4	**7**	1-5/8 X 12	1.81	1-9/16	3632-1.1/4HD	**172.092**	172.093	172.093	172.093	137.674	137.674	137.674
1-1/2	**6**	1-7/8 X 12	2	1-13/16	3632-1.1/2HD	**331.330**	331.330	331.330	331.330	331.330	331.330	331.330

UNF – HEAVY DUTY CARBON STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**32**	3/8 X 16	0.31	Q	3634-10GHD	–	–	–	**4.870**	3.897	3.506	3.332
1/4	**28**	7/16 X 14	0.37	X	3634-1/4HD	–	–	–	**5.130**	4.103	3.694	3.509
5/16	**24**	1/2 X 13	0.43	29/64	3634-5/16HD	–	–	–	**5.708**	4.566	4.111	3.904
3/8	**24**	9/16 X 12	0.5	33/64	3634-3/8HD	–	–	–	**6.357**	5.085	4.577	4.348
7/16	**20**	5/8 X 11	0.62	37/64	3634-7/16HD	–	–	–	**8.113**	6.491	5.842	5.549
1/2	**20**	3/4 X 16	0.62	45/64	3634-1/2HD	–	–	–	**9.540**	7.634	6.870	6.526
9/16	**18**	3/4 X 16	0.81	45/64	3634-9/16HD	–	–	**13.044**	13.044	10.435	9.391	8.922
5/8	**18**	7/8 X 14	0.87	53/64	3634-5/8HD	–	–	**15.378**	15.378	12.304	11.073	10.519
3/4	**16**	1-1/8 X 12	1.12	1-1/16	3634-3/4HD	–	**21.924**	21.924	21.924	17.539	15.786	14.996
7/8	**14**	1-1/4 X 12	1.25	1-3/16	3634-7/8HD	–	**28.670**	28.670	28.670	22.936	20.642	19.610
1	**12**	1-3/8 X 12	1.37	1-5/16	3634-1HD	**58.119**	58.119	58.119	58.119	46.495	41.846	39.753
1	**14**	1-3/8 X 12	1.37	1-5/16	3635-1HD	**58.119**	58.119	58.119	58.119	46.495	41.846	39.753
1-1/8	**12**	1-1/2 X 12	1.62	1-7/16	3634-1.1/8HD	**140.108**	140.108	140.108	140.108	112.086	112.086	112.086
1-1/4	**12**	1-5/8 X 12	1.81	1-9/16	3634-1.1/4HD	**172.093**	172.093	172.093	172.093	137.674	137.674	137.674
1-1/2	**12**	1-7/8 X12	2	1-13/16	3634-1.1/2HD	**331.330**	331.330	331.330	331.330	331.330	331.330	331.330

Loksert Features and Benefits

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Impossible to cross thread during installation.

Simple removal process if required.

No tang to break and remove.

Available in metric sizes and inch sizes.

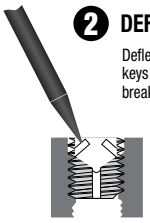
Available in Thinwall and Heavy Duty.

loksert® REMOVAL

1 DRILL

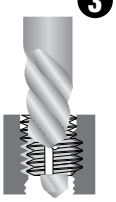
Drill out the material between the locking keys and the internal thread to the specified depth.

Note: Drill size and drilling depth are shown in the loksert technical tables.



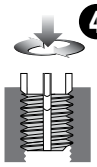
2 DEFLECT

Deflect locking keys inward and break off



3 REMOVE

Remove the insert from the hole by winding it out using a screw extractor or similar type tool.



4 INSERT

A new loksert insert of exactly the same size can be installed in the original hole.

GROUP	PSSI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**STAINLESS STEEL**
STYLE	**HEAVY DUTY**

MC
MF

Loksert

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They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

METRIC COARSE – HEAVY DUTY STAINLESS STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
4.00	**0.70**	8.00 X 1.25	8.00	6.9	3720-4.00HD	–	**20.214**	20.214	20.214	17.182	14.604	13.144
5.00	**0.80**	10.00 X 1.25	10.00	8.8	3720-5.00HD	–	**20.663**	20.663	20.663	17.562	14.929	13.436
6.00	**1.00**	12.00 X 1.25	12.00	10.8	3720-6.00HD	–	**21.783**	21.783	21.783	18.515	15.737	14.165
8.00	**1.25**	14.00 X 1.50	14.00	12.8	3720-8.00HD	–	**22.914**	22.914	22.914	19.478	16.555	14.901
10.00	**1.50**	16.00 X 1.50	16.00	14.75	3720-10.00HD	–	**24.047**	24.047	24.047	20.440	17.373	15.637
12.00	**1.75**	18.00 X 1.50	18.00	16.75	3720-12.00HD	–	**25.167**	25.167	25.167	21.393	18.184	16.364
14.00	**2.00**	20.00 X 1.50	20.00	18.75	3720-14.00HD	**28.611**	28.611	28.611	28.611	24.320	20.671	18.604
16.00	**2.00**	22.00 X 1.50	22.00	20.5	3720-16.00HD	**37.079**	37.079	37.079	37.079	31.517	26.790	24.110
20.00	**2.50**	30.00 X 2.00	30.00	28	3720-20.00HD	**71.517**	71.517	71.517	71.517	60.790	51.671	46.503
24.00	**3.00**	33.00 X 2.00	33.00	31	3720-24.00HD	**76.812**	76.812	76.812	76.812	65.290	55.497	49.947

METRIC FINE – HEAVY DUTY STAINLESS STEEL BULK INSERTS

MM	MM	MM	MM	MM	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8.00	**1.00**	14.00 X 1.5	8.00	12.8	3721-8.00HD	–	**22.914**	22.914	22.914	19.478	16.555	14.901
10.00	**1.25**	16.00 X 1.5	16.00	14.75	3721-10.00HD	–	**24.047**	24.047	24.047	20.440	17.373	15.637
12.00	**1.25**	18.00 X 1.5	18.00	16.75	3721-12.00HD	–	**25.167**	25.167	25.167	21.393	18.184	16.364
14.00	**1.50**	20.00 X 1.5	20.00	18.75	3721-14.00HD	**28.611**	28.611	28.611	28.611	24.320	20.671	18.604
16.00	**1.50**	22.00 X 1.5	22.00	20.5	3721-16.00HD	**37.079**	37.079	37.079	37.079	31.517	26.790	24.110
18.00	**1.50**	24.00 X 1.5	24.00	22.5	3721-18.00HD	**71.517**	71.517	71.517	71.517	60.790	51.671	46.503
20.00	**1.50**	30.00 X 2.0	30.00	28	3721-20.00HD	**71.517**	71.517	71.517	71.517	60.790	51.671	46.503
22.00	**1.50**	32.00 X 2.0	32.00	30	3721-22.00HD	**76.812**	76.812	76.812	76.812	65.290	55.497	49.947
24.00	**2.00**	33.00 X 2.0	33.00	31	3721-24.00HD	**113.856**	113.856	113.856	113.856	96.777	82.260	74.034

GROUP	PSSI
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**STAINLESS STEEL**
STYLE	**HEAVY DUTY**

BORDO® INDUSTRIAL TOOLS

UNC
UNF

UNC – HEAVY DUTY STAINLESS STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
8G	**32**	5/16 X 18	0.31	I	3732-8GHD	–	–	–	**7.595**	6.076	5.468	5.194
10G	**24**	3/8 X 16	0.31	Q	3732-10GHD	–	–	–	**8.374**	6.698	6.029	5.728
1/4	**20**	7/16 X 14	0.37	X	3732-1/4HD	–	–	–	**9.081**	7.265	6.539	6.212
5/16	**18**	1/2 X 13	0.43	29/64	3732-5/16HD	–	–	–	**13.563**	10.850	9.765	9.277
3/8	**16**	9/16 X 12	0.5	33/64	3732-3/8HD	–	–	–	**15.828**	12.662	11.395	10.827
7/16	**14**	5/8 X 11	0.62	37/64	3732-7/16HD	–	–	–	**23.292**	18.634	16.771	15.933
1/2	**13**	3/4 X 16	0.62	45/64	3732-1/2HD	–	–	–	**28.481**	22.786	20.507	19.482
9/16	**12**	3/4 X 16	0.81	45/64	3732-9/16HD	–	–	**30.226**	30.226	24.182	21.763	20.675
5/8	**11**	7/8 X 14	0.87	53/64	3732-5/8HD	–	–	**37.951**	37.951	30.362	27.325	25.959
3/4	**10**	1-1/8 X 12	1.12	1-1/16	3732-3/4HD	–	**44.568**	44.568	44.568	35.655	32.089	30.485
7/8	**9**	1-1/4 X 12	1.25	1-3/16	3732-7/8HD	–	**83.936**	83.936	83.936	67.149	67.149	67.149
1	**8**	1-3/8 X 12	1.37	1-5/16	3732-1HD	**106.379**	106.379	106.379	106.379	106.379	106.379	106.379

UNF – HEAVY DUTY STAINLESS STEEL BULK INSERTS

INCH	TPI	INCH X TPI	INCH	INCH	PART #	$ EACH 1	$ EACH 2	$ EACH 3	$ EACH 4	$ EACH 6	$ EACH 100	$ EACH 500
10G	**32**	3/8 X 16	0.31	Q	3734-10GHD	–	–	**8.374**	8.374	6.698	6.029	5.728
1/4	**28**	7/16 X 14	0.37	X	3734-1/4HD	–	–	**8.374**	8.374	6.698	6.029	5.728
5/16	**24**	1/2 X 13	0.43	29/64	3734-5/16HD	–	**13.563**	13.563	13.563	10.850	9.765	9.277
3/8	**24**	9/16 X 12	0.5	33/64	3734-3/8HD	–	**15.828**	15.828	15.828	12.662	11.395	10.827
7/16	**20**	5/8 X 11	0.62	37/64	3734-7/16HD	–	**23.292**	23.292	23.292	18.634	16.771	15.933
1/2	**20**	3/4 X 16	0.62	45/64	3734-1/2HD	–	**28.481**	28.481	28.481	22.786	20.507	19.482
9/16	**18**	3/4 X 16	0.81	45/64	3734-9/16HD	–	**30.226**	30.226	30.226	24.182	21.763	20.675
5/8	**18**	7/8 X 14	0.87	53/64	3734-5/8HD	–	**37.951**	37.951	37.951	30.362	27.325	25.959
3/4	**16**	1-1/8 X 12	1.12	1-1/16	3734-3/4HD	–	**44.568**	44.568	44.568	35.655	32.089	30.485
7/8	**14**	1-1/4 X 12	1.25	1-3/16	3734-7/8HD	**83.936**	83.936	83.936	83.936	67.149	67.149	67.149
1	**12**	1-3/8 X 12	1.37	1-5/16	3734-1HD	**106.376**	106.376	106.376	106.376	106.376	106.376	106.376

Loksert Features and Benefits

Solid bushing utilising locking keys provides positive mechanical lock against rotation.

High strength and reliability provides maximum pullout strength.

Installed using standard drills and taps.

Simple installation - no special skills required.

Suitable for use in a wide range of parent materials.

Impossible to cross thread during installation.

Simple removal process if required.

No tang to break and remove.

Available in metric sizes and inch sizes.

Available in Thinwall and Heavy Duty.

BORDO INDUSTRIAL TOOLS

MC
MF
UNC
UNF

Loksert

Loksert solid keylocking inserts are an easily installed thread assembly that is ideal for replacing damaged or worn threads in virtually any material – ferrous, non-ferrous and non-metallic.

They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

GROUP	PSCI	PSCI
TO SUIT INSERT TYPE	**THINWALL**	**THINWALL**
TAP / DRILL MATERIAL	HSS	HSS
TAP LEAD TYPE	INTERMEDIATE 4-5	–
DRILL POINT TYPE	–	118º SPLIT POINT / 118º NOTCHED POINT

METRIC COARSE AND METRIC FINE

MM	MM	MM X MM	MM	$	PART #	MM	$	PART #
5.00	**0.80**	8.00 X 1.25	72.00	**11.20**	3620-8.00I	6.90	**7.95**	3620-6.9
6.00	**1.00**	10.00 X 1.25	76.00	**28.49**	3621-10.00I	8.80	**12.76**	3620-8.8
8.00	**1.25**	12.00 X 1.25	84.00	**32.73**	3622-12.00I	10.80	**28.28**	3620-10.8
10.00	**1.50**	14.00 X 1.50	95.00	**44.33**	3621-14.00I	12.80	**41.11**	3620-12.8
12.00	**1.75**	16.00 X 1.50	102.00	**48.30**	3621-16.00I	14.75	**42.97**	3620-14.75*

UNC AND UNF

INCH	TPI	INCH X TPI	MM	$	PART #	INCH	$	PART #
10G	**24**	5/16 X 18	72.00	**11.20**	3632-5/16I	I	**6.71**	3632-I
1/4	**20**	3/8 X 16	80.00	**15.33**	3632-3/8I	Q	**9.48**	3632-Q
5/16	**18**	7/16 X 14	85.00	**20.64**	3632-7/16I	X	**16.19**	3632-X
3/8	**16**	1/2 X 13	89.00	**22.70**	3632-1/2I	29/64	**22.33**	3632-29/64
7/16	**14**	9/16 X 12	95.00	**32.78**	3632-9/16I	33/64	**42.97**	3632-33/64*
1/2	**13**	5/8 X 11	102.00	**34.56**	3632-5/8I	37/64	**53.95**	3632-37/64*

* Supplied as Reduced Shank HSS 118º notched point drill.

HSS 118º Split Point Jobber Drill – Bright Finish

HSS 118º Notched Point Reduced Shank Drill – Bright/Black Finish

HSS 118º Notched Point Morse Taper Shank Drill – Black Finish

BORDO® INDUSTRIAL TOOLS

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GROUP	PSCI	PSCI
TO SUIT INSERT TYPE	**HEAVY DUTY**	**HEAVY DUTY**
TAP / DRILL MATERIAL	HSS	HSS
TAP LEAD TYPE	INTERMEDIATE 4-5	–
DRILL POINT TYPE	–	118º SPLIT POINT / 118º NOTCHED POINT

METRIC COARSE & METRIC FINE

MM	MM X MM	MM	$	PART #	MM	$	PART #
4.00	8.00 X 1.25	72.00	**11.20**	3620-8.00I	6.90	**7.95**	3620-6.9
5.00	10.00 X 1.25	76.00	**28.49**	3621-10.00I	8.80	**12.76**	3620-8.8
6.00	12.00 X 1.25	84.00	**32.73**	3622-12.00I	10.80	**28.28**	3620-10.8
8.00	14.00 X 1.50	95.00	**44.33**	3621-14.00I	12.80	**41.11**	3620-12.8
10.00	16.00 X 1.50	102.00	**48.30**	3621-16.00I	14.75	**42.97**	3620-14.75*
12.00	18.00 X 1.50	104.00	**106.85**	3622-18.00I	16.75	**66.79**	3620-16.75*
14.00	20.00 X 1.50	104.00	**133.62**	3623-20.00I	18.75	**68.34**	3620-18.75*
16.00	22.00 X 1.50	113.00	**160.10**	3621-22.00I	20.50	**84.19**	3620-20.50*
18.00	24.00 X 1.50	120.00	**166.45**	3624-24.00I	22.50	**92.74**	3620-22.50*
20.00	30.00 X 2.00	127.00	**204.39**	3621-30.00I	28.00	**151.32**	3620-28.00*
22.00	32.00 X 2.00	137.00	**299.75**	3622-32.00I	30.00	**158.62**	3620-30.00*
24.00	33.00 X 2.00	137.00	**299.75**	3621-33.00I	31.00	**167.60**	3620-31.00*

UNC & UNF

INCH	INCH X TPI	MM	$	PART #	INCH	$	PART #
8G	5/16 X 18	72.00	**11.20**	3632-5/16I	I	**6.71**	3632-I
10G	3/8 X 16	80.00	**15.33**	3632-3/8I	Q	**9.48**	3632-Q
1/4	7/16 X 14	85.00	**20.64**	3632-7/16I	X	**16.19**	3632-X
5/16	1/2 X 13	89.00	**22.70**	3632-1/2I	29/64	**22.33**	3632-29/64
3/8	9/16 X 12	95.00	**32.78**	3632-9/16I	33/64	**42.97**	3632-33/64*
7/16	5/8 X 11	102.00	**34.56**	3632-5/8I	37/64	**53.95**	3632-37/64*
1/2	3/4 X 16	104.00	**77.07**	3632-3/4I	45/64	**69.95**	3632-45/64*
9/16	3/4 X 16	104.00	**77.07**	3632-3/4I	45/64	**69.95**	3632-45/64*
5/8	7/8 X 14	113.00	**107.38**	3632-7/8I	53/64	**88.62**	3632-53/64*
3/4	1-1/8 X 12	127.00	**228.43**	3632-1.1/8I	1-1/16	**141.56**	3632-1.1/16*
7/8	1-1/4 X 12	137.00	**255.20**	3632-1.1/4I	1-3/16	**158.62**	3632-1.3/16*
1	1-3/8 X 12	144.00	**338.87**	3632-1.3/8I	1-5/16	**300.93**	3632-1.5/16**
1-1/8	1-1/2 X 12	149.00	**379.84**	3632-1.1/2I	1-7/16	**392.12**	3632-1.7/16**
1-1/4	1-5/8 X 12	170.00	**427.14**	3632-1.5/8I	1-9/16	**449.28**	3632-1.9/16**
1-1/2	1-7/8 X 12	186.00	**557.98**	3632-1.7/8I	1-13/16	**528.50**	3632-1.13/16**

* Supplied as Reduced Shank HSS 118º notched point drill.
** Supplied as Morse Taper Shank (MTS) HSS 118º notched point drill.

Loksert Features and Benefits

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Available in Thinwall and Heavy Duty.

GROUP	PSIT
INSERT TYPE	SOLID KEYLOCKING
INSERT MATERIAL	**CARBON & STAINLESS STEEL**

Loksert

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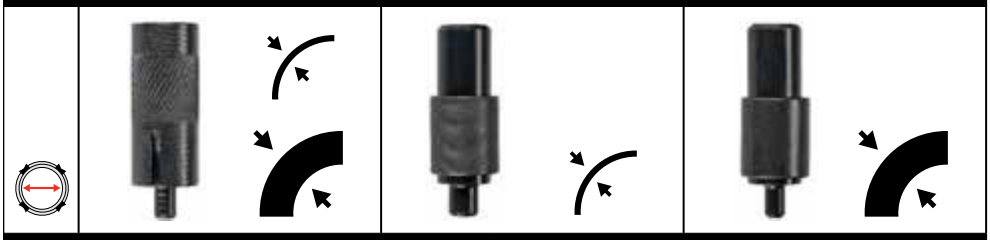
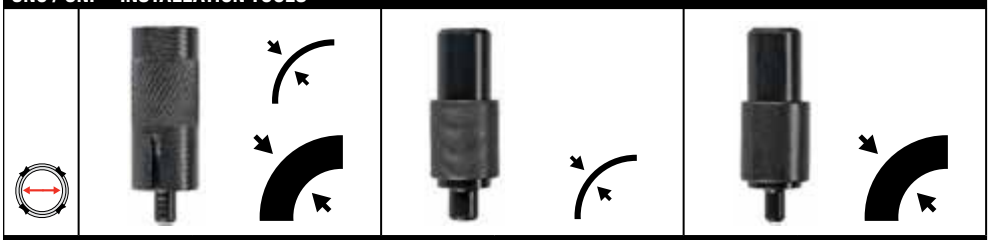
METRIC – INSTALLATION TOOLS



	UNIVERSAL TOOL		THIN WALL TOOL		HEAVY DUTY TOOL	
MM	$	PART #	$	PART #	$	PART #
4.00	–	–	–	–	**39.51**	3600-4.00HT
5.00	**24.33**	3600-190T	**40.55**	3600-5.00TT	**40.55**	3600-5.00HT
6.00	**25.11**	3600-250T	**41.84**	3600-6.00TT	**41.84**	3600-6.00HT
8.00	**26.07**	3600-312T	**43.46**	3600-8.00TT	**43.46**	3600-8.00HT
10.00	**28.02**	3600-375T	**46.70**	3600-10.00TT	**46.70**	3600-10.00HT
12.00	**31.84**	3600-500T	**50.13**	3600-12.00TT	**50.13**	3600-12.00HT
14.00	–	–	–	–	**54.84**	3600-14.00HT
16.00	**34.06**	3600-625T	–	–	**56.76**	3600-16.00HT
18.00	–	–	–	–	**61.92**	3600-18.00HT
20.00	**36.08**	3600-875T	–	–	**64.87**	3600-20.00HT
22.00	–	–	–	–	**67.81**	3600-22.00HT
24.00	–	–	–	–	**73.12**	3600-24.00HT

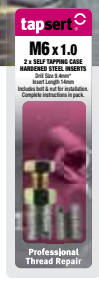
UNC / UNF – INSTALLATION TOOLS



	UNIVERSAL TOOL		THIN WALL TOOL		HEAVY DUTY TOOL	
INCH	$	PART #	$	PART #	$	PART #
8G	–	–	–	–	**70.76**	3600-8GHT
10G	**24.33**	3600-190T	**46.62**	3600-10GTT	**53.07**	3600-10GHT
1/4	**25.11**	3600-250T	**48.12**	3600-1/4TT	**50.13**	3600-1/4HT
5/16	**26.07**	3600-312T	**51.19**	3600-5/16TT	**52.07**	3600-5/16HT
3/8	**28.02**	3600-375T	**76.74**	3600-3/8TT	**55.97**	3600-3/8HT
7/16	**28.02**	3600-375T	**77.06**	3600-7/16TT	**60.09**	3600-7/16HT
1/2	**31.84**	3600-500T	**80.79**	3600-1/2TT	**63.16**	3600-1/2HT
9/16	**31.84**	3600-500T	–	–	**66.85**	3600-9/16HT
5/8	**34.06**	3600-625T	–	–	**70.29**	3600-5/8HT
3/4	**36.08**	3600-875T	–	–	**85.50**	3600-3/4HT
7/8	**36.08**	3600-875T	–	–	**93.35**	3600-7/8HT
1	**44.39**	3600-100T	–	–	**95.73**	3600-1HT
1-1/8	–	–	–	–	**256.04**	3600-1.1/8HT
1-1/4	–	–	–	–	**277.38**	3600-1.1/4HT
1-1/2	–	–	–	–	**334.64**	3600-1.1/2HT

BORDO INDUSTRIAL TOOLS

tapsert®



GROUP	STSI
INSERT TYPE	SELF TAPPING
INSERT MATERIAL	**CASE HARDENED STEEL**
FINISH	YELLOW ZINC PASSIVATED

BORDO INDUSTRIAL TOOLS

MC SPARK UNC UNF

Tapserts

Tapserts are self cutting threaded inserts that feature both external and internal threads. They are driven into a pre-formed or pre-drilled retaining hole and the cutting slots (or cutting bores) effectively tap the hole as the insert is wound into the parent material.

Tapserts are ideal for use in low shear strength materials (such as alloys, plastics and castings) which require threaded seats with high load capacity and wear resistance.

Tapserts feature:

High pull-out strength

High loading capacity in low shear strength materials

Wear free, vibration resistant screw joint

Pre-cast or pre-drilled holes with standard tolerance

No requirement for thread tapping tools

Retains and captures chips from installation in chipping reservoirs.

METRIC

MM	MM	MM X MM	MM	$	PART #	#	MM
2.50	**0.45**	4.50 X 0.50	6	**12.01**	3920-2.5X6P	2	4.3*
3.00	**0.50**	5.00 X 0.50	6	**12.01**	3920-3X6P	2	4.8*
4.00	**0.70**	6.50 X 0.75	8	**10.92**	3920-4X8P	2	6.2*
5.00	**0.80**	8.00 X 1.00	10	**10.92**	3920-5X10P	2	7.6*
6.00	**1.00**	10.00 X 1.50	14	**10.92**	3920-6X14P	2	9.4*
8.00	**1.25**	12.00 X 1.50	15	**12.01**	3920-8X15P	2	11.4*
10.00	**1.50**	14.00 X 1.50	18	**13.10**	3920-10X18P	2	13.4*
12.00	**1.75**	16.00 X 1.50	22	**15.29**	3920-12X22P	2	15.4*
14.00	**2.00**	18.00 X 1.50	24	**15.98**	3920-14X24P	2	17.4*
16.00	**1.50**	20.00 X 1.50	22	**22.93**	3921-16X22P	2	19.4*
16.00	**2.00**	20.00 X 1.50	22	**22.93**	3920-16X22P	2	19.4*

SPARK PLUG

MM	MM	MM X MM	MM	$	PART #	#	MM
14.00	**1.25**	17.70 X 1.25	9	**19.11**	3922-14X9P	2	17.4*
14.00	**1.25**	17.70 X 1.25	15	**20.20**	3922-14X15P	2	17.4*
14.00	**1.25**	17.70 X 1.25	9 & 15	**20.20**	3922-14CP	1 EACH	17.4*

UNC

INCH	TPI	MM X MM	MM	$	PART #	#	MM
4G	**40**	5.00 X 0.50	6	**9.66**	3932-4GX6P	2	4.8*
6G	**32**	6.00 X 0.75	8	**9.66**	3932-6GX8P	2	5.7*
8G	**32**	6.50 X 0.75	8	**9.66**	3932-8GX8P	2	6.2*
10G	**24**	8.00 X 1.00	10	**9.66**	3932-10GX10P	2	7.6*
1/4	**20**	10.00 X 1.50	14	**10.92**	3932-1/4X14P	2	9.4*
5/16	**18**	12.00 X 1.50	15	**12.01**	3932-5/16X15P	2	11.4*
3/8	**16**	14.00 X 1.50	18	**13.10**	3932-3/8X18P	2	13.4*
7/16	**14**	16.00 X 1.50	22	**14.20**	3932-7/16X22P	2	15.4*
1/2	**13**	18.00 X 1.50	22	**15.29**	3932-1/2X22P	2	17.4*
5/8	**11**	20.00 X 1.50	22	**17.03**	3932-5/8X22P	2	19.4*

UNF

INCH	TPI	MM X MM	MM	$	PART #	#	MM
10G	**32**	8.00 X 1.00	10	**9.66**	3934-10GX10P	2	7.6*
1/4	**28**	10.00 X 1.50	14	**10.92**	3934-1/4X14P	2	9.4*
5/16	**24**	12.00 X 1.50	15	**12.01**	3934-5/16X15P	2	11.4*
3/8	**24**	14.00 X 1.50	18	**13.10**	3934-3/8X18P	2	13.4*
7/16	**20**	16.00 X 1.50	22	**14.20**	3934-7/16X22P	2	15.4*
1/2	**20**	18.00 X 1.50	22	**15.29**	3934-1/2X22P	2	17.4*
5/8	**18**	20.00 X 1.50	22	**17.03**	3934-5/8X22P	2	19.4*

* Tapping drill not included in kit.

GROUP	STSI
INSERT TYPE	SELF TAPPING
INSERT MATERIAL	CASE HARDENED STEEL
FINISH	YELLOW ZINC PASSIVATED

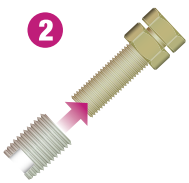
MERCHANDISER

	$	PART #
TAPSERT HANG SELL MERCHANDISER	**562.34**	3900-D1

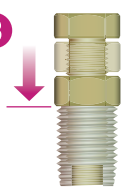
#	PART #
2	3920-3X6P
2	3920-4X8P
2	3920-5X10P
2	3920-6X14P
2	3920-8X15P
2	3920-10X18P
2	3920-12X22P
2	3920-16X22P
2	3921-16X22P
2	3922-14X15P
2	3922-14X9P
2	3922-14CP
2	3932-1/4X14P
2	3932-5/16X15P
2	3932-3/8X18P
2	3932-7/16X22P
2	3932-1/2X22P
2	3934-5/16x15P
2	3934-3/8X18P

tapsert® INSTALLATION

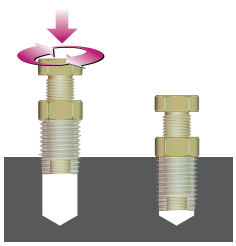
1 Drill hole to recommended size as shown in the selection table.



2 Thread the Tapsert on to the bolt ensuring the slot side is down. The insert should be flush with the end of the bolt.



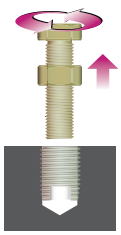
3 Thread the nut down the bolt until it sits firmly against the top of the Tapsert.



4 To ensure the Tapsert installation is straight apply downward pressure on the assembly.

If using an open ended wrench apply downward pressure to the bolt head whilst turning the nut to wind the Tapsert in. Alternatively if using a socket for installation apply downward pressure to the socket.

The Tapsert is installed when the nut is flush with the top of the parent material.



5 Loosen the nut with an open ended wrench and wind the nut and bolt assembly out of the Tapsert.

Congratulations – you have successfully created a new thread.

NOTE Tapping fluid should be used to aid installation.

Tapserts

Tapserts are self cutting threaded inserts that feature both external and internal threads. They are driven into a pre-formed or pre-drilled retaining hole and the cutting slots (or cutting bores) effectively tap the hole as the insert is wound into the parent material.

Tapserts are ideal for use in low shear strength materials (such as alloys, plastics and castings) which require threaded seats with high load capacity and wear resistance.

Tapserts feature:

High pull-out strength

High loading capacity in low shear strength materials

Wear free, vibration resistant screw joint

Pre-cast or pre-drilled holes with standard tolerance

No requirement for expensive thread tapping tools

Retains and captures chips from installation in chipping reservoirs.

tapsert®

BORDO® INDUSTRIAL TOOLS

MC SPARK UNC UNF

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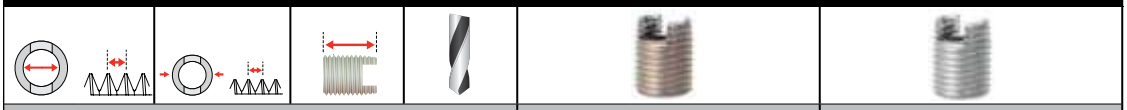
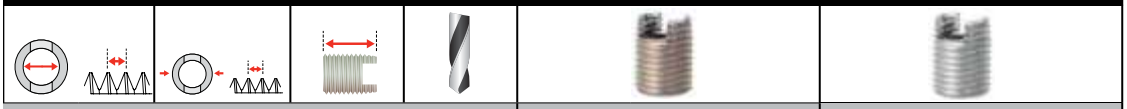
GROUP	STSI	STSS
INSERT TYPE	SELF TAPPING	SELF TAPPING
INSERT MATERIAL	**CASE HARDENED STEEL**	**STAINLESS STEEL**
FINISH	YELLOW ZINC PASSIVATED	BRIGHT

METRIC COARSE



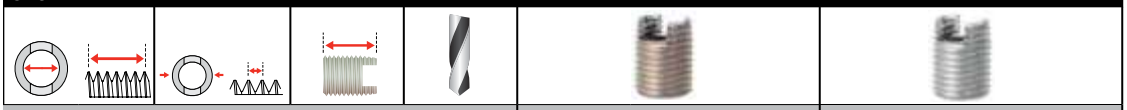
MM	MM	MM X MM	MM	MM	$	PART #	$	PART #
2.50	**0.45**	4.50 X 0.50	6	4.3*	**0.45**	3920-2.5X6	**0.80**	3920-2.5X6SS
3.00	**0.50**	5.00 X 0.50	6	4.8*	**0.44**	3920-3X6	**0.81**	3920-3X6SS
4.00	**0.70**	6.50 X 0.75	8	6.2*	**0.60**	3920-4X8	**1.10**	3920-4X8SS
5.00	**0.80**	8.00 X 1.00	10	7.6*	**0.79**	3920-5X10	**1.62**	3920-5X10SS
6.00	**1.00**	10.00 X 1.50	14	9.4*	**1.11**	3920-6X14	**2.14**	3920-6X14SS
8.00	**1.25**	12.00 X 1.50	15	11.4*	**1.45**	3920-8X15	**2.85**	3920-8X15SS
10.00	**1.50**	14.00 X 1.50	18	13.4*	**2.05**	3920-10X18	**3.95**	3920-10X18SS
12.00	**1.75**	16.00 X 1.50	22	15.4*	**3.01**	3920-12X22	**5.92**	3920-12X22SS
14.00	**2.00**	18.00 X 1.50	24	17.4*	**3.55**	3920-14X24	**6.52**	3920-14X24SS
16.00	**1.50**	20.00 X 1.50	22	19.4*	**4.00**	3921-16X22	–	–
16.00	**2.00**	20.00 X 1.50	22	19.4*	**4.00**	3920-16X22	**8.48**	3920-16X22SS
18.00	**2.50**	22.00 X 1.50	24	21.4*	**4.66**	3920-18X24	**8.55**	3920-18X24SS
20.00	**2.50**	26.00 X 1.50	27	25.4*	**5.47**	3920-20X26	**10.03**	3920-20X26SS
22.00	**2.50**	26.00 X 1.50	30	25.4*	**6.25**	3920-22X30	**11.46**	3920-22X30SS
24.00	**3.00**	30.00 X 1.50	30	29.4*	**7.18**	3920-24X30	**13.17**	3920-24X30SS

SPARK PLUG



MM	MM	MM X MM	MM	MM	$	PART #	$	PART #
14.00	**1.25**	17.70 X 1.25	9	17.4*	**2.47**	3922-14X9	**4.29**	3922-14X9SS
14.00	**1.25**	17.70 X 1.25	15	17.4*	**3.31**	3922-14X15	**5.99**	3922-14X15SS

UNC



INCH	TPI	MM X MM	MM	MM	$	PART #	$	PART #
4G	**40**	5.00 X 0.50	6	4.8*	**0.46**	3932-4GX6	**0.85**	3932-4GX6SS
6G	**32**	6.00 X 0.75	8	5.7*	**0.61**	3932-6GX8	**1.11**	3932-6GX8SS
8G	**32**	6.50 X 0.75	8	6.2*	**0.79**	3932-8GX8	**1.45**	3932-8GX8SS
10G	**24**	8.00 X 1.00	10	7.6*	**0.92**	3932-10GX10	**1.69**	3932-10GX10SS
1/4	**20**	10.00 X 1.50	14	9.4*	**1.11**	3932-1/4X14	**2.14**	3932-1/4X14SS
5/16	**18**	12.00 X 1.50	15	11.4*	**1.45**	3932-5/16X15	**2.85**	3932-5/16X15SS
3/8	**16**	14.00 X 1.50	18	13.4*	**2.05**	3932-3/8X18	**4.07**	3932-3/8X18SS
7/16	**14**	16.00 X 1.50	22	15.4*	**3.01**	3932-7/16X22	**5.92**	3932-7/16X22SS
1/2	**13**	18.00 X 1.50	22	17.4*	**3.79**	3932-1/2X22	**7.90**	3932-1/2X22SS
5/8	**11**	20.00 X 1.50	22	19.4*	**4.32**	3932-5/8X22	**7.91**	3932-5/8X22SS

UNF

INCH	TPI	MM X MM	MM	MM	$	PART #	$	PART #
10G	**32**	8.00 X 1.00	10	7.6*	**0.92**	3934-10GX10	**1.69**	3934-10GX10SS
1/4	**28**	10.00 X 1.50	14	9.4*	**1.11**	3934-1/4X14	**2.14**	3934-1/4X14SS
5/16	**24**	12.00 X 1.50	15	11.4*	**1.45**	3934-5/16X15	**2.85**	3934-5/16X15SS
3/8	**24**	14.00 X 1.50	18	13.4*	**2.05**	3934-3/8X18	**4.07**	3934-3/8X18SS
7/16	**20**	16.00 X 1.50	22	15.4*	**3.01**	3934-7/16X22	**5.92**	3934-7/16X22SS
1/2	**20**	18.00 X 1.50	22	17.4*	**3.79**	3934-1/2X22	**7.90**	3934-1/2X22SS
5/8	**18**	20.00 X 1.50	22	19.4*	**4.32**	3934-5/8X22	**7.91**	3934-5/8X22SS

Nes®


MINI KIT 1044
U.S. pat. No. 6,544,127
Patented in other countries
& PAT. PEND.
INTERNAL
1
2
3
For internal aluminium threads plastic pads must be used.
See details and replacing instructions on www.threadmate.com

BORDO INDUSTRIAL TOOLS

NES Threadmate

ThreadMate Kits are an economical option for internal M5 - M12 external M4 - M13 and are ideal for:

- Outdoor technicians
- Maintenance
- Workshops
- Garages
- Marine Repairs
- Agricultural Repairs
- Motorcycles
- Bicycles

NES Threadmate tools are also available individually in convenient clam shell hang packs.

Spare blades are available in 60º, which are supplied as standard, and also 55º to suit BSW and BSF thread forms.

Threadmate kits include replaceable nylon pads to protect thread crests when restoring threads in soft metals and alloys.

GROUP	NESR
THREAD TYPE	EXTERNAL
THREAD ANGLE	60º
THREAD RANGE	**4-13MM (5/32-1/2")**

THREADMATE

MIN MAX MM	MIN MAX INCH		$	PART #
4.00–13.00	**5/32–1/2**		**59.26**	3507-06040

GROUP	NESR
THREAD TYPE	INTERNAL & EXTERNAL
THREAD ANGLE	60º
INTERNAL THREAD RANGE	**5-12MM (12G-1/2")**
EXTERNAL THREAD RANGE	**4-13MM (5/32-1/2")**

THREADMATE KIT

MIN MAX MM	MIN MAX INCH	MIN MAX MM	MIN MAX INCH	$	PART #
4.00–13.00	**5/32–1/2**	**5.00–12.00**	**12G–1/2**	**259.41**	3507-01044

PART #	QTY	MM	INCH
3507-06040	1	4 – 13	5/32 – 1/2
TM20	1	5 – 8	12G – 5/16
TM21	1	8 – 12	5/16 – 7/16
3507-07207	4	–	–
3507-07217	4	–	–

GROUP	NESR
THREAD TYPE	INTERNAL & EXTERNAL
THREAD ANGLE	60º
INTERNAL THREAD RANGE	**5-12MM (12G-1/2")**
EXTERNAL THREAD RANGE	**4-13MM (5/32-1/2")**

THREADMATE KIT MERCHANDISER

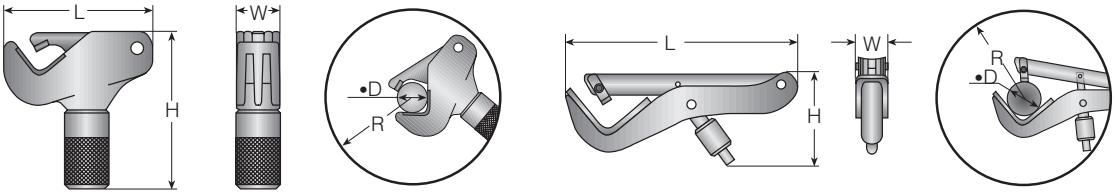
MIN MAX MM	MIN MAX INCH	MIN MAX MM	MIN MAX INCH	QTY	$	PART #
4.00–13.00	**5/32–1/2**	**5.00–12.00**	**12G–1/2**	5	**1297.05**	3507-D1

GROUP	NESR

THREADMATE

EXTERNAL	INTERNAL	$	PART #	$	PART #
–	TM20 NYLON PADS (5)	**8.96**	3507-07207	–	–
–	TM21 NYLON PADS (5)	**12.81**	3507-07217	–	–
–	60º BLADES	–	–	**18.30**	3507-06046
–	55º BLADES	–	–	**18.30**	3507-06045

GROUP	NESR
THREAD TYPE	EXTERNAL
THREAD ANGLE	60º

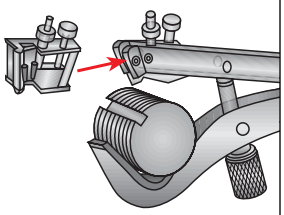


EXTERNAL

	MIN MAX	MIN MAX	MIN MAX						
	MM	INCH	PIPE	$	PART #	L	W	H	R
NES 1A	4.00 – 18.00	5/32 – 11/16	up to 7/16"	**117.22**	3507-NES1A	61	23	62	68
NES 2	17.00 – 38.00	11/16 – 1-1/2	3/8" to 1-1/8"	**170.85**	3507-NES2	105	32	110	117
NES 3	32.00 – 152.00	1-1/4 – 6	1" to 5-1/2"	**392.79**	3507-NES3	305	44	130	250

KEYWAY SKIP ADAPTOR

SUITS		$	PART #
NES 3	PITCH ≥ 1.75MM OR 14TPI	**118.72**	3507-03101
NES 3	PITCH < 1.75MM OR 14TPI	**203.60**	3507-03103



REPLACEMENT BLADES

		60º		55º	
SUITS		$	PART #	$	PART #
NES 1A	ALL PITCHES	**44.17**	3507-00010	**44.17**	3507-00020
NES 2	PITCH ≥ 1.5MM OR 17TPI	**60.00**	3507-00030	**60.00**	3507-00040
NES 2	PITCH < 1.5MM OR 17TPI	**60.00**	3507-00031F	**60.00**	3507-00041F
NES 3	1.75MM 14TPI ≤ PITCH ≤ 3.5MM 7TPI	**84.87**	3507-03010	**84.87**	3507-03020
NES 3	PITCH > 3.5MM OR 7TPI	**84.87**	3507-03011C	**84.87**	3507-03021C
NES 3	PITCH < 1.75MM OR 14TPI	**84.87**	3507-03010F	–	–

BORDO® INDUSTRIAL TOOLS

Features and Benefits of NES Adjustable Thread Restoring Tools and Kits

One tool restores Metric, Imperial, Right Hand and Left Hand threads and replaces many taps and/or dies.

Does not require calibration.

Self adjusting to any size and pitch within tool range.

Hardened HSS cutting blades for long service life.

Tool uses undamaged section of thread to guide cutting blades during repair to damaged areas.

Removes rust and burrs.

Quick to set up and simple to use.

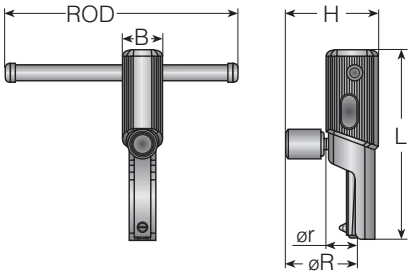
Spare cutting blades are available in 60º and 55º flank angles.

Repairs a wide range of sizes Internal 8mm to 108mm External 4mm to 152mm

Nylon Pads

Nylon pads are available for NES 21 through to NES 24 internal tools and are to be used during the repair of threads in aluminium and other soft metals. NES Nylon Pads are produced from top quality polyamide resins which provide superior toughness, resilience and outstanding mechanical properties over a wide range of operating environments.

GROUP	NESR
THREAD TYPE	INTERNAL
THREAD ANGLE	60°



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INTERNAL

	MIN MAX	MIN MAX								
	MM	INCH	$	PART #	L	B	H	ROD	ø r	ø R
NES 21	8.00 – 11.00	5/16 – 7/16	**129.49**	3507-NES21	109	18	45	136	16	38
NES 22	12.00 – 16.00	1/2 – 5/8	**129.49**	3507-NES22	109	18	45	136	17	39
NES 23	16.00 – 20.00	11/16 – 13/16	**141.26**	3507-NES23	111	21	53	146	20	45
NES 24	22.00 – 32.00	7/8 – 1-1/4	**188.38**	3507-NES24	136	27	64	161	27	54
NES 25	32.00 – 54.00	1-1/4 – 2-1/8	**329.77**	3507-NES25	163	38	81	192	35	62
NES 26	32.00 – 68.00	1-1/4 – 2-5/8	**471.16**	3507-NES26	163	50	92	192	41	70
NES 27	69.00 – 81.00	2-3/4 – 3-3/16	**613.41**	3507-NES27	163	50	103	192	48	76
NES 28	82.00 – 95.00	3-1/4 – 3-3/4	**757.55**	3507-NES28	163	50	118	192	54	82
NES 29	96.00 – 108.00	3-3/4 – 4-1/4	**894.47**	3507-NES29	163	50	132	192	61	88

ACCESSORIES

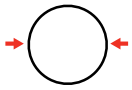
	MIN MAX					
SUITS	NEW TOOL SIZE RANGE	QTY	$	PART #	$	PART #
NES 21	9-11MM, 3/8-1/2"	5	**12.81**	3507-07217	–	–
NES 22	14-18MM, 9/16-11/16"	5	**12.81**	3507-07227	–	–
NES 23	18-22MM, 11/16-7/8"	5	**14.39**	3507-07237	–	–
NES 24	22-33MM, 7/8-1-5/16"	5	**15.41**	3507-07247	–	–
NES 25	68MM, 2-5/8"	1	–	–	**118.72**	3507-07269

REPLACEMENT BLADES

		60°		55°	
SUITS		$	PART #	$	PART #
NES 21	ALL PITCHES	**31.17**	3507-07216	**31.17**	3507-07215
NES 22	ALL PITCHES	**28.33**	3507-07226	**28.33**	3507-07225
NES 23	ALL PITCHES	**29.28**	3507-07236	**29.28**	3507-07235
NES 24	PITCH ≤ 2.5MM OR 10TPI	**30.87**	3507-07246F	**30.87**	3507-07245F
NES 24	PITCH > 2.5MM OR 10TPI	**30.87**	3507-07246C	**30.87**	3507-07245C
NES 25	PITCH ≤ 1.75MM OR 14TPI	**35.61**	3507-07256	**35.61**	3507-07255
NES 25	PITCH < 1.75MM OR 14TPI	**35.64**	3507-07256F	**35.64**	3507-07255F
NES 26	1.75MM 14TPI ≤ PITCH ≤ 3.5MM 7TPI	**38.09**	3507-07266	**35.61**	3507-07265
NES 26	PITCH < 1.75MM OR 14TPI	**38.09**	3507-07266F	**35.61**	3507-07265F
NES 26	PITCH > 3.5MM OR 7TPI	–	–	**35.61**	3507-07265C

GROUP	NESR
THREAD TYPE	INTERNAL & EXTERNAL
THREAD ANGLE	60°

MERCHANDISER

				
	$	PART #	PART #	PART #
NES HANG SELL MERCHANDISER	**935.95**	3507-D2	3507-NES21	3507-06040
			3507-NES22	3507-NES1A
			3507-NES23	3507-NES2
			3507-NES24	–

BORDO® INDUSTRIAL TOOLS

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Repairs a wide range of sizes Internal 8mm to 108mm External 4mm to 152mm.

GROUP	NESR
THREAD TYPE	INTERNAL
THREAD ANGLE	60°
INTERNAL THREAD RANGE	**8 – 32MM (5/16 – 1-1/4")**

INTERNAL KIT

	$	PART #	PART #	QTY	MM (MIN MAX)	INCH (MIN MAX)
SET 1008	**586.89**	3507-01008	3507-NES21	1	8.00 – 11.00	5/16 – 7/16
			3507-NES22	1	12.00 – 16.00	1/2 – 5/8
			3507-NES23	1	16.00 – 20.00	11/16 – 13/16
			3507-NES24	1	22.00 – 32.00	7/8 – 1-1/4
			3507-07216	1	–	–
			3507-07226	1	–	–
			3507-07236	1	–	–
			3507-07246F	1	–	–

GROUP	NESR
THREAD TYPE	INTERNAL & EXTERNAL
THREAD ANGLE	60°
INTERNAL THREAD RANGE	**8 – 32MM (5/16 – 1-1/4")**
EXTERNAL THREAD RANGE	**4 – 38MM (5/32 – 1-1/2")**

COMBINATION KIT

	$	PART #	PART #	QTY	MM (MIN MAX)	INCH (MIN MAX)	MM (MIN MAX)	INCH (MIN MAX)
SET 1025	**898.51**	3507-01025	3507-NES1A	1	–	–	4.00 – 18.00	5/32 – 11/16
			3507-NES2	1	–	–	17.00 – 38.00	11/16 – 1-1/2
			3507-NES21	1	8.00 – 11.00	5/16 – 7/16	–	–
			3507-NES22	1	12.00 – 16.00	1/2 – 5/8	–	–
			3507-NES23	1	16.00 – 20.00	11/16 – 13/16	–	–
			3507-NES24	1	22.00 – 32.00	7/8 – 1-1/4	–	–
			3507-00010	1	–	–	–	–
			3507-00030	1	–	–	–	–
			3507-07216	1	–	–	–	–
			3507-07226	1	–	–	–	–
			3507-07236	1	–	–	–	–
			3507-07246F	1	–	–	–	–

GROUP	NESR
THREAD TYPE	EXTERNAL
THREAD ANGLE	60°
THREAD RANGE	**4 – 38MM (5/32 – 1-1/2")**

EXTERNAL KIT

	Nes®				MIN MAX	MIN MAX
	$	PART #	PART #	QTY	MM	INCH
SET 12	**321.23**	3507-01000	3507-NES1A	1	4.00 – 18.00	5/32 – 11/16
			3507-NES2	1	17.00 – 38.00	11/16 – 1-1/2
			3507-00010	1	–	–
			3507-00030	1	–	–

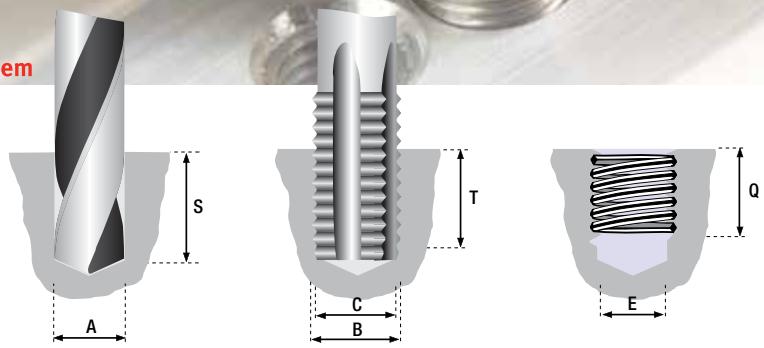
GROUP	NESR
THREAD TYPE	EXTERNAL
THREAD ANGLE	60°
THREAD RANGE	**4 – 152MM (5/32 – 6")**

EXTERNAL KIT

	Nes®				MIN MAX	MIN MAX
	$	PART #	PART #	QTY	MM	INCH
SET 123	**788.74**	3507-01300	3507-NES1A	1	4.00 – 18.00	5/32 – 11/16
			3507-NES2	1	17.00 – 38.00	11/16 – 1-1/2
			3507-NES3	1	32.00 – 152.00	1-1/4 – 6
			3507-00010	1	–	–
			3507-00030	1	–	–
			3507-03010	1	–	–
			CLEANER	1	–	–
			EXTENSION HANDLE	1	–	–

powercoil® wire thread insert system

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.



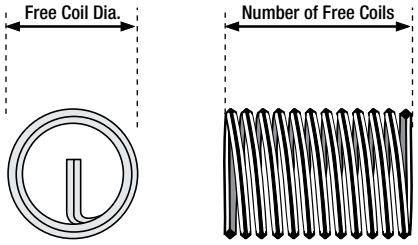
Nominal Thread Size	DRILLED HOLE DIMENSIONS									Nominal Thread Size	TAPPED HOLE DIMENSIONS									E Fitted Minor Dia.
	Drill				S Min. Drilling Depth Inter/Plug Tap						B Major Dia.	C Pitch Diameter			T Minimum Tapping Depth					
	Size		A Minor Dia.		1D	1.5D	2D	2.5D	3D			Min	5H Max	6H Max	1D	1.5D	2D	2.5D	3D	
	mm	inch	mm	mm	mm	mm	mm	mm	mm		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
METRIC										**METRIC**										
M2 X 0.40	2.10	#45	2.087	2.177	3.80	4.80	5.80	6.80	7.80	**M2 X 0.40**	2.520	2.260	2.296	2.311	3.40	4.40	5.40	6.40	7.40	1.567
M2.2 X 0.45	2.30	#42	2.297	2.397	4.23	5.33	6.43	7.53	8.63	**M2.2 X 0.45**	2.785	2.492	2.532	2.547	3.78	4.88	5.98	7.08	8.18	1.713
M2.5 X 0.45	2.60	#37	2.597	2.697	4.53	5.78	7.03	8.28	9.53	**M2.5 X 0.45**	3.085	2.792	2.832	2.847	4.08	5.33	6.58	7.83	9.08	2.013
M3 X 0.50	3.20	1/8	3.108	3.220	5.25	6.75	8.25	9.75	11.25	**M3 X 0.50**	3.650	3.325	3.367	3.384	4.75	6.25	7.75	9.25	10.75	2.459
M3.5 X 0.60	3.70	#27	3.630	3.755	6.20	7.95	9.70	11.45	13.20	**M3.5 X 0.60**	4.279	3.890	3.940	3.959	5.60	7.35	9.10	10.85	12.60	2.850
M4 x 0.70	4.20	11/64	4.152	4.292	7.15	9.15	11.15	13.15	15.15	**M4 x 0.70**	4.909	4.455	4.509	4.529	6.45	8.45	10.45	12.45	14.45	3.242
M5 X 0.80	5.20	13/64	5.173	5.333	8.60	11.10	13.60	16.10	18.60	**M5 X 0.80**	6.039	5.520	5.577	5.597	7.80	10.30	12.80	15.30	17.80	4.134
M6 X 1.00	6.30	1/4	6.216	6.406	10.50	13.50	16.50	19.50	22.50	**M6 X 1.00**	7.299	6.650	6.719	6.742	9.50	12.50	15.50	18.50	21.50	4.917
M7 X 1.00	7.30	9/32	7.216	7.406	11.50	15.00	18.50	22.00	25.50	**M7 X 1.00**	8.299	7.650	7.719	7.742	10.50	14.00	17.50	21.00	24.50	5.917
M8 X 1.25	8.30	21/64	8.271	8.483	13.63	17.63	21.63	25.63	29.63	**M8 X 1.25**	9.624	8.812	8.886	8.912	12.38	16.38	20.38	24.38	28.38	6.647
M8 X 1.00	8.30	21/64	8.216	8.406	12.50	16.50	20.50	24.50	28.50	**M8 X 1.00**	9.299	8.650	8.719	8.742	11.50	15.50	19.50	23.50	27.50	6.917
M9 X 1.25	9.40	3/8	9.271	9.483	14.63	19.13	23.63	28.13	32.63	**M9 X 1.25**	10.624	9.812	9.886	9.912	13.38	17.88	22.38	26.88	31.38	7.647
M9 x 1.00	9.30	23/64	9.216	9.406	13.50	18.00	22.50	27.00	31.50	**M9 x 1.00**	10.299	9.650	9.719	9.742	12.50	17.00	21.50	26.00	30.50	7.917
M10 X 1.50	10.40	13/32	10.325	10.561	16.75	21.75	26.75	31.75	36.75	**M10 X 1.50**	11.949	10.974	11.061	11.089	15.25	20.25	25.25	30.25	35.25	8.376
M10 X 1.25	10.30	13/32	10.271	10.483	15.63	20.63	25.63	30.63	35.63	**M10 X 1.25**	11.624	10.812	10.886	10.912	14.38	19.38	24.38	29.38	34.38	8.647
M10 x 1.00	10.30	13/32	10.216	10.406	14.50	19.50	24.50	29.50	34.50	**M10 x 1.00**	11.299	10.650	10.724	10.742	13.50	18.50	23.50	28.50	33.50	8.917
M11 X 1.50	11.40	7/16	11.325	11.561	17.75	23.25	28.75	34.25	39.75	**M11 X 1.50**	12.949	11.974	12.061	12.089	16.25	21.75	27.25	32.75	38.25	9.376
M11 X 1.25	11.30	7/16	11.271	11.483	16.63	22.13	27.63	33.13	38.63	**M11 X 1.25**	12.624	11.812	11.898	11.926	15.38	20.88	26.38	31.88	37.38	9.647
M11 X 1.00	11.30	7/16	11.216	11.406	15.50	21.00	26.50	32.00	37.50	**M11 X 1.00**	12.299	11.650	11.724	11.742	14.50	20.00	25.50	31.00	36.50	9.917
M12 X 1.75	12.50	31/64	12.379	12.644	19.88	25.88	31.88	37.88	43.88	**M12 X 1.75**	14.273	13.137	13.236	13.271	18.13	24.13	30.13	36.13	42.13	10.106
M12 X 1.50	12.40	31/64	12.325	12.561	18.75	24.75	30.75	36.75	42.75	**M12 X 1.50**	13.949	12.974	13.067	13.099	17.25	23.25	29.25	35.25	41.25	10.376
M12 X 1.25	12.30	31/64	12.271	12.483	17.63	23.63	29.63	35.63	41.63	**M12 X 1.25**	13.624	12.812	12.898	12.926	16.38	22.38	28.38	34.38	40.38	10.647
M12 X 1.00	12.30	31/64	12.216	12.406	16.50	22.50	28.50	34.50	40.50	**M12 X 1.00**	13.299	12.649	12.724	12.749	15.50	21.50	27.50	33.50	39.50	10.917
M13 X 1.75	13.50	33/64	13.379	13.644	20.88	27.38	33.88	40.38	46.88	**M13 X 1.75**	15.273	14.137	14.236	14.271	19.13	25.63	32.13	38.63	45.13	11.106
M13 X 1.50	13.20	33/64	13.325	13.561	19.75	26.25	32.75	39.25	45.75	**M13 X 1.50**	14.949	13.974	14.067	14.099	18.25	24.75	31.25	37.75	44.25	11.376
M13 X 1.25	13.20	33/64	13.271	13.483	18.63	25.13	31.63	38.13	44.63	**M13 X 1.25**	14.624	13.812	13.898	13.926	17.38	23.88	30.38	36.88	43.38	11.647
M14 X 2.00	14.50	37/64	14.433	14.733	23.00	30.00	37.00	44.00	51.00	**M14 X 2.00**	16.598	15.299	15.406	15.444	21.00	28.00	35.00	42.00	49.00	11.835
M14 X 1.50	14.40	9/16	14.325	14.561	20.75	27.75	34.75	41.75	48.75	**M14 X 1.50**	15.949	14.974	15.067	15.099	19.25	26.25	33.25	40.25	47.25	12.376
M14 X 1.25	14.30	9/16	14.271	14.483	19.63	26.63	33.63	40.63	47.63	**M14 X 1.25**	15.624	14.812	14.898	14.926	18.38	25.38	32.38	39.38	46.38	12.674
M14 X 1.00	14.30	9/16	14.216	14.406	18.50	25.50	32.50	39.50	46.50	**M14 X 1.00**	15.299	14.649	14.724	14.749	17.50	24.50	31.50	38.50	45.50	12.917
M15 X 2.00	15.50	39/64	15.433	15.733	24.00	31.50	39.00	46.50	54.00	**M15 X 2.00**	17.598	16.299	16.406	16.444	22.00	29.50	37.00	44.50	52.00	12.835
M15 X 1.50	15.30	39/64	15.325	15.561	21.75	29.25	36.75	44.25	51.75	**M15 X 1.50**	16.949	15.974	16.067	16.099	20.25	27.75	35.25	42.75	50.25	13.376
M16 X 2.00	16.50	21/32	16.433	16.733	25.00	33.00	41.00	49.00	57.00	**M16 X 2.00**	18.598	17.299	17.406	17.444	23.00	31.00	39.00	47.00	55.00	13.835
M16 X 1.50	16.50	21/32	16.325	16.561	22.75	30.75	38.75	46.75	54.75	**M16 X 1.50**	17.949	16.974	17.067	17.099	21.25	29.25	37.25	45.25	53.25	14.376
M18 X 2.50	18.80	47/64	18.541	18.896	29.25	38.25	47.25	56.25	65.25	**M18 X 2.50**	21.248	19.624	19.738	19.778	26.75	35.75	44.75	53.75	62.75	15.294
M18 X 2.00	18.50	23/32	18.433	18.733	27.00	36.00	45.00	54.00	63.00	**M18 X 2.00**	20.598	19.299	19.406	19.444	25.00	34.00	43.00	52.00	61.00	15.835
M18 X 1.50	18.50	23/32	18.325	18.561	24.75	33.75	42.75	51.75	60.75	**M18 X 1.50**	19.949	18.974	19.067	19.099	23.25	32.25	41.25	50.25	59.25	16.376
M20 X 2.50	20.80	13/16	20.541	20.896	31.25	41.25	51.25	61.25	71.25	**M20 X 2.50**	23.248	21.624	21.738	21.778	28.75	38.75	48.75	58.75	68.75	17.294
M20 X 2.00	20.50	13/16	20.433	20.733	29.00	39.00	49.00	59.00	69.00	**M20 X 2.00**	22.598	21.299	21.406	21.444	27.00	37.00	47.00	57.00	67.00	17.835
M20 X 1.50	20.50	13/16	20.325	20.561	26.75	36.75	46.75	56.75	66.75	**M20 X 1.50**	21.949	20.974	21.067	21.099	25.25	35.25	45.25	55.25	65.25	18.376
M22 X 2.50	22.80	57/64	22.541	22.896	33.25	44.25	55.25	66.25	77.25	**M22 X 2.50**	25.248	23.624	23.738	23.778	30.75	41.75	52.75	63.75	74.75	19.294
M22 X 2.00	22.50	57/64	22.433	22.733	31.00	42.00	53.00	64.00	75.00	**M22 X 2.00**	24.598	23.299	23.406	23.444	29.00	40.00	51.00	62.00	73.00	19.835
M22 X 1.50	22.50	57/64	22.325	22.561	28.75	39.75	50.75	61.75	72.75	**M22 X 1.50**	23.949	22.974	23.067	23.099	27.25	38.25	49.25	60.25	71.25	20.376
M24 X 3.00	25.00	31/32	24.650	25.050	37.50	49.50	61.50	73.50	85.50	**M24 X 3.00**	27.897	25.948	26.093	26.135	34.50	46.50	58.50	70.50	82.50	20.752
M24 X 2.00	24.50	31/32	24.433	24.733	33.00	45.00	57.00	69.00	81.00	**M24 X 2.00**	26.598	25.299	25.414	25.454	31.00	43.00	55.00	67.00	79.00	21.835
M24 X 1.50	24.50	31/32	24.325	24.561	30.75	42.75	54.75	66.75	78.75	**M24 X 1.50**	25.949	24.975	25.044	25.135	29.25	41.25	53.25	65.25	77.25	22.376
M26 X 1.50	26.50	1.1/32	26.325	26.561	32.75	45.75	58.75	71.75	84.75	**M26 X 1.50**	27.949	26.975	27.044	27.135	31.25	44.25	57.25	70.25	83.25	24.376
M27 X 3.00	28.00	1.3/32	27.650	28.050	40.50	54.00	67.50	81.00	94.50	**M27 X 3.00**	30.897	28.498	29.093	29.135	37.50	51.00	64.50	78.00	91.50	23.752
M27 X 2.00	27.50	1.5/64	27.433	27.733	36.00	49.50	63.00	76.50	90.00	**M27 X 2.00**	29.598	28.299	28.414	28.454	34.00	47.50	61.00	74.50	88.00	24.835
M30 X 3.50	31.00	1.7/32	30.758	31.208	45.75	60.75	75.75	90.75	105.75	**M30 X 3.50**	34.547	32.273	32.428	32.472	42.25	57.25	72.25	87.25	102.25	26.211
M30 X 3.00	31.00	1.7/32	30.650	31.050	43.50	58.50	73.50	88.50	103.50	**M30 X 3.00**	33.897	31.948	32.093	32.135	40.50	55.50	70.50	85.50	100.50	26.752
M30 X 2.00	30.50	1.3/16	30.433	30.733	39.00	54.00	69.00	84.00	99.00	**M30 X 2.00**	32.598	31.299	31.414	31.454	37.00	52.00	67.00	82.00	97.00	27.835
M33 X 3.50	34.00	1.21/64	33.758	34.208	48.75	65.25	81.75	98.25	114.75	**M33 X 3.50**	37.547	35.273	35.428	35.472	45.25	61.75	78.25	94.75	111.25	29.211
M33 X 3.00	33.50	1.5/16	33.650	34.050	46.50	63.00	79.50	96.00	112.50	**M33 X 3.00**	36.897	34.948	35.093	35.135	43.50	60.00	76.50	93.00	109.50	29.752
M33 X 2.00	33.50	1.5/16	33.433	33.733	42.00	58.50	75.00	91.50	108.00	**M33 X 2.00**	35.598	34.299	34.414	34.454	40.00	56.50	73.00	89.50	106.00	30.835
M36 X 4.00	37.00	1.29/64	36.866	37.341	54.00	72.00	90.00	108.00	126.00	**M36 X 4.00**	41.196	38.598	38.763	38.809	50.00	68.00	86.00	104.00	122.00	31.670
M36 X 3.00	37.00	1.29/64	36.650	37.050	49.50	67.50	85.50	103.50	121.50	**M36 X 3.00**	39.897	37.948	38.093	38.135	46.50	64.50	82.50	100.50	118.50	32.752
M39 X 4.00	40.00	1.9/16	39.866	40.341	57.00	76.50	96.00	115.50	135.00	**M39 X 4.00**	44.196	41.598	41.763	41.809	53.00	72.50	92.00	111.50	131.00	34.670
M42 X 4.50	43.00	1.11/16	42.975	43.505	62.25	83.25	104.25	125.25	146.25	**M42 X 4.50**	47.846	44.923	45.098	45.147	57.75	78.75	99.75	120.75	141.75	37.129
M42 X 3.00	42.50	1.11/16	42.650	43.050	55.50	76.50	97.50	118.50	139.50	**M42 X 3.00**	45.897	43.948	44.093	44.135	52.50	73.50	94.50	115.50	136.50	38.752

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 listed below are adhered to.

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.

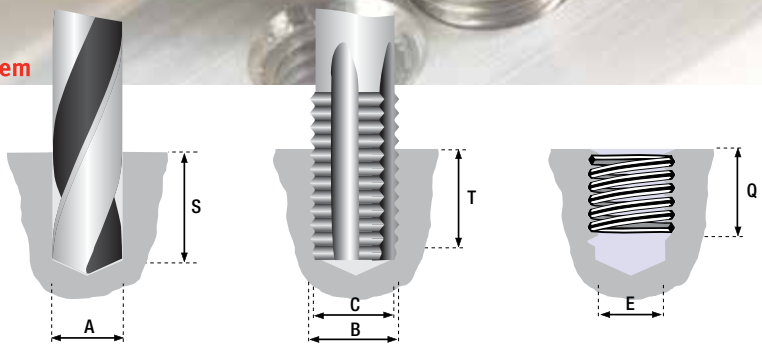
PowerCoil wire thread inserts can be manufactured to different standards upon request. Technical data on these standards can be obtained from our website – www.powercoil.com.au.



Nominal Thread Size	INSERT SPECIFICATIONS																		Nominal Thread Size
	Q Nominal Length – installed					Free Coil Diameter		Number of Free Coils ± 1/4 coil counted 90° from Tang											
	1D	1.5D	2D	2.5D	3D	Min	Max	1D		1.5D		2D		2.5D		3D			
	mm	mm	mm	mm	mm	mm	mm	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
METRIC																			**METRIC**
M2 X 0.40	2.00	3.00	4.00	5.00	6.00	2.49	2.70	3.00	3.30	5.20	5.70	7.40	8.10	9.60	10.50	11.80	13.00		**M2 X 0.40**
M2.2 X 0.45	2.20	3.30	4.40	5.50	6.60	2.76	3.00	2.90	3.20	5.00	5.50	7.10	7.90	9.30	10.30	11.40	12.60		**M2.2 X 0.45**
M2.5 X 0.45	2.50	3.75	5.00	6.25	7.50	3.05	3.70	3.10	3.80	5.20	6.50	7.40	9.20	9.50	11.90	11.70	14.60		**M2.5 X 0.45**
M3 X 0.50	3.00	4.50	6.00	7.50	9.00	3.61	4.35	3.40	4.30	5.80	7.20	8.20	10.10	10.50	13.10	12.90	16.00		**M3 X 0.50**
M3.5 X 0.60	3.50	5.25	7.00	8.75	10.50	4.24	4.95	3.40	4.10	5.80	7.00	8.20	9.80	10.50	12.60	12.90	15.50		**M3.5 X 0.60**
M4 x 0.70	4.00	6.00	8.00	10.00	12.00	4.86	5.60	3.40	4.00	5.70	6.80	8.10	9.60	10.50	12.30	12.80	15.10		**M4 x 0.70**
M5 X 0.80	5.00	7.50	10.00	12.50	15.00	5.98	6.80	3.90	4.50	6.50	7.60	9.20	10.60	11.80	13.70	14.40	16.70		**M5 X 0.80**
M6 X 1.00	6.00	9.00	12.00	15.00	18.00	7.23	7.95	3.80	4.30	6.40	7.20	9.10	10.10	11.70	13.10	14.30	16.00		**M6 X 1.00**
M7 X 1.00	7.00	10.50	14.00	17.50	21.00	8.22	9.20	4.60	5.30	7.70	8.70	10.70	12.10	13.70	15.60	16.70	19.00		**M7 X 1.00**
M8 X 1.25	8.00	12.00	16.00	20.00	24.00	9.53	10.35	4.20	4.70	7.10	7.80	9.90	10.90	12.80	14.10	15.60	17.20		**M8 X 1.25**
M8 X 1.00	8.00	12.00	16.00	20.00	24.00	9.39	10.25	5.60	6.10	9.10	10.00	12.50	13.80	16.00	17.70	19.50	21.50		**M8 X 1.00**
M9 X 1.25	9.00	13.50	18.00	22.50	27.00	10.52	11.16	5.10	5.50	8.40	9.00	11.70	12.50	15.00	16.10	18.30	19.60		**M9 X 1.25**
M9 x 1.00	9.00	13.50	18.00	22.50	27.00	10.40	11.23	6.50	7.10	10.50	11.50	14.50	15.80	18.50	20.20	22.50	24.50		**M9 x 1.00**
M10 X 1.50	10.00	15.00	20.00	25.00	30.00	11.83	12.50	4.60	4.90	7.70	8.20	10.80	11.50	13.80	14.70	16.90	18.00		**M10 X 1.50**
M10 X 1.25	10.00	15.00	20.00	25.00	30.00	11.74	12.65	5.60	6.10	9.20	10.00	12.70	13.80	16.30	17.70	19.80	21.50		**M10 X 1.25**
M10 x 1.00	10.00	15.00	20.00	25.00	30.00	11.41	12.50	7.30	8.10	11.70	12.90	16.10	17.80	20.50	22.60	24.90	27.50		**M10 x 1.00**
M11 X 1.50	11.00	16.50	22.00	27.50	33.00	12.82	13.59	5.20	5.60	8.60	9.20	12.00	12.80	15.40	16.40	18.70	20.00		**M11 X 1.50**
M11 X 1.25	11.00	16.50	22.00	27.50	33.00	12.75	13.76	6.40	6.90	10.30	11.20	14.20	15.40	18.10	19.70	22.00	23.90		**M11 X 1.25**
M11 X 1.00	11.00	16.50	22.00	27.50	33.00	12.42	13.41	8.40	9.10	13.30	14.40	18.20	19.80	23.10	25.10	28.00	30.40		**M11 X 1.00**
M12 X 1.75	12.00	18.00	24.00	30.00	36.00	14.13	15.00	4.80	5.10	7.90	8.50	11.10	11.90	14.20	15.20	17.30	18.60		**M12 X 1.75**
M12 X 1.50	12.00	18.00	24.00	30.00	36.00	14.09	15.20	5.60	6.10	9.20	10.00	12.70	13.80	16.20	17.70	19.80	21.50		**M12 X 1.50**
M12 X 1.25	12.00	18.00	24.00	30.00	36.00	13.76	15.00	7.00	7.70	11.20	12.40	15.50	17.00	19.70	21.60	23.90	26.30		**M12 X 1.25**
M12 X 1.00	12.00	18.00	24.00	30.00	36.00	13.43	14.49	9.30	10.10	14.70	15.90	20.00	21.70	25.40	27.60	30.80	33.40		**M12 X 1.00**
M13 X 1.75	13.00	19.50	26.00	32.50	39.00	15.12	16.04	5.30	5.70	8.70	9.40	12.20	13.00	15.60	16.70	19.00	20.30		**M13 X 1.75**
M13 X 1.50	13.00	19.50	26.00	32.50	39.00	15.10	16.29	6.20	6.80	10.10	11.00	13.90	15.20	17.80	19.30	21.60	23.50		**M13 X 1.50**
M13 X 1.25	13.00	19.50	26.00	32.50	39.00	14.77	15.94	7.80	8.50	12.50	13.50	17.10	18.60	21.70	23.60	26.40	28.70		**M13 X 1.25**
M14 X 2.00	14.00	21.00	28.00	35.00	42.00	16.43	17.35	5.00	5.30	8.20	8.70	11.40	12.10	14.60	15.60	17.90	19.00		**M14 X 2.00**
M14 X 1.50	14.00	21.00	28.00	35.00	42.00	16.11	17.25	6.90	7.50	11.10	12.00	15.30	16.50	19.40	21.00	23.60	25.50		**M14 X 1.50**
M14 X 1.25	14.00	21.00	28.00	35.00	42.00	15.78	17.03	8.60	9.30	13.60	14.70	18.60	20.20	23.60	25.60	28.60	31.00		**M14 X 1.25**
M14 X 1.00	14.00	21.00	28.00	35.00	42.00	15.45	16.68	11.10	12.10	17.40	18.90	23.70	25.70	30.00	32.50	36.20	39.30		**M14 X 1.00**
M15 X 2.00	15.00	22.50	30.00	37.50	45.00	17.42	18.48	5.40	5.80	8.80	9.50	12.30	13.10	15.70	16.80	19.20	20.50		**M15 X 2.00**
M15 X 1.50	15.00	22.50	30.00	37.50	45.00	17.12	18.47	7.50	8.10	11.90	12.90	16.40	17.80	20.80	22.60	25.30	27.50		**M15 X 1.50**
M16 X 2.00	16.00	24.00	32.00	40.00	48.00	18.41	19.60	5.90	6.30	9.50	10.20	13.20	14.20	16.90	18.10	20.50	22.00		**M16 X 2.00**
M16 X 1.50	16.00	24.00	32.00	40.00	48.00	18.13	19.60	8.00	8.80	12.80	13.90	17.50	19.10	22.30	24.30	27.00	29.40		**M16 X 1.50**
M18 X 2.50	18.00	27.00	36.00	45.00	54.00	21.04	22.00	5.20	5.50	8.60	9.00	11.90	12.50	15.30	16.10	18.60	19.60		**M18 X 2.50**
M18 X 2.00	18.00	27.00	36.00	45.00	54.00	20.80	21.85	6.70	7.10	10.90	11.50	15.00	15.80	19.10	20.20	23.20	24.50		**M18 X 2.00**
M18 X 1.50	18.00	27.00	36.00	45.00	54.00	20.15	21.75	9.30	10.10	14.60	15.90	20.00	21.70	25.40	27.60	30.70	33.40		**M18 X 1.50**
M20 X 2.50	20.00	30.00	40.00	50.00	60.00	23.02	24.40	5.90	6.30	9.60	10.20	13.30	14.20	16.90	18.10	20.60	22.00		**M20 X 2.50**
M20 X 2.00	20.00	30.00	40.00	50.00	60.00	22.82	24.05	7.70	8.10	12.20	12.90	16.80	17.80	21.40	22.60	25.90	27.50		**M20 X 2.00**
M20 X 1.50	20.00	30.00	40.00	50.00	60.00	22.17	24.00	10.50	11.40	16.40	17.90	22.40	24.40	28.30	30.90	34.30	37.40		**M20 X 1.50**
M22 X 2.50	22.00	33.00	44.00	55.00	66.00	25.00	26.90	6.50	7.10	10.50	11.40	14.50	15.80	18.50	20.10	22.50	24.50		**M22 X 2.50**
M22 X 2.00	22.00	33.00	44.00	55.00	66.00	24.84	26.50	8.50	9.10	13.40	14.40	18.40	19.80	23.40	25.10	28.40	30.40		**M22 X 2.00**
M22 X 1.50	22.00	33.00	44.00	55.00	66.00	24.19	26.45	11.60	12.70	18.10	19.90	24.60	27.00	31.10	34.20	37.60	41.30		**M22 X 1.50**
M24 X 3.00	24.00	36.00	48.00	60.00	72.00	27.62	29.00	5.90	6.30	9.70	10.20	13.40	14.20	17.10	18.10	20.90	22.00		**M24 X 3.00**
M24 X 2.00	24.00	36.00	48.00	60.00	72.00	26.86	29.10	9.20	10.10	14.60	15.90	19.90	21.70	25.30	27.60	30.60	33.40		**M24 X 2.00**
M24 X 1.50	24.00	36.00	48.00	60.00	72.00	26.21	28.28	12.90	14.00	20.10	21.80	27.30	29.70	34.50	37.50	41.70	45.30		**M24 X 1.50**
M26 X 1.50	26.00	39.00	52.00	65.00	78.00	28.23	30.46	14.20	15.40	22.00	23.80	29.80	32.30	37.60	40.80	45.40	49.20		**M26 X 1.50**
M27 X 3.00	27.00	40.50	54.00	67.50	81.00	30.59	32.40	6.80	7.30	11.00	11.70	15.20	16.20	19.30	20.60	23.50	25.10		**M27 X 3.00**
M27 X 2.00	27.00	40.50	54.00	67.50	81.00	29.89	32.30	10.60	11.60	16.70	18.10	22.70	24.70	28.80	31.30	34.80	37.90		**M27 X 2.00**
M30 X 3.50	30.00	45.00	60.00	75.00	90.00	34.20	35.81	6.50	6.90	10.50	11.10	14.50	15.30	18.60	19.50	22.60	23.80		**M30 X 3.50**
M30 X 3.00	30.00	45.00	60.00	75.00	90.00	34.24	36.10	7.60	8.10	12.20	12.90	16.80	17.80	21.30	22.60	25.90	27.50		**M30 X 3.00**
M30 X 2.00	30.00	45.00	60.00	75.00	90.00	32.92	35.70	12.00	13.00	18.70	20.40	25.40	27.70	32.10	35.00	38.80	42.30		**M30 X 2.00**
M33 X 3.50	33.00	49.50	66.00	82.50	99.00	37.17	38.80	7.40	7.70	11.80	12.40	16.20	17.00	20.70	21.70	25.10	26.40		**M33 X 3.50**
M33 X 3.00	33.00	49.50	66.00	82.50	99.00	37.27	39.50	8.50	9.10	13.50	14.40	18.50	19.80	23.60	25.10	28.60	30.40		**M33 X 3.00**
M33 X 2.00	33.00	49.50	66.00	82.50	99.00	35.95	39.20	13.30	14.50	20.60	22.60	28.00	30.60	35.30	38.70	42.70	46.80		**M33 X 2.00**
M36 X 4.00	36.00	54.00	72.00	90.00	108.00	40.78	42.67	6.90	7.30	11.20	11.70	15.40	16.20	19.60	20.60	23.80	25.10		**M36 X 4.00**
M36 X 3.00	36.00	54.00	72.00	90.00	108.00	40.30	42.70	9.50	10.10	14.90	15.90	20.40	21.70	25.90	27.60	31.40	33.40		**M36 X 3.00**
M39 X 4.00	39.00	58.50	78.00	97.50	117.00	43.75	45.75	7.70	8.00	12.20	12.90	16.80	17.70	21.40	22.50	26.00	27.30		**M39 X 4.00**
M42 X 4.50	42.00	63.00	84.00	105.00	126.00	47.37	49.00	7.30	7.60	11.80	12.20	16.20	16.80	20.70	21.50	25.10	26.10		**M42 X 4.50**
M42 X 3.00	42.00	63.00	84.00	105.00	126.00	46.36	49.00	11.40	12.10	17.80	18.90	24.20	25.70	30.60	32.50	37.10	39.30		**M42 X 3.00**

powercoil® wire thread insert system

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.



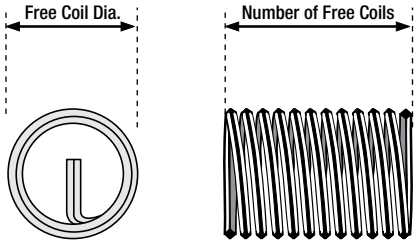
Nominal Thread Size	DRILLED HOLE DIMENSIONS									Nominal Thread Size	TAPPED HOLE DIMENSIONS									E Fitted Minor Dia.
	Drill				S Min. Drilling Depth Inter/Plug Tap						B Major Dia.	C Pitch Diameter			T Minimum Tapping Depth					
	Size		A Minor Dia.		1D	1.5D	2D	2.5D	3D			Min	2B Max	1B Max	1D	1.5D	2D	2.5D	3D	
	mm	inch	inch	inch	inch	inch	inch	inch	inch		inch	inch	inch	inch	inch	inch	inch	inch	inch	inch
UNC										**UNC**										
2 X 56	2.40	#41	0.090	0.094	0.166	0.209	0.252	0.295	0.338	**2 X 56**	0.109	0.098	0.099	0.100	0.148	0.191	0.234	0.277	0.320	0.0667
3 X 48	2.70	#36	0.104	0.108	0.193	0.242	0.292	0.341	0.391	**3 X 48**	0.126	0.113	0.114	0.115	0.172	0.221	0.271	0.320	0.370	0.0764
4 X 40	3.00	#31	0.117	0.122	0.224	0.280	0.336	0.392	0.448	**4 X 40**	0.145	0.128	0.130	0.131	0.199	0.255	0.311	0.367	0.423	0.0849
5 X 40	3.40	#29	0.130	0.135	0.237	0.300	0.362	0.425	0.487	**5 X 40**	0.158	0.141	0.143	0.144	0.212	0.275	0.337	0.400	0.462	0.0979
6 X 32	3.70	#25	0.145	0.150	0.279	0.348	0.417	0.486	0.555	**6 X 32**	0.179	0.158	0.160	0.161	0.247	0.316	0.385	0.454	0.523	0.1040
8 X 32	4.40	11/64	0.171	0.176	0.305	0.387	0.469	0.551	0.633	**8 X 32**	0.205	0.184	0.186	0.187	0.273	0.355	0.437	0.519	0.601	0.1300
10 X 24	5.10	13/64	0.199	0.205	0.377	0.472	0.567	0.662	0.757	**10 X 24**	0.244	0.217	0.219	0.220	0.336	0.431	0.526	0.621	0.716	0.1450
12 X 24	5.70	15/64	0.225	0.231	0.403	0.511	0.619	0.727	0.835	**12 X 24**	0.270	0.243	0.245	0.247	0.362	0.470	0.578	0.686	0.794	0.1710
1/4 X 20	6.70	17/64	0.261	0.270	0.475	0.600	0.725	0.850	0.975	**1/4 X 20**	0.315	0.283	0.285	0.286	0.425	0.550	0.675	0.800	0.925	0.1959
5/16 X 18	8.30	21/64	0.325	0.334	0.562	0.718	0.875	1.031	1.187	**5/16 X 18**	0.385	0.349	0.352	0.353	0.507	0.663	0.819	0.975	1.132	0.2524
3/8 X 16	9.90	25/64	0.389	0.399	0.656	0.844	1.031	1.219	1.406	**3/8 X 16**	0.456	0.416	0.419	0.420	0.594	0.781	0.969	1.156	1.344	0.3073
7/16 X 14	11.60	29/64	0.453	0.464	0.758	0.977	1.196	1.415	1.633	**7/16 X 14**	0.530	0.484	0.488	0.489	0.687	0.906	1.125	1.344	1.562	0.3602
1/2 X 13	13.00	33/64	0.517	0.528	0.846	1.096	1.346	1.596	1.846	**1/2 X 13**	0.600	0.550	0.554	0.555	0.769	1.019	1.269	1.519	1.769	0.4167
9/16 X 12	15.00	19/32	0.581	0.592	0.937	1.219	1.500	1.781	2.062	**9/16 X 12**	0.671	0.617	0.621	0.623	0.854	1.135	1.417	1.698	1.979	0.4723
5/8 X 11	16.50	21/32	0.645	0.657	1.034	1.347	1.659	1.972	2.284	**5/8 X 11**	0.743	0.684	0.689	0.690	0.943	1.256	1.568	1.881	2.193	0.5266
3/4 X 10	19.80	25/32	0.772	0.784	1.200	1.575	1.950	2.325	2.700	**3/4 X 10**	0.880	0.815	0.820	0.822	1.100	1.475	1.850	2.225	2.600	0.6417
7/8 X 9	23.00	29/32	0.899	0.912	1.375	1.812	2.250	2.687	3.125	**7/8 X 9**	1.019	0.947	0.952	0.954	1.264	1.701	2.139	2.576	3.014	0.7547
1 X 8	26.20	1.1/32	1.027	1.042	1.562	2.062	2.562	3.062	3.562	**1 X 8**	1.162	1.081	1.087	1.089	1.437	1.937	2.437	2.937	3.437	0.8647
1-1/8 X 7	29.50	1.5/32	1.156	1.171	1.768	2.330	2.893	3.455	4.018	**1-1/8 X 7**	1.311	1.218	1.224	1.226	1.625	2.187	2.750	3.312	3.875	0.9704
1-1/4 X 7	32.50	1.9/32	1.281	1.296	1.893	2.518	3.143	3.768	4.393	**1-1/4 X 7**	1.436	1.343	1.349	1.351	1.750	2.375	3.000	3.625	4.250	1.0954
1-3/8 X 6	36.00	1.13/32	1.411	1.431	2.125	2.812	3.500	4.187	4.875	**1-3/8 X 6**	1.591	1.483	1.490	1.493	1.958	2.646	3.333	4.021	4.708	1.1946
1-1/2 X 6	39.50	1.35/64	1.536	1.556	2.250	3.000	3.750	4.500	5.250	**1-1/2 X 6**	1.716	1.608	1.615	1.618	2.083	2.833	3.583	4.333	5.083	1.3196
UNF										**UNF**										
2 X 64	2.30	3/32	0.089	0.093	0.156	0.199	0.242	0.285	0.328	**2 X 64**	0.106	0.096	0.097	0.098	0.141	0.184	0.227	0.270	0.313	0.0691
3 X 56	2.70	#37	0.103	0.107	0.179	0.229	0.278	0.328	0.377	**3 X 56**	0.122	0.111	0.112	0.113	0.161	0.210	0.260	0.310	0.359	0.0797
4 X 48	3.00	#31	0.117	0.121	0.206	0.262	0.318	0.374	0.430	**4 X 48**	0.139	0.126	0.127	0.128	0.185	0.241	0.297	0.353	0.409	0.0894
5 X 44	3.40	#30	0.130	0.134	0.227	0.290	0.352	0.414	0.477	**5 X 44**	0.155	0.140	0.141	0.142	0.204	0.267	0.329	0.391	0.454	0.1004
6 X 40	3.70	#26	0.143	0.148	0.250	0.319	0.388	0.457	0.526	**6 X 40**	0.171	0.154	0.156	0.157	0.225	0.294	0.363	0.432	0.501	0.111
8 X 36	4.40	11/64	0.170	0.175	0.289	0.371	0.453	0.535	0.617	**8 X 36**	0.200	0.182	0.184	0.185	0.261	0.343	0.425	0.507	0.589	0.134
10 X 32	5.10	13/64	0.197	0.202	0.331	0.426	0.521	0.616	0.711	**10 X 32**	0.231	0.210	0.212	0.213	0.299	0.394	0.489	0.584	0.679	0.156
1/4 X 28	6.60	17/64	0.258	0.265	0.411	0.536	0.661	0.786	0.911	**1/4 X 28**	0.296	0.273	0.275	0.277	0.375	0.500	0.625	0.750	0.875	0.2113
5/16 X 24	8.20	21/64	0.322	0.329	0.500	0.656	0.812	0.969	1.125	**5/16 X 24**	0.367	0.340	0.342	0.343	0.458	0.614	0.771	0.927	1.083	0.2674
3/8 X 24	9.80	25/64	0.384	0.391	0.562	0.750	0.937	1.124	1.312	**3/8 X 24**	0.429	0.402	0.405	0.406	0.521	0.708	0.896	1.083	1.271	0.3299
7/16 X 20	11.50	29/64	0.448	0.456	0.662	0.881	1.100	1.319	1.537	**7/16 X 20**	0.503	0.470	0.473	0.474	0.612	0.831	1.050	1.269	1.487	0.3834
1/2 X 20	13.00	33/64	0.511	0.518	0.725	0.975	1.225	1.475	1.725	**1/2 X 20**	0.565	0.533	0.536	0.537	0.675	0.925	1.175	1.425	1.675	0.4459
9/16 X 18	14.70	37/64	0.575	0.582	0.811	1.093	1.374	1.655	1.936	**9/16 X 18**	0.635	0.599	0.602	0.604	0.756	1.038	1.319	1.600	1.881	0.5024
5/8 X 18	16.30	41/64	0.637	0.645	0.874	1.187	1.500	1.812	2.124	**5/8 X 18**	0.697	0.661	0.665	0.666	0.819	1.132	1.444	1.757	2.069	0.5649
3/4 X 16	19.50	49/64	0.764	0.772	1.031	1.406	1.781	2.156	2.531	**3/4 X 16**	0.831	0.791	0.795	0.796	0.969	1.344	1.719	2.094	2.469	0.6823
7/8 X 14	22.50	57/64	0.891	0.899	1.196	1.634	2.071	2.509	2.946	**7/8 X 14**	0.968	0.921	0.926	0.927	1.125	1.562	2.000	2.437	2.875	0.7977
1 X 12	26.00	1.1/64	1.018	1.028	1.375	1.875	2.375	2.875	3.375	**1 X 12**	1.108	1.054	1.059	1.061	1.292	1.792	2.292	2.792	3.292	0.9098
1 X 14	26.00	1.1/64	1.016	1.024	1.320	1.820	2.320	2.820	3.320	**1 X 14**	1.093	1.046	1.051	1.053	1.250	1.750	2.250	2.750	3.250	0.9277
1-1/8 X 12	29.50	1.5/32	1.143	1.154	1.500	2.062	2.625	3.187	3.750	**1-1/8 X 12**	1.233	1.179	1.184	1.186	1.417	1.979	2.542	3.104	3.667	1.0348
1-1/4 X 12	32.50	1.9/32	1.268	1.279	1.625	2.250	2.875	3.500	4.125	**1-1/4 X 12**	1.358	1.304	1.309	1.311	1.542	2.167	2.792	3.417	4.042	1.1598
1-3/8 X 12	35.50	1.13/32	1.393	1.404	1.750	2.438	3.125	3.813	4.500	**1-3/8 X 12**	1.483	1.429	1.434	1.436	1.667	2.354	3.042	3.729	4.417	1.2848
1-1/2 X 12	38.50	1.17/32	1.518	1.529	1.875	2.625	3.375	4.125	4.875	**1-1/2 X 12**	1.608	1.554	1.560	1.562	1.792	2.542	3.292	4.042	4.792	1.4098

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 listed below are adhered to.

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.

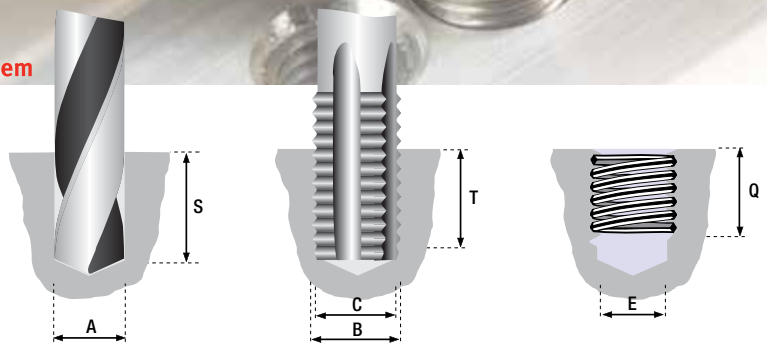
PowerCoil wire thread inserts can be manufactured to different standards upon request. Technical data on these standards can be obtained from our website – www.powercoil.com.au.



Nominal Thread Size	INSERT SPECIFICATIONS																		Nominal Thread Size
	Q Nominal Length – installed					Free Coil Diameter		Number of Free Coils ± 1/4 coil counted 90° from Tang											
	1D	1.5D	2D	2.5D	3D	Min	Max	1D		1.5D		2D		2.5D		3D			
	inch	inch	inch	inch	inch	inch	inch	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
UNC																			**UNC**
2 X 56	0.086	0.129	0.172	0.215	0.258	0.11	0.12	2.80	3.10	4.80	5.40	6.90	7.80	9.00	10.10	11.10	12.50		**2 X 56**
3 X 48	0.099	0.148	0.198	0.247	0.297	0.12	0.14	2.80	3.20	4.90	5.50	7.00	7.90	9.00	10.30	11.20	12.70		**3 X 48**
4 X 40	0.112	0.168	0.224	0.280	0.336	0.14	0.16	2.40	2.80	4.30	4.90	6.20	7.10	8.10	9.20	10.00	11.40		**4 X 40**
5 X 40	0.125	0.187	0.250	0.312	0.375	0.16	0.17	2.90	3.30	5.00	5.70	7.20	8.10	9.30	10.50	11.50	13.00		**5 X 40**
6 X 32	0.138	0.207	0.276	0.345	0.414	0.18	0.19	2.40	2.70	4.30	4.80	6.20	7.00	8.20	9.10	10.10	11.20		**6 X 32**
8 X 32	0.164	0.246	0.328	0.410	0.492	0.20	0.22	3.20	3.50	5.50	6.10	7.80	8.60	10.10	11.20	12.40	13.70		**8 X 32**
10 X 24	0.190	0.285	0.380	0.475	0.570	0.24	0.26	2.60	2.80	4.60	5.00	6.70	7.20	8.70	9.40	10.70	11.60		**10 X 24**
12 X 24	0.216	0.324	0.432	0.540	0.648	0.27	0.28	3.20	3.50	5.60	6.00	7.90	8.50	10.30	11.00	12.60	13.50		**12 X 24**
1/4 X 20	0.250	0.375	0.500	0.625	0.750	0.31	0.33	3.10	3.30	5.30	5.70	7.60	8.10	9.90	10.50	12.10	13.00		**1/4 X 20**
5/16 X 18	0.312	0.469	0.625	0.781	0.937	0.38	0.40	3.70	3.90	6.30	6.70	8.90	9.50	11.50	12.20	14.10	15.00		**5/16 X 18**
3/8 X 16	0.375	0.562	0.750	0.937	1.125	0.45	0.47	4.10	4.30	6.80	7.20	9.60	10.10	12.40	13.10	15.20	16.00		**3/8 X 16**
7/16 X 14	0.437	0.656	0.875	1.094	1.312	0.52	0.55	4.10	4.40	7.00	7.40	9.80	10.40	12.60	13.40	15.50	16.30		**7/16 X 14**
1/2 X 13	0.500	0.750	1.000	1.250	1.500	0.59	0.62	4.50	4.80	7.50	8.00	10.60	11.10	13.60	14.30	16.60	17.50		**1/2 X 13**
9/16 X 12	0.562	0.844	1.125	1.406	1.687	0.66	0.69	4.80	5.00	7.90	8.40	11.10	11.70	14.20	15.00	17.40	18.30		**9/16 X 12**
5/8 X 11	0.625	0.937	1.250	1.562	1.875	0.74	0.77	4.90	5.10	8.10	8.50	11.30	11.90	14.50	15.20	17.70	18.60		**5/8 X 11**
3/4 X 10	0.750	1.125	1.500	1.875	2.250	0.87	0.91	5.50	5.80	9.00	9.50	12.60	13.10	16.10	16.80	19.60	20.50		**3/4 X 10**
7/8 X 9	0.875	1.312	1.750	2.187	2.625	1.01	1.05	5.90	6.20	9.60	10.00	13.30	13.90	17.00	17.80	20.70	21.70		**7/8 X 9**
1 X 8	1.000	1.500	2.000	2.500	3.000	1.15	1.20	6.00	6.30	9.80	10.20	13.60	14.20	17.30	18.10	21.10	22.00		**1 X 8**
1-1/8 X 7	1.125	1.687	2.250	2.812	3.375	1.30	1.36	5.90	6.20	9.60	10.10	13.30	14.00	17.00	17.90	20.70	21.80		**1-1/8 X 7**
1-1/4 X 7	1.250	1.875	2.500	3.125	3.750	1.42	1.48	6.70	7.10	10.90	11.40	15.00	15.80	19.20	20.10	23.30	24.40		**1-1/4 X 7**
1-3/8 X 6	1.375	2.062	2.750	3.437	4.125	1.58	1.64	6.20	6.50	10.10	10.60	14.00	14.60	17.80	18.70	21.70	22.70		**1-3/8 X 6**
1-1/2 X 6	1.500	2.250	3.000	3.750	4.500	1.70	1.77	6.90	7.30	11.20	11.70	15.40	16.10	19.60	20.60	23.90	25.00		**1-1/2 X 6**
UNF																			**UNF**
2 X 64	0.086	0.129	0.172	0.215	0.258	0.11	0.12	3.40	3.70	5.80	6.30	8.20	8.90	10.50	11.60	12.90	14.20		**2 X 64**
3 X 56	0.099	0.148	0.198	0.247	0.297	0.12	0.15	3.10	3.70	5.20	6.40	7.40	9.00	9.60	11.60	11.80	14.30		**3 X 56**
4 X 48	0.112	0.168	0.224	0.280	0.336	0.14	0.16	3.20	3.70	5.40	6.40	7.60	9.00	9.80	11.60	12.10	14.20		**4 X 48**
5 X 44	0.125	0.187	0.250	0.312	0.375	0.16	0.17	3.40	3.70	5.80	6.30	8.20	8.90	10.60	11.50	13.00	14.20		**5 X 44**
6 X 40	0.138	0.207	0.276	0.345	0.414	0.17	0.19	3.20	3.70	5.50	6.30	7.80	9.00	10.10	11.60	12.40	14.20		**6 X 40**
8 X 36	0.164	0.246	0.328	0.410	0.492	0.20	0.22	3.60	4.10	6.10	6.90	8.60	9.70	11.10	12.50	13.60	15.30		**8 X 36**
10 X 32	0.190	0.285	0.380	0.475	0.570	0.23	0.26	3.80	4.30	6.40	7.20	9.00	10.10	11.60	13.00	14.20	15.90		**10 X 32**
1/4 X 28	0.250	0.375	0.500	0.625	0.750	0.30	0.33	4.70	5.20	7.70	8.50	10.80	11.90	13.80	15.20	16.90	18.60		**1/4 X 28**
5/16 X 24	0.312	0.469	0.625	0.781	0.937	0.37	0.40	5.10	5.60	8.50	9.20	11.70	12.80	15.00	16.40	18.30	20.00		**5/16 X 24**
3/8 X 24	0.375	0.562	0.750	0.937	1.125	0.43	0.47	6.50	7.10	10.50	11.40	14.50	15.80	18.50	20.10	22.50	24.50		**3/8 X 24**
7/16 X 20	0.437	0.656	0.875	1.094	1.312	0.51	0.55	6.30	6.90	10.20	11.10	14.00	15.30	17.90	19.50	21.70	23.70		**7/16 X 20**
1/2 X 20	0.500	0.750	1.000	1.250	1.500	0.57	0.62	7.40	8.10	11.90	12.90	16.30	17.80	20.80	22.60	25.20	27.50		**1/2 X 20**
9/16 X 18	0.562	0.844	1.125	1.406	1.687	0.64	0.69	7.60	8.30	12.20	13.30	16.80	18.20	21.30	23.10	25.90	28.10		**9/16 X 18**
5/8 X 18	0.625	0.937	1.250	1.562	1.875	0.70	0.76	8.70	9.40	13.80	14.90	18.90	20.50	24.00	26.00	29.10	31.50		**5/8 X 18**
3/4 X 16	0.750	1.125	1.500	1.875	2.250	0.84	0.90	9.30	10.10	14.70	15.90	20.10	21.70	25.50	27.60	30.90	33.40		**3/4 X 16**
7/8 X 14	0.875	1.312	1.750	2.187	2.625	0.98	1.05	9.60	10.30	15.10	16.30	20.60	22.20	26.10	28.20	31.60	34.20		**7/8 X 14**
1 X 12	1.000	1.500	2.000	2.500	3.000	1.12	1.20	9.40	10.10	14.80	16.00	20.30	21.80	25.70	27.70	31.10	33.50		**1 X 12**
1 X 14	1.000	1.500	2.000	2.500	3.000	1.10	1.19	11.20	12.10	17.50	18.90	23.80	25.70	30.10	32.50	36.40	39.40		**1 X 14**
1-1/8 X 12	1.125	1.687	2.250	2.812	3.375	1.25	1.33	10.80	11.60	16.90	18.20	23.00	24.80	29.20	31.40	35.30	38.00		**1-1/8 X 12**
1-1/4 X 12	1.250	1.875	2.500	3.125	3.750	1.37	1.47	12.20	13.10	19.00	20.40	25.80	27.80	32.70	35.10	39.50	42.50		**1-1/4 X 12**
1-3/8 X 12	1.375	2.062	2.750	3.437	4.125	1.50	1.61	13.50	14.60	21.00	22.70	28.50	30.80	36.00	38.80	43.50	46.90		**1-3/8 X 12**
1-1/2 X 12	1.500	2.250	3.000	3.750	4.500	1.62	1.75	14.90	16.10	23.10	24.90	31.30	33.70	39.50	42.60	47.70	51.40		**1-1/2 X 12**

powercoil® wire thread insert system

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.



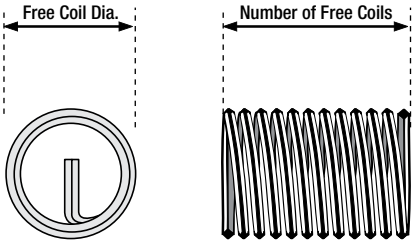
Nominal Thread Size	DRILLED HOLE DIMENSIONS									Nominal Thread Size	TAPPED HOLE DIMENSIONS									E Fitted Minor Dia.
	Drill				S Min. Drilling Depth Inter/Plug Tap						B Major Dia.	C Pitch Diameter			T Minimum Tapping Depth					
	Size		A Minor Dia.		1D	1.5D	2D	2.5D	3D			Min	Close	Medium	1D	1.5D	2D	2.5D	3D	
	mm	inch	inch	inch	inch	inch	inch	inch	inch		inch	inch	inch	inch	inch	inch	inch	inch	inch	inch
BSW										**BSW**										
1/8 X 40	3.40	#30	0.129	0.135	0.237	0.300	0.362	0.425	0.487	**1/8 X 40**	0.155	0.1410	0.1420	0.1430	0.212	0.275	0.337	0.400	0.462	0.0930
3/16 X 24	5.00	13/64	0.196	0.202	0.375	0.469	0.562	0.656	0.750	**3/16 X 24**	0.237	0.2142	0.2154	0.2166	0.333	0.427	0.521	0.614	0.708	0.1341
1/4 X 20	6.70	17/64	0.261	0.267	0.475	0.600	0.725	0.850	0.975	**1/4 X 20**	0.309	0.2820	0.2836	0.2849	0.425	0.550	0.675	0.800	0.925	0.1860
5/16 X 18	8.30	21/64	0.328	0.334	0.562	0.718	0.875	1.031	1.187	**5/16 X 18**	0.378	0.3480	0.3498	0.3512	0.507	0.663	0.819	0.975	1.132	0.2413
3/8 X 16	10.00	25/64	0.390	0.398	0.656	0.844	1.031	1.219	1.406	**3/8 X 16**	0.448	0.4150	0.4170	0.4185	0.594	0.781	0.969	1.156	1.344	0.2950
7/16 X 14	11.60	29/64	0.453	0.463	0.758	0.977	1.196	1.415	1.633	**7/16 X 14**	0.521	0.4833	0.4855	0.4871	0.687	0.906	1.125	1.344	1.562	0.3461
1/2 X 12	13.00	33/64	0.515	0.525	0.875	1.125	1.375	1.625	1.875	**1/2 X 12**	0.597	0.5533	0.5557	0.5575	0.792	1.042	1.292	1.542	1.792	0.3932
9/16 X 12	14.80	37/64	0.578	0.588	0.937	1.219	1.500	1.781	2.062	**9/16 X 12**	0.660	0.6158	0.6184	0.6201	0.854	1.135	1.417	1.698	1.979	0.4557
5/8 X 11	16.70	21/32	0.653	0.663	1.034	1.347	1.659	1.972	2.284	**5/8 X 11**	0.731	0.6832	0.6859	0.6878	0.943	1.256	1.568	1.881	2.193	0.5086
3/4 X 10	20.00	25/32	0.781	0.791	1.200	1.575	1.950	2.325	2.700	**3/4 X 10**	0.867	0.8141	0.8171	0.8191	1.100	1.475	1.850	2.225	2.600	0.6220
7/8 X 9	23.20	29/32	0.906	0.916	1.375	1.812	2.250	2.687	3.125	**7/8 X 9**	1.005	0.9462	0.9495	0.9516	1.264	1.701	2.139	2.576	3.014	0.7328
1 X 8	26.50	1.1/32	1.031	1.044	1.562	2.062	2.562	3.062	3.562	**1 X 8**	1.146	1.0801	1.0836	1.0859	1.437	1.937	2.437	2.937	3.437	0.8400
1-1/8 X 7	30.00	1.11/64	1.171	1.186	1.768	2.330	2.893	3.455	4.018	**1-1/8 X 7**	1.291	1.2165	1.2203	1.2227	1.625	2.187	2.750	3.312	3.875	0.9420
1-1/4 X 7	33.00	1.19/64	1.296	1.311	1.893	2.518	3.143	3.768	4.393	**1-1/4 X 7**	1.416	1.3415	1.3454	1.3479	1.750	2.375	3.000	3.625	4.250	1.0670
1-1/2 X 6	39.50	1.35/64	1.546	1.571	2.250	3.000	3.750	4.500	5.250	**1-1/2 X 6**	1.694	1.6067	1.6110	1.6137	2.083	2.833	3.583	4.333	5.083	1.2866
BSF										**BSF**										
3/16 X 32	5.00	13/64	0.192	0.198	0.328	0.422	0.515	0.609	0.703	**3/16 X 32**	0.225	0.2075	0.2087	0.2098	0.297	0.390	0.484	0.578	0.672	0.1475
1/4 X 26	6.60	17/64	0.257	0.264	0.423	0.548	0.673	0.798	0.923	**1/4 X 26**	0.296	0.2747	0.2762	0.2774	0.385	0.510	0.635	0.760	0.885	0.2008
5/16 X 22	8.30	21/64	0.323	0.330	0.517	0.673	0.829	0.986	1.142	**5/16 X 22**	0.366	0.3416	0.3433	0.3447	0.472	0.628	0.784	0.940	1.096	0.2543
3/8 X 20	9.80	25/64	0.385	0.392	0.600	0.787	0.975	1.162	1.350	**3/8 X 20**	0.434	0.4070	0.4089	0.4104	0.550	0.737	0.925	1.112	1.300	0.3110
7/16 X 18	11.60	29/64	0.450	0.458	0.687	0.906	1.124	1.343	1.562	**7/16 X 18**	0.503	0.4730	0.4751	0.4767	0.632	0.851	1.069	1.288	1.507	0.3663
1/2 X 16	13.20	33/64	0.513	0.522	0.781	1.031	1.281	1.531	1.781	**1/2 X 16**	0.574	0.5400	0.5423	0.5440	0.719	0.969	1.219	1.469	1.719	0.4200
9/16 X 16	14.80	37/64	0.577	0.586	0.844	1.125	1.406	1.687	1.969	**9/16 X 16**	0.636	0.6025	0.6049	0.6067	0.781	1.062	1.344	1.625	1.906	0.4825
5/8 X 14	16.30	41/64	0.640	0.649	0.946	1.259	1.571	1.884	2.196	**5/8 X 14**	0.709	0.6708	0.6734	0.6752	0.875	1.187	1.500	1.812	2.125	0.5336
3/4 X 12	19.50	49/64	0.765	0.775	1.125	1.500	1.875	2.250	2.625	**3/4 X 12**	0.848	0.8033	0.8062	0.8082	1.042	1.417	1.792	2.167	2.542	0.6432
7/8 X 11	22.80	57/64	0.890	0.900	1.284	1.722	2.159	2.596	3.034	**7/8 X 11**	0.982	0.9332	0.9364	0.9384	1.193	1.631	2.068	2.506	2.943	0.7586
1 X 10	26.20	1.1/32	1.031	1.044	1.450	1.950	2.450	2.950	3.450	**1 X 10**	1.117	1.0641	1.0675	1.0697	1.350	1.850	2.350	2.850	3.350	0.8720
1-1/8 X 9	29.50	1.5/32	1.156	1.170	1.625	2.187	2.750	3.312	3.875	**1-1/8 X 9**	1.255	1.1962	1.1998	1.2021	1.514	2.076	2.639	3.201	3.764	0.9828
1-1/4 X 9	32.50	1.9/32	1.281	1.295	1.750	2.375	3.000	3.625	4.250	**1-1/4 X 9**	1.380	1.3212	1.3250	1.3274	1.639	2.264	2.889	3.514	4.139	1.1078
1-3/8 X 8	36.00	1.13/32	1.406	1.420	1.937	2.625	3.312	4.000	4.687	**1-3/8 X 8**	1.521	1.4551	1.4591	1.4616	1.812	2.500	3.187	3.875	4.562	1.2150
1-1/2 X 8	39.00	1.17/32	1.531	1.545	2.062	2.812	3.562	4.312	5.062	**1-1/2 X 8**	1.646	1.5801	1.5843	1.5868	1.937	2.687	3.437	4.187	4.937	1.3400
BSP										**BSP**										
1/8 X 28	10.00	25/64	0.390	0.400	0.286	0.348	0.411	0.437	0.536	**1/8 X 28**	0.426	0.4058	0.4076	0.4090	0.250	0.312	0.375	0.437	0.500	0.3372
1/4 X 19	13.60	17/32	0.530	0.540	0.487	0.612	0.737	0.862	0.987	**1/4 X 19**	0.580	0.5517	0.5539	0.5556	0.434	0.559	0.684	0.809	0.934	0.4506
3/8 X 19	17.10	43/64	0.670	0.680	0.612	0.799	0.987	1.174	1.362	**3/8 X 19**	0.718	0.6897	0.6920	0.6937	0.559	0.747	0.934	1.122	1.309	0.5886
1/2 X 14	21.50	27/32	0.840	0.850	0.821	1.071	1.321	1.571	1.821	**1/2 X 14**	0.909	0.8708	0.8735	0.8754	0.750	1.000	1.250	1.500	1.750	0.7336
5/8 X 14	23.40	59/64	0.915	0.927	0.946	1.258	1.571	1.883	2.196	**5/8 X 14**	0.986	0.9478	0.9506	0.9524	0.875	1.187	1.500	1.812	2.125	0.8106
3/4 X 14	27.00	1.1/16	1.053	1.066	1.071	1.446	1.821	2.196	2.571	**3/4 X 14**	1.126	1.0868	1.0898	1.0918	1.000	1.375	1.750	2.125	2.500	0.9496
7/8 X 14	30.50	1.13/64	1.200	1.213	1.196	1.634	2.071	2.509	2.946	**7/8 X 14**	1.274	1.2348	1.2378	1.2399	1.125	1.562	2.000	2.437	2.875	1.0976
1 X 11	33.70	1.21/64	1.320	1.335	1.409	1.909	2.409	2.909	3.409	**1 X 11**	1.416	1.3673	1.3705	1.3727	1.318	1.818	2.318	2.818	3.318	1.1926
1-1/4 X 11	42.50	1.43/64	1.665	1.680	1.660	2.284	2.909	3.534	4.159	**1-1/4 X 11**	1.757	1.7083	1.7118	1.7141	1.568	2.193	2.818	3.443	4.068	1.5336
1-1/2 X 11	48.50	1.29/32	1.906	1.921	1.909	2.659	3.409	4.159	4.909	**1-1/2 X 11**	1.989	1.9403	1.9440	1.9464	1.818	2.568	3.318	4.068	4.818	1.7656

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 listed below are adhered to.

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.

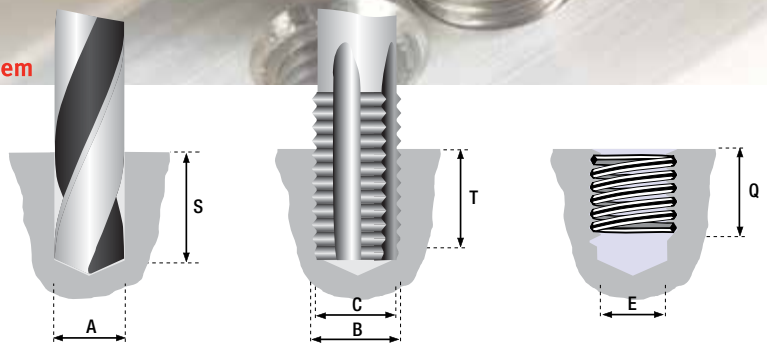
PowerCoil wire thread inserts can be manufactured to different standards upon request. Technical data on these standards can be obtained from our website – www.powercoil.com.au.



Nominal Thread Size	INSERT SPECIFICATIONS																		Nominal Thread Size
	Q Nominal Length – installed					Free Coil Diameter		Number of Free Coils ± 1/4 coil counted 90° from Tang											
	1D	1.5D	2D	2.5D	3D	Min	Max	1D		1.5D		2D		2.5D		3D			
	inch	inch	inch	inch	inch	inch	inch	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
BSW																			**BSW**
1/8 X 40	0.125	0.187	0.250	0.312	0.375	0.15	0.17	3.00	3.40	5.10	5.80	7.30	8.40	9.40	10.90	11.60	13.40		**1/8 X 40**
3/16 X 24	0.187	0.281	0.375	0.469	0.562	0.23	0.26	2.60	2.90	4.60	5.10	6.60	7.40	8.70	9.70	10.70	11.90		**3/16 X 24**
1/4 X 20	0.250	0.375	0.500	0.625	0.750	0.31	0.33	3.10	3.40	5.40	5.90	7.70	8.50	9.90	11.00	12.20	13.50		**1/4 X 20**
5/16 X 18	0.312	0.469	0.625	0.781	0.937	0.37	0.40	3.80	4.10	6.40	6.90	9.00	9.80	11.60	12.60	14.20	15.50		**5/16 X 18**
3/8 X 16	0.375	0.562	0.750	0.937	1.125	0.44	0.47	4.10	4.40	6.90	7.40	9.70	10.50	12.50	13.50	15.30	16.50		**3/8 X 16**
7/16 X 14	0.437	0.656	0.875	1.094	1.312	0.52	0.55	4.20	4.60	7.10	7.60	9.90	10.70	12.80	13.80	15.60	16.90		**7/16 X 14**
1/2 X 12	0.500	0.750	1.000	1.250	1.500	0.59	0.63	4.10	4.50	7.00	7.40	9.80	10.50	12.60	13.60	15.40	16.60		**1/2 X 12**
9/16 X 12	0.562	0.844	1.125	1.406	1.687	0.65	0.69	4.90	5.20	8.00	8.60	11.20	12.00	14.40	15.40	17.60	18.80		**9/16 X 12**
5/8 X 11	0.625	0.937	1.250	1.562	1.875	0.72	0.77	5.00	5.30	8.20	8.70	11.50	12.20	14.70	15.70	17.90	19.20		**5/8 X 11**
3/4 X 10	0.750	1.125	1.500	1.875	2.250	0.86	0.90	5.60	6.00	9.20	9.70	12.70	13.50	16.30	17.30	19.80	21.10		**3/4 X 10**
7/8 X 9	0.875	1.312	1.750	2.187	2.625	0.99	1.05	6.00	6.30	9.70	10.20	13.40	14.30	17.10	18.20	20.90	22.20		**7/8 X 9**
1 X 8	1.000	1.500	2.000	2.500	3.000	1.13	1.20	6.10	6.50	9.90	10.40	13.70	14.50	17.50	18.60	21.20	22.60		**1 X 8**
1-1/8 X 7	1.125	1.687	2.250	2.812	3.375	1.28	1.35	5.90	6.30	9.60	10.20	13.40	14.30	17.10	18.20	20.80	22.20		**1-1/8 X 7**
1-1/4 X 7	1.250	1.875	2.500	3.125	3.750	1.40	1.48	6.80	7.20	10.90	11.60	15.00	16.00	19.20	20.40	23.30	24.90		**1-1/4 X 7**
1-1/2 X 6	1.500	2.250	3.000	3.750	4.500	1.68	1.78	7.00	7.50	11.30	11.90	15.50	16.50	19.80	21.10	24.00	25.60		**1-1/2 X 6**
BSF																			**BSF**
3/16 X 32	0.187	0.281	0.375	0.469	0.562	0.23	0.25	3.90	4.30	6.50	7.20	9.20	10.20	11.90	13.10	14.50	16.00		**3/16 X 32**
1/4 X 26	0.250	0.375	0.500	0.625	0.750	0.30	0.33	4.30	4.80	7.10	7.90	9.90	11.20	12.70	14.40	15.60	17.50		**1/4 X 26**
5/16 X 22	0.312	0.469	0.625	0.781	0.937	0.37	0.40	4.70	5.20	7.70	8.50	10.70	11.90	13.80	15.30	16.80	18.70		**5/16 X 22**
3/8 X 20	0.375	0.562	0.750	0.937	1.125	0.44	0.48	5.30	5.80	8.60	9.40	12.00	13.20	15.30	16.90	18.70	20.50		**3/8 X 20**
7/16 X 18	0.437	0.656	0.875	1.094	1.312	0.51	0.56	5.60	6.20	9.10	10.00	12.60	13.90	16.10	17.80	19.60	21.60		**7/16 X 18**
1/2 X 16	0.500	0.750	1.000	1.250	1.500	0.58	0.63	5.70	6.30	9.30	10.20	12.90	14.20	16.50	18.10	20.00	22.00		**1/2 X 16**
9/16 X 16	0.562	0.844	1.125	1.406	1.687	0.64	0.70	6.60	7.30	10.60	11.70	14.70	16.10	18.70	20.60	22.70	25.00		**9/16 X 16**
5/8 X 14	0.625	0.937	1.250	1.562	1.875	0.72	0.77	6.50	7.10	10.40	11.30	14.30	15.70	18.30	20.00	22.20	24.30		**5/8 X 14**
3/4 X 12	0.750	1.125	1.500	1.875	2.250	0.86	0.92	6.70	7.30	10.80	11.70	14.90	16.20	19.00	20.70	23.00	25.10		**3/4 X 12**
7/8 X 11	0.875	1.312	1.750	2.187	2.625	0.99	1.07	7.20	7.90	11.60	12.60	15.90	17.40	20.30	22.10	24.60	26.90		**7/8 X 11**
1 X 10	1.000	1.500	2.000	2.500	3.000	1.13	1.22	7.60	8.30	12.10	13.20	16.60	18.10	21.20	23.10	25.70	28.00		**1 X 10**
1-1/8 X 9	1.125	1.687	2.250	2.812	3.375	1.27	1.37	7.80	8.40	12.30	13.30	17.00	18.40	21.50	23.40	26.10	28.40		**1-1/8 X 9**
1-1/4 X 9	1.250	1.875	2.500	3.125	3.750	1.39	1.50	8.80	9.50	13.90	15.00	19.00	20.60	24.20	26.20	29.30	31.70		**1-1/4 X 9**
1-3/8 X 8	1.375	2.062	2.750	3.437	4.125	1.54	1.66	8.50	9.30	13.50	14.60	18.50	20.10	23.50	25.50	28.50	31.00		**1-3/8 X 8**
1-1/2 X 8	1.500	2.250	3.000	3.750	4.500	1.66	1.81	9.40	10.30	14.80	16.10	20.10	22.10	25.50	28.00	30.90	33.90		**1-1/2 X 8**
BSP																			**BSP**
1/8 X 28	0.125	0.187	0.250	0.312	0.375	0.43	0.47	1.70	1.90	3.20	3.60	4.80	5.30	6.40	7.00	7.90	8.80		**1/8 X 28**
1/4 X 19	0.250	0.375	0.500	0.625	0.750	0.59	0.64	2.80	3.10	5.00	5.40	7.10	7.80	9.20	10.10	11.40	12.50		**1/4 X 19**
3/8 X 19	0.375	0.562	0.750	0.937	1.125	0.73	0.79	5.00	5.50	8.20	8.90	11.40	12.50	14.60	16.00	17.90	19.50		**3/8 X 19**
1/2 X 14	0.500	0.750	1.000	1.250	1.500	0.92	0.99	4.90	5.30	8.10	8.80	11.20	12.20	14.40	15.70	17.60	19.10		**1/2 X 14**
5/8 X 14	0.625	0.937	1.250	1.562	1.875	1.00	1.08	6.50	7.10	10.40	11.30	14.40	15.70	18.40	20.00	22.30	24.30		**5/8 X 14**
3/4 X 14	0.750	1.125	1.500	1.875	2.250	1.14	1.23	8.10	8.80	12.90	13.90	17.60	19.20	22.40	24.30	27.20	29.50		**3/4 X 14**
7/8 X 14	0.875	1.312	1.750	2.187	2.625	1.29	1.39	9.70	10.50	15.30	16.50	20.80	22.60	26.40	28.70	32.00	34.70		**7/8 X 14**
1 X 11	1.000	1.500	2.000	2.500	3.000	1.43	1.54	8.60	9.30	13.60	14.70	18.60	20.10	23.60	25.60	28.60	31.00		**1 X 11**
1-1/4 X 11	1.250	1.875	2.500	3.125	3.750	1.77	1.91	11.10	12.00	17.40	18.70	23.70	25.60	30.00	32.40	36.20	39.20		**1-1/4 X 11**
1-1/2 X 11	1.500	2.250	3.000	3.750	4.500	2.01	2.16	13.60	14.70	21.20	22.80	28.70	31.00	36.30	39.20	43.80	47.30		**1-1/2 X 11**

powercoil® wire thread insert system

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.



Nominal Thread Size	DRILLED HOLE DIMENSIONS									Nominal Thread Size	TAPPED HOLE DIMENSIONS									E Fitted Minor Dia.
	Drill				S Min. Drilling Depth Inter/Plug Tap						B Major Dia.	C Pitch Diameter		T Minimum Tapping Depth						
	Size		A Minor Dia.		1D	1.5D	2D	2.5D	3D			Minimum	Normal	1D	1.5D	2D	2.5D	3D		
	mm	inch	inch	inch	inch	inch	inch	inch	inch		inch	inch	inch	inch	inch	inch	inch	inch	inch	inch
BA										**BA**										
6BA	2.90	#33	0.113	0.116	0.204	0.259	0.314	0.369	0.424	**6BA**	0.134	0.1226	0.1252	0.183	0.238	0.293	0.348	0.404	0.0850
5BA	3.40	#29	0.129	0.135	0.230	0.293	0.356	0.419	0.482	**5BA**	0.152	0.1399	0.1426	0.207	0.270	0.333	0.396	0.459	0.0980
4BA	3.80	#25	0.147	0.152	0.259	0.329	0.400	0.471	0.542	**4BA**	0.171	0.1574	0.1605	0.233	0.303	0.374	0.445	0.516	0.1106
3BA	4.30	11/64	0.166	0.171	0.291	0.371	0.452	0.533	0.613	**3BA**	0.194	0.1786	0.1821	0.262	0.343	0.423	0.504	0.585	0.1268
2BA	4.90	#10	0.191	0.196	0.328	0.421	0.513	0.606	0.698	**2BA**	0.221	0.2042	0.2079	0.297	0.389	0.482	0.574	0.667	0.1468
1BA	5.50	7/32	0.213	0.220	0.368	0.472	0.576	0.681	0.785	**1BA**	0.249	0.2299	0.2342	0.333	0.437	0.541	0.646	0.750	0.1661
0BA	6.20	C	0.241	0.246	0.413	0.531	0.649	0.768	0.886	**0BA**	0.281	0.2598	0.2645	0.374	0.492	0.610	0.728	0.846	0.1890
BSC										**BSC**										
3/16 X 32	5.10	13/64	0.195	0.205	0.330	0.420	0.520	0.610	0.700	**3/16 X 32**	0.232	0.2136	0.2112	0.300	0.390	0.480	0.580	0.670	0.1543
1/4 X 26	6.60	17/64	0.258	0.270	0.420	0.550	0.670	0.800	0.920	**1/4 X 26**	0.304	0.2817	0.2790	0.380	0.510	0.630	0.760	0.880	0.2090
5/16 X 26	8.00	5/16	0.320	0.332	0.490	0.640	0.800	0.950	1.110	**5/16 X 26**	0.367	0.3444	0.3415	0.450	0.600	0.760	0.920	1.070	0.2715
3/8 X 26	9.80	25/64	0.383	0.395	0.550	0.740	0.920	1.110	1.300	**3/8 X 26**	0.429	0.4070	0.4040	0.510	0.700	0.880	1.070	1.260	0.3340
7/16 X 26	11.10	7/16	0.446	0.457	0.610	0.830	1.050	1.270	1.490	**7/16 X 26**	0.492	0.4697	0.4665	0.570	0.790	1.010	1.230	1.450	0.3965
1/2 X 26	12.70	1/2	0.508	0.520	0.670	0.920	1.170	1.420	1.670	**1/2 X 26**	0.554	0.5323	0.5290	0.630	0.880	1.130	1.380	1.630	0.4590
9/16 X 26	14.75	37/64	0.571	0.582	0.740	1.020	1.300	1.580	1.860	**9/16 X 26**	0.617	0.5945	0.5915	0.700	0.980	1.260	1.540	1.820	0.5215
5/8 X 26	16.30	41/64	0.633	0.645	0.800	1.110	1.420	1.740	2.050	**5/8 X 26**	0.679	0.6575	0.6540	0.760	1.070	1.380	1.700	2.010	0.5840
3/4 X 26	19.50	49/64	0.758	0.769	0.920	1.300	1.670	2.050	2.420	**3/4 X 26**	0.804	0.7827	0.7790	0.880	1.260	1.630	2.010	2.380	0.7090
1 X 24	25.75	1.1/64	1.009	1.020	1.190	1.690	2.190	2.690	3.190	**1 X 24**	1.059	1.0355	1.0314	1.150	1.650	2.150	2.650	3.150	0.9556

Nominal Thread Size	DRILLED HOLE DIMENSIONS									Nominal Thread Size	TAPPED HOLE DIMENSIONS										E Fitted Minor Dia.
	Drill				S Min. Drilling Depth Inter/Plug Tap						B Major Dia.	C Pitch Dia.		Tap Std.	T Minimum Tapping Depth						
	Size		A Minor Dia.		1D	1.5D	2D	2.5D	3D			Min	3B		1D	1.5D	2D	2.5D	3D		
	mm	inch	inch	inch	inch	inch	inch	inch	inch		inch	inch	inch	8 TPI	inch	inch	inch	inch	inch		inch
8-UN										**8-UN**											
1.1/8 X 8	28.50	1.1/8	1.130	1.155	1.690	2.250	2.810	3.380	3.940	**1.1/8 X 8**	1.261	1.1688	1.1757	1.1/4	1.560	2.130	2.690	3.250	3.810		–
1.1/4 X 8	32.00	1.1/4	1.255	1.280	1.810	2.440	3.060	3.690	4.310	**1.1/4 X 8**	1.386	1.2938	1.3008	1.3/8	1.690	2.310	2.940	3.560	4.190		–
1.3/8 X 8	35.00	1.3/8	1.380	1.405	1.940	2.620	3.310	4.000	4.690	**1.3/8 X 8**	1.511	1.4188	1.4259	1.1/2	1.810	2.500	3.190	3.880	4.560		–
1.1/2 X 8	38.00	1.1/2	1.505	1.530	2.060	2.810	3.560	4.310	5.060	**1.1/2 X 8**	1.636	1.5438	1.5510	1.5/8	1.940	2.690	3.440	4.190	4.940		–
1.5/8 X 8	41.00	1.5/8	1.630	1.655	2.190	3.000	3.810	4.630	5.440	**1.5/8 X 8**	1.761	1.6688	1.6762	1.3/4	2.060	2.880	3.690	4.500	5.310		–
1.3/4 X 8	44.50	1.3/4	1.755	1.780	2.310	3.190	4.060	4.940	5.810	**1.3/4 X 8**	1.886	1.7938	1.8013	1.7/8	2.190	3.060	3.940	4.810	5.690		–
1.7/8 X 8	47.50	1.7/8	1.880	1.905	2.440	3.370	4.310	5.250	6.190	**1.7/8 X 8**	2.011	1.9188	1.9264	2	2.310	3.250	4.190	5.130	6.060		–
2 X 8	50.80	2	2.005	2.030	2.560	3.560	4.560	5.560	6.560	**2 X 8**	2.136	2.0438	2.0515	2.1/8	2.440	3.440	4.440	5.440	6.440		–

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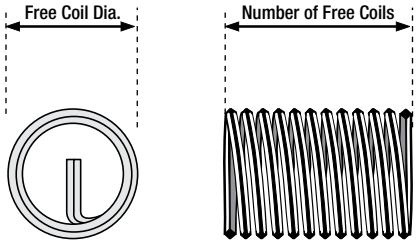
PowerCoil wire thread inserts can be manufactured to different standards upon request. Technical data on these standards can be obtained from our website – www.powercoil.com.au.



Nominal Thread Size	INSERT SPECIFICATIONS																		Nominal Thread Size
	Q Nominal Length – installed					Free Coil Diameter		Number of Free Coils ± 1/4 coil counted 90° from Tang											
	1D	1.5D	2D	2.5D	3D	Min	Max	1D		1.5D		2D		2.5D		3D			
	inch	inch	inch	inch	inch	inch	inch	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
BA																			**BA**
6BA	0.110	0.165	0.220	0.275	0.331	0.14	0.15	3.30	3.60	5.60	6.20	7.90	8.70	10.20	11.20	12.50	13.80		**6BA**
5BA	0.126	0.189	0.252	0.315	0.378	0.15	0.17	3.40	3.80	5.80	6.40	8.10	9.00	10.50	11.60	12.90	14.20		**5BA**
4BA	0.142	0.212	0.283	0.354	0.425	0.17	0.19	3.50	3.80	5.80	6.40	8.20	9.10	10.60	11.70	13.00	14.40		**4BA**
3BA	0.161	0.242	0.323	0.403	0.484	0.20	0.21	3.60	3.90	6.00	6.70	8.50	9.40	10.90	12.10	13.40	14.80		**3BA**
2BA	0.185	0.277	0.370	0.462	0.555	0.22	0.24	3.80	4.20	6.30	6.90	8.80	9.80	11.40	12.60	13.90	15.40		**2BA**
1BA	0.209	0.313	0.417	0.522	0.626	0.25	0.27	3.80	4.20	6.40	7.10	9.00	9.90	11.60	12.80	14.10	15.60		**1BA**
0BA	0.236	0.354	0.472	0.590	0.709	0.28	0.31	3.90	4.30	6.60	7.20	9.20	10.10	11.80	13.00	14.50	16.00		**0BA**
BSC																			**BSC**
3/16 X 32	0.187	0.281	0.375	0.469	0.562	0.23	0.26	3.70	4.10	6.20	6.90	8.70	9.70	11.20	12.50	13.70	15.30		**3/16 X 32**
1/4 X 26	0.250	0.375	0.500	0.625	0.750	0.31	0.34	4.10	4.60	6.90	7.60	9.60	10.70	12.30	13.80	15.10	16.80		**1/4 X 26**
5/16 X 26	0.312	0.469	0.625	0.781	0.937	0.37	0.41	5.50	6.20	9.00	10.00	12.50	13.90	16.00	17.80	19.40	21.60		**5/16 X 26**
3/8 X 26	0.375	0.562	0.750	0.937	1.125	0.43	0.48	7.00	7.80	11.20	12.40	15.40	17.10	19.60	21.70	23.80	26.40		**3/8 X 26**
7/16 X 26	0.437	0.656	0.875	1.094	1.312	0.50	0.55	8.40	9.40	13.40	14.80	18.30	20.30	23.30	25.80	28.20	31.20		**7/16 X 26**
1/2 X 26	0.500	0.750	1.000	1.250	1.500	0.56	0.61	9.90	11.00	15.60	17.20	21.20	23.50	26.90	29.80	32.60	36.00		**1/2 X 26**
9/16 X 26	0.562	0.844	1.125	1.406	1.687	0.62	0.68	11.40	12.60	17.80	19.70	24.20	26.70	30.50	33.80	36.90	40.90		**9/16 X 26**
5/8 X 26	0.625	0.937	1.250	1.562	1.875	0.69	0.75	12.80	14.20	19.90	22.00	27.10	29.90	34.20	37.80	41.30	45.70		**5/8 X 26**
3/4 X 26	0.750	1.125	1.500	1.875	2.250	0.81	0.89	15.70	17.40	24.30	26.90	32.90	36.30	41.50	45.80	50.10	55.30		**3/4 X 26**
1 X 24	1.000	1.500	2.000	2.500	3.000	1.07	1.17	19.80	21.80	30.40	33.50	41.00	45.30	51.60	57.00	62.20	68.70		**1 X 24**

Nominal Thread Size	INSERT SPECIFICATIONS																		Nominal Thread Size
	Q Nominal Length – installed					Free Coil Diameter		Number of Free Coils ± 1/4 coil counted 90° from Tang											
	1D	1.5D	2D	2.5D	3D	Min	Max	1D		1.5D		2D		2.5D		3D			
	inch	inch	inch	inch	inch	inch	inch	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
8-UN																			**8-UN**
1.1/8 X 8	1.125	1.688	2.250	2.81	3.38	1.25	1.30	7.10	7.50	11.50	12.00	15.80	16.60	20.10	21.10	24.50	25.60		**1.1/8 X 8**
1.1/4 X 8	1.250	1.875	2.500	3.13	3.75	1.39	1.43	8.10	8.30	12.90	13.30	17.70	18.30	22.60	23.30	27.40	28.20		**1.1/4 X 8**
1.3/8 X 8	1.375	2.062	2.750	3.44	4.13	1.52	1.57	9.00	9.30	14.30	14.80	19.60	20.20	24.90	25.70	30.20	31.20		**1.3/8 X 8**
1.1/2 X 8	1.500	2.250	3.000	3.75	4.50	1.65	1.69	10.00	10.30	15.80	16.20	21.50	22.20	27.30	28.10	33.10	34.10		**1.1/2 X 8**
1.5/8 X 8	1.625	2.438	3.250	4.06	4.88	1.78	1.90	10.50	11.20	16.40	17.70	22.40	24.10	28.40	30.50	34.30	37.00		**1.5/8 X 8**
1.3/4 X 8	1.750	2.625	3.500	4.38	5.25	1.90	2.04	11.40	12.20	17.80	19.20	24.20	26.10	30.70	33.00	37.10	39.90		**1.3/4 X 8**
1.7/8 X 8	1.875	2.812	3.750	4.69	5.63	2.03	2.16	12.40	13.20	19.30	20.60	26.20	28.10	33.20	35.50	40.10	42.90		**1.7/8 X 8**
2 X 8	2.000	3.000	4.000	5.00	6.00	2.16	2.28	13.40	14.20	20.90	22.10	28.40	30.00	35.90	38.00	43.30	45.90		**2 X 8**

General Information for MS/NAS Style – 303 CRES Inch and Metric Lokserts:

Insert Material: 303 CRES
Key Material: 302 CRES
Finish: Passivated
Insert Tolerances: ± .010 inch or ± .25mm unless otherwise specified
Internal Threads: Inch per SAE AS8879, Metric per Fed Std H28/21, MJ Form
Keys: Inserts with an internal thread size of 5/16 or M8 and greater have 4 locking keys. Smaller sizes have 2 locking keys.

Please note that all Inch inserts conform to:
• MIL-I-45914A • MS51830, MS51831 • NAS1394, NAS1395

There is no National Aerospace Standard for Metric keylocking Inserts manufactured from 303CRES. Sales drawings are available upon request.

General Information for Industrial Style Carbon Steel Lokserts:

Insert Material: C1215 or equivalent
Key Material: 302 CRES or equivalent
Finish: Zinc Phosphate
Insert Tolerances: ± .010 inch or ± .25 mm unless otherwise specified.
Internal Threads: Internal Inch 3B.
Internal Metric 5H.
Keys: Inserts with an internal thread size of 5/16 or M8 and greater have 4 locking keys. Smaller sizes have 2 locking keys.

Please note that there are no industry, MS or NAS specifications with respect to carbon steel keylocking thread inserts. Sales drawings are available upon request.

Internal Thread	INSERT SPECIFICATIONS			Internal Thread	DRILL, TAP & COUNTERSINK SPECIFICATIONS				Internal Thread	REMOVAL SPECIFICATIONS	
	External Thread	Q Nominal Length	Installation Tool		A Drill Size*	Tap Size Class 6H	T Minimum Tapping Depth	C Min. Width Countersink†		R1 Drill Size	R2 Minimum Drilling Depth
mm	mm	mm	Part #	mm	mm	mm	mm	mm	mm	mm	mm
THIN WALL				**THIN WALL**					**THIN WALL**		
M5 X 0.8	M8 X 1.25	8.0	3600-190T	**M5 X 0.8**	6.90	M8 X 1.25	9.50	8.25	**M5 X 0.8**	5.50	4.00
M6 X 1.0	M10 X 1.25	10.0	3600-250T	**M6 X 1.0**	8.80	M10 x 1.25	11.50	10.25	**M6 X 1.0**	7.50	4.75
M8 X 1.25	M12 x 1.25	12.0	3600-312T	**M8 X 1.25**	10.80	M12 x 1.25	13.50	12.25	**M8 X 1.25**	9.50	4.75
M8 X 1.0	M12 x 1.25	12.0	3600-312T	**M8 X 1.0**	10.80	M12 x 1.25	13.50	12.25	**M8 X 1.0**	9.50	4.75
M10 X 1.5	M14 x 1.5	14.0	3600-375T	**M10 X 1.5**	12.80	M14 x 1.5	15.50	14.25	**M10 X 1.5**	11.50	4.75
M10 X 1.25	M14 x 1.5	14.0	3600-375T	**M10 X 1.25**	12.80	M14 x 1.5	15.50	14.25	**M10 X 1.25**	11.50	4.75
M12 X 1.75	M16 x 1.5	16.0	3600-500T	**M12 X 1.75**	14.75	M16 x 1.5	17.50	16.25	**M12 X 1.75**	13.50	4.75
M12 X 1.25	M16 x 1.5	16.0	3600-500T	**M12 X 1.25**	14.75	M16 x 1.5	17.50	16.25	**M12 X 1.25**	13.50	4.75
HEAVY DUTY				**HEAVY DUTY**					**HEAVY DUTY**		
M4 X 0.7	M8 X 1.25	8.0	3600-4.00HT	**M4 X 0.7**	6.90	M8 X 1.25	9.50	8.25	**M4 X 0.7**	5.50	4.00
M5 X 0.8	M10 X 1.25	10.0	3600-190T	**M5 X 0.8**	8.80	M10 x 1.25	12.50	10.25	**M5 X 0.8**	7.50	4.75
M6 X 1.0	M12 x 1.25	12.0	3600-250T	**M6 X 1.0**	10.80	M12 x 1.25	14.50	12.25	**M6 X 1.0**	9.50	4.75
M8 X 1.25	M14 x 1.5	14.0	3600-312T	**M8 X 1.25**	12.80	M14 x 1.5	16.50	14.25	**M8 X 1.25**	11.50	4.75
M8 X 1.0	M14 x 1.5	14.0	3600-312T	**M8 X 1.0**	12.80	M14 x 1.5	16.50	14.25	**M8 X 1.0**	11.50	4.75
M10 X 1.5	M16 x 1.5	16.0	3600-375T	**M10 X 1.5**	14.75	M16 x 1.5	18.50	16.25	**M10 X 1.5**	13.50	4.75
M10 X 1.25	M16 x 1.5	16.0	3600-375T	**M10 X 1.25**	14.75	M16 x 1.5	18.50	16.25	**M10 X 1.25**	13.50	4.75
M12 X 1.75	M18 X 1.5	18.0	3600-500T	**M12 X 1.75**	16.75	M18 X 1.5	20.50	18.25	**M12 X 1.75**	15.50	4.75
M12 X 1.25	M18 X 1.5	18.0	3600-500T	**M12 X 1.25**	16.75	M18 X 1.5	20.50	18.25	**M12 X 1.25**	15.50	4.75
M14 X 2.0	M20 X 1.5	20.0	3600-14.00HT	**M14 X 2.0**	18.75	M20 X 1.5	22.50	20.25	**M14 X 2.0**	17.50	4.75
M14 X 1.5	M20 X 1.5	20.0	3600-14.00HT	**M14 X 1.5**	18.75	M20 X 1.5	22.50	20.25	**M14 X 1.5**	17.50	4.75
M16 X 2.0	M22 X 1.5	22.0	3600-625T	**M16 X 2.0**	20.50	M22 X 1.5	24.50	22.25	**M16 X 2.0**	17.75	6.35
M16 X 1.5	M22 X 1.5	22.0	3600-625T	**M16 X 1.5**	20.50	M22 X 1.5	24.50	22.25	**M16 X 1.5**	17.75	6.35
M18 X 1.5	M24 X 1.5	24.0	3600-18.00HT	**M18 X 1.5**	22.50	M24 X 1.5	26.50	24.25	**M18 X 1.5**	19.75	6.35
M20 X 2.5	M30 X 2.0	30.0	3600-875T	**M20 X 2.5**	28.00	M30 X 2.0	34.50	30.25	**M20 X 2.5**	25.75	6.35
M20 X 1.5	M30 X 2.0	30.0	3600-875T	**M20 X 1.5**	28.00	M30 X 2.0	34.50	30.25	**M20 X 1.5**	25.75	6.35
M22 X 1.5	M32 X 2.0	32.0	3600-22.00HT	**M22 X 1.5**	30.00	M32 X 2.0	36.50	32.25	**M22 X 1.5**	27.75	6.35
M24 X 3.0	M33 X 2.0	33.0	3600-24.00HT	**M24 X 3.0**	31.00	M33 X 2.0	37.50	33.25	**M24 X 3.0**	28.75	6.35
M24 X 2.0	M33 X 2.0	33.0	3600-24.00HT	**M24 X 2.0**	31.00	M33 X 2.0	37.50	33.25	**M24 X 2.0**	28.75	6.35

*** Drill Size**

Tapping Drill Tolerance:
Metric 6.90-10.80mm +0.100-0.025mm
Metric over 12.80mm +0.130-0.025mm
Inch 0.234-0.500" +0.004-0.001"
Inch over 0.500" +0.005-0.001"

† Countersink Diameter

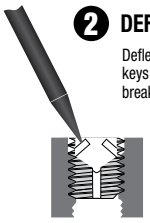
Countersink Tolerance:
Metric +0.250-0.000mm
Inch +0.010-0.000"

loksert® REMOVAL

1 DRILL

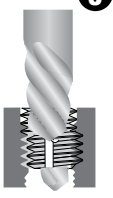
Drill out the material between the locking keys and the internal thread to the specified depth.

Note: Drill size and drilling depth are shown in the loksert technical tables.



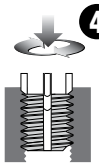
2 DEFLECT

Deflect locking keys inward and break off



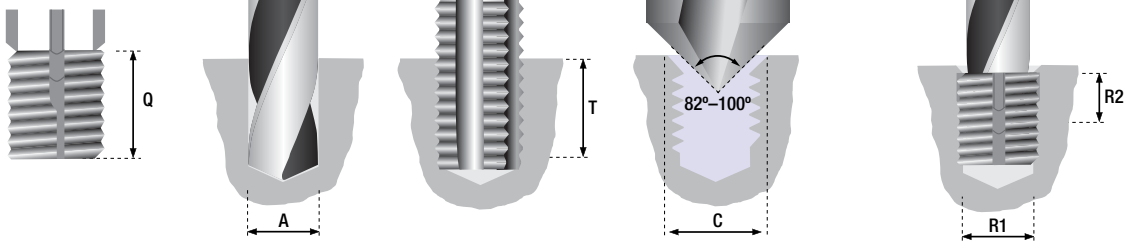
3 REMOVE

Remove the insert from the hole by winding it out using a screw extractor or similar type tool.



4 INSERT

A new loksert insert of exactly the same size can be installed in the original hole.



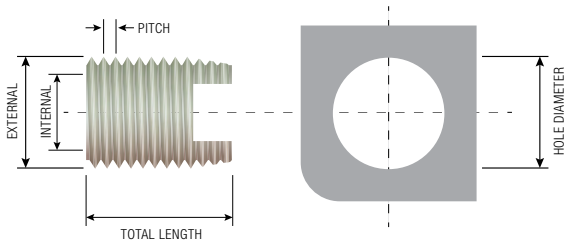
Internal Thread	INSERT SPECIFICATIONS			Internal Thread	DRILL, TAP & COUNTERSINK SPECIFICATIONS				Internal Thread	REMOVAL SPECIFICATIONS	
	External Thread	Q Nominal Length	Installation Tool		A Drill Size*	Tap Size Class 2B	T Minimum Tapping Depth	C Min. Width Countersink†		R1 Drill Size	R2 Minimum Drilling Depth
inch	inch	inch	Part #	inch	inch	inch	inch	inch	inch	inch	inch
THIN WALL				**THIN WALL**					**THIN WALL**		
10G X 24	5/16 X 18	0.31	3600-190T	**10G X 24**	"I"	5/16 X 18	0.37	0.32	**10G X 24**	7/32	1/8
10G X 32	5/16 X 18	0.31	3600-190T	**10G X 32**	"I"	5/16 X 18	0.37	0.32	**10G X 32**	7/32	1/8
1/4 X 20	3/8 X 16	0.37	3600-250T	**1/4 X 20**	"Q"	3/8 X 16	0.43	0.38	**1/4 X 20**	9/32	3/16
1/4 X 28	3/8 X 16	0.37	3600-250T	**1/4 X 28**	"Q"	3/8 X 16	0.43	0.38	**1/4 X 28**	9/32	3/16
5/16 X 18	7/16 X 14	0.43	3600-312T	**5/16 X 18**	"X"	7/16 X 14	0.50	0.44	**5/16 X 18**	11/32	3/16
5/16 X 24	7/16 X 14	0.43	3600-312T	**5/16 X 24**	"X"	7/16 X 14	0.50	0.44	**5/16 X 24**	11/32	3/16
3/8 X 16	1/2 X 13	0.50	3600-375T	**3/8 X 16**	29/64	1/2 X 13	0.56	0.51	**3/8 X 16**	13/32	3/16
3/8 X 24	1/2 X 13	0.50	3600-375T	**3/8 X 24**	29/64	1/2 X 13	0.56	0.51	**3/8 X 24**	13/32	3/16
7/16 X 14	9/16 X 12	0.56	3600-375T	**7/16 X 14**	33/64	9/16 X 12	0.62	0.57	**7/16 X 14**	15/32	3/16
7/16 X 20	9/16 X 12	0.56	3600-375T	**7/16 X 20**	33/64	9/16 X 12	0.62	0.57	**7/16 X 20**	15/32	3/16
1/2 X 13	5/8 X 11	0.62	3600-500T	**1/2 X 13**	37/64	5/8 X 11	0.68	0.63	**1/2 X 13**	17/32	3/16
1/2 X 20	5/8 X 11	0.62	3600-500T	**1/2 X 20**	37/64	5/8 X 11	0.68	0.63	**1/2 X 20**	17/32	3/16
HEAVY DUTY				**HEAVY DUTY**					**HEAVY DUTY**		
8G X 32	5/16 X 18	0.31	3600-8GHT	**8G X 32**	"I"	5/16 X 18	0.37	0.32	**8G X 32**	7/32	1/8
10G X 24	3/8 X 16	0.31	3600-190T	**10G X 24**	"Q"	3/8 X 16	0.37	0.38	**10G X 24**	9/32	1/8
10G X 32	3/8 X 16	0.31	3600-190T	**10G X 32**	"Q"	3/8 X 16	0.37	0.38	**10G X 32**	9/32	1/8
1/4 X 20	7/16 X 14	0.37	3600-250T	**1/4 X 20**	"X"	7/16 X 14	0.43	0.44	**1/4 X 20**	11/32	3/16
1/4 X 28	7/16 X 14	0.37	3600-250T	**1/4 X 28**	"X"	7/16 X 14	0.43	0.44	**1/4 X 28**	11/32	3/16
5/16 X 18	1/2 X 13	0.43	3600-312T	**5/16 X 18**	29/64	1/2 X 13	0.50	0.51	**5/16 X 18**	13/32	3/16
5/16 X 24	1/2 X 13	0.43	3600-312T	**5/16 X 24**	29/64	1/2 X 13	0.50	0.51	**5/16 X 24**	13/32	3/16
3/8 X 16	9/16 X 12	0.50	3600-375T	**3/8 X 16**	33/64	9/16 X 12	0.56	0.57	**3/8 X 16**	15/32	3/16
3/8 X 24	9/16 X 12	0.50	3600-375T	**3/8 X 24**	33/64	9/16 X 12	0.56	0.57	**3/8 X 24**	15/32	3/16
7/16 X 14	5/8 X 11	0.62	3600-375T	**7/16 X 14**	37/64	5/8 X 11	0.68	0.63	**7/16 X 14**	17/32	3/16
7/16 X 20	5/8 X 11	0.62	3600-375T	**7/16 X 20**	37/64	5/8 X 11	0.68	0.63	**7/16 X 20**	17/32	3/16
1/2 X 13	3/4 X 16	0.62	3600-500T	**1/2 X 13**	45/64	3/4 X 16	0.68	0.76	**1/2 X 13**	21/32	3/16
1/2 X 20	3/4 X 16	0.62	3600-500T	**1/2 X 20**	45/64	3/4 X 16	0.68	0.76	**1/2 X 20**	21/32	3/16
9/16 X 12	3/4 X 16	0.81	3600-500T	**9/16 X 12**	45/64	3/4 X 16	0.94	0.76	**9/16 X 12**	21/32	3/16
9/16 X 18	3/4 X 16	0.81	3600-500T	**9/16 X 18**	45/64	3/4 X 16	0.94	0.76	**9/16 X 18**	21/32	3/16
5/8 X 11	7/8 X 14	0.87	3600-625T	**5/8 X 11**	53/64	7/8 X 14	1.00	0.88	**5/8 X 11**	25/32	5/16
5/8 X 18	7/8 X 14	0.87	3600-625T	**5/8 X 18**	53/64	7/8 X 14	1.00	0.88	**5/8 X 18**	25/32	5/16
3/4 X 10	1-1/8 X 12	1.12	3600-875T	**3/4 X 10**	1-1/16	1-1/8 X 12	1.31	1.14	**3/4 X 10**	31/32	5/16
3/4 X 16	1-1/8 X 12	1.12	3600-875T	**3/4 X 16**	1-1/16	1-1/8 X 12	1.31	1.14	**3/4 X 16**	31/32	5/16
7/8 X 9	1-1/4 X 12	1.25	3600-875T	**7/8 X 9**	1-3/16	1-1/4 X 12	1.44	1.27	**7/8 X 9**	1-3/32	5/16
7/8 X 14	1-1/4 X 12	1.25	3600-875T	**7/8 X 14**	1-3/16	1-1/4 X 12	1.44	1.27	**7/8 X 14**	1-3/32	5/16
1 X 8	1-3/8 X 12	1.37	3600-100T	**1 X 8**	1-5/16	1-3/8 X 12	1.56	1.39	**1 X 8**	1-7/32	5/16
1 X 12	1-3/8 X 12	1.37	3600-100T	**1 X 12**	1-5/16	1-3/8 X 12	1.56	1.39	**1 X 12**	1-7/32	5/16
1 X 14	1-3/8 X 12	1.37	3600-100T	**1 X 14**	1-5/16	1-3/8 X 12	1.56	1.39	**1 X 14**	1-7/32	5/16
1-1/8 X 7	1-1/2 X 12	1.62	3600-1.1/8HT	**1-1/8 X 7**	1-7/16	1-1/2 X 12	1.84	1.52	**1-1/8 X 7**	1-11/32	5/16
1-1/8 X 12	1-1/2 X 12	1.62	3600-1.1/8HT	**1-1/8 X 12**	1-7/16	1-1/2 X 12	1.84	1.52	**1-1/8 X 12**	1-11/32	5/16
1-1/4 X 7	1-5/8 X 12	1.81	3600-1.1/4HT	**1-1/4 X 7**	1-9/16	1-5/8 X 12	2.06	1.64	**1-1/4 X 7**	1-15/32	5/16
1-1/4 X 12	1-5/8 X 12	1.81	3600-1.1/4HT	**1-1/4 X 12**	1-9/16	1-5/8 X 12	2.06	1.64	**1-1/4 X 12**	1-15/32	5/16
1-1/2 X 6	1-7/8 X 12	2.00	3600-1.1/2HT	**1-1/2 X 6**	1-13/16	1-7/8 X 12	2.28	1.89	**1-1/2 X 6**	1-23/32	5/16
1-1/2 X 12	1-7/8 X 12	2.00	3600-1.1/2HT	**1-1/2 X 12**	1-13/16	1-7/8 X 12	2.28	1.89	**1-1/2 X 12**	1-23/32	5/16

*** Drill Size**

Tapping Drill Tolerance:
Metric 6.90-10.80mm +0.100-0.025mm
Metric over 12.80mm +0.130-0.025mm
Inch 0.234-0.500" +0.004-0.001"
Inch over 0.500" +0.005-0.001"

† Countersink Diameter

Countersink Tolerance: Metric +0.250-0.000mm
Inch +0.010-0.000"



Tapserts are self cutting threaded inserts that feature both external and internal threads. They are driven into a pre-formed or pre-drilled retaining hole and the cutting slots (or cutting bores) effectively tap the hole as the insert is wound into the parent material.

Tapserts are ideal for use in low shear strength materials (such as alloys, plastics and castings) which require threaded seats with high load capacity and wear resistance.

Tapserts feature:

- High pull-out strength
- High loading capacity in low shear strength materials
- Wear free, vibration resistant screw joint
- Pre-cast or pre-drilled holes with standard tolerance
- No requirement for thread tapping tools
- Retains and captures chips from installation in chipping reservoirs.

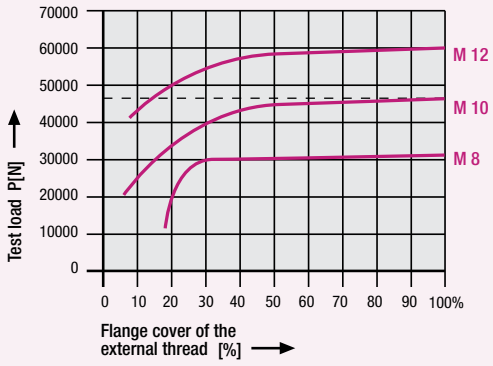
HOLE PREPARATION

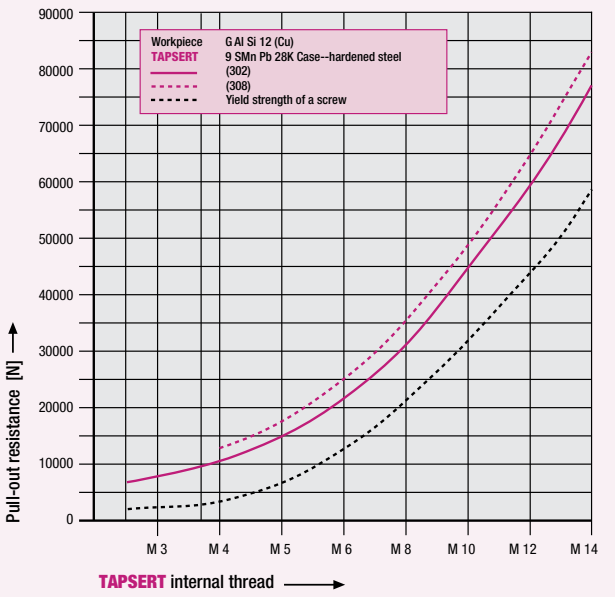
The receiving hole is drilled or pre-cast in the parent material. Generally there is no requirement to countersink the hole but it is recommended care is taken not to warp the workpiece surface when installing the insert. Tapserts must be installed at least 0.1-0.2mm below the assembly surface.

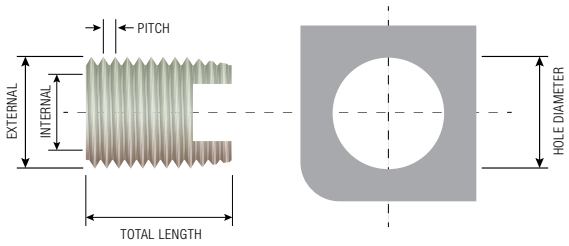
- The length of the Tapsert MUST NOT exceed the thickness of the parent material.
- The minimum hole depth is indicated in the data tables included in every kit. Alternatively these may be downloaded from the website www.powercoil.com.au
- The minimum wall thickness of the assembly is dependant on the maximum insert loads and the elasticity of the parent material.
- Detailed hole diameter information is shown on the installation leaflet included with every kit and is also available at www.powercoil.com.au. As a general guide hard materials require a larger diameter hole than softer, elastic materials. If the installed insert is being subjected to high loads it is recommended to perform material specific testing prior to production.

INSTALLATION NUT & BOLT

Screw the insert onto the bolt and nut assembly ensuring the slot side is pointing downward. Thread the nut down the bolt until it sits firmly against the top of the Tapsert. Ensure that the Tapsert is perpendicular to the workpiece and apply downward pressure on the installation assembly. Turn the bolt head to wind the Tapsert into the receiving hole. The tapsert is installed when the nut is flush with the top of the parent material. Loosen the nut and wind the assembly out of the Tapsert. Complete instructions are included in every Tapsert kit.







			DRILL SIZE SELECTION				
	Light Alloys Rm = tensile strength N/mm²		Rm<250	Rm<300	Rm<350	Rm>350	Minimum drill hole depth for blind holes
	MS, Bronze, NF Metal					Rm>350	
	Cast Iron HB = Brinell hardness N/mm²		<150 HB	<200 HB	>200 HB		
INTERNAL THREAD	EXT. THREAD	LENGTH	MM	MM	MM	MM	MM
M 2.5 - 0.45	M 4.5 - 0.5	6	–	4.1	4.2	**4.3**	8
M 3.0 - 0.6	M 5 - 0.5	6	–	4.6	4.7	**4.8**	8
M 4 - 0.7	M 6.5 - 0.75	8	5.9	6.0	6.1	**6.2**	10
M 5 - 0.8	M 8 - 1.0	10	7.2	7.3	7.5	**7.6**	13
M 6 - 1.0	M 10 - 1.5	14	8.8	9.0	9.2	**9.4**	17
M 8 - 1.25	M 12 - 1.5	15	10.8	11.0	11.2	**11.4**	18
M 10 - 1.5	M 14 - 1.5	18	12.8	13.0	13.2	**13.4**	22
M 12 - 1.75	M 16 - 1.5	22	14.8	15.0	15.2	**15.4**	26
M 16 - 2.0	M 20 - 1.5	22	18.8	19.0	19.2	**19.4**	27
M 16 - 1.5	M 20 - 1.5	22	18.8	19.0	19.2	**19.4**	27
M 18 - 2.5	M 22 - 1.5	24	20.8	21.0	21.2	**21.4**	29
M 20 - 2.5	M 26 - 1.5	27	24.8	25.0	25.2	**25.4**	32
M 22 - 2.5	M 26 - 1.5	30	24.8	25.0	25.2	**25.4**	36
M 24 - 3.0	M 30 - 1.5	30	28.8	29.0	29.2	**29.4**	36
M 14 - 1.25 Spark Plug	M 18 - 1.5	15	16.8	17.0	17.2	**17.4**	28
M 14 - 1.25 Spark Plug	M 18 - 1.5	9	16.8	17.0	17.2	**17.4**	28
M 14 - 1.25 Spark Plug	M 18 - 1.5	9 & 15	16.8	17.0	17.2	**17.4**	28
UNC 1/4 - 20	M 10 - 1.5	14	8.8	9.0	9.2	**9.4**	17
UNC 5/16 - 18	M 12 - 1.5	15	10.8	11.0	11.2	**11.4**	18
UNC 3/8 - 16	M 14 - 1.5	18	12.8	13.0	13.2	**13.4**	22
UNC 7/16 - 14	M 16 - 1.5	22	14.8	15.0	15.2	**15.4**	26
UNC 1/2 - 13	M 18 - 1.5	22	16.8	17.0	17.2	**17.4**	28
UNC 5/8 - 11	M 20 - 1.5	22	18.8	19.0	19.2	**19.4**	27
UNF 1/4 - 28	M 10 - 1.5	14	8.8	9.0	9.2	**9.4**	17
UNF 5/16 - 24	M 12 - 1.5	15	10.8	11.0	11.2	**11.4**	18
UNF 3/8 - 24	M 14 - 1.5	18	12.8	13.0	13.2	**13.4**	22
UNF 7/16 - 20	M 16 - 1.5	22	14.8	15.0	15.2	**15.4**	26
UNF 1/2 - 20	M 18 - 1.5	22	16.8	17.0	17.2	**17.4**	28
UNF 5/8 - 18	M 20 - 1.5	22	18.8	19.0	19.2	**19.4**	27

DRILL HOLE DIAMETER

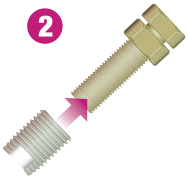
Brittle, tough, and hard materials require a larger drill hole than soft and elastic materials. For recommended hole sizes see table above. The drill sizes in bold are the recommended diameter for easy assembly. Smaller diameters may require the use of cutting fluid during installation. When specific load performance is required we advise insert/material testing.

tapsert® INSTALLATION

1

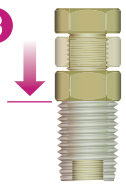
Drill hole to recommended size as shown in the selection table.

2



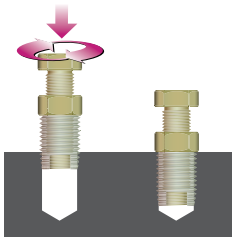
Thread the Tapsert on to the bolt ensuring the slot side is down. The insert should be flush with the end of the bolt.

3



Thread the nut down the bolt until it sits firmly against the top of the Tapsert.

4

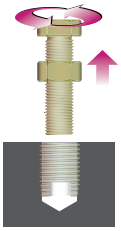


To ensure the Tapsert installation is straight apply downward pressure on the assembly.

If using an open ended wrench apply downward pressure to the bolt head whilst turning the nut to wind the Tapsert in. Alternatively if using a socket for installation apply downward pressure to the socket.

The Tapsert is installed when the nut is flush with the top of the parent material.

5



Loosen the nut with an open ended wrench and wind the nut and bolt assembly out of the Tapsert.

Congratulations – you have successfully created a new thread.

NOTE Tapping fluid should be used to aid installation.

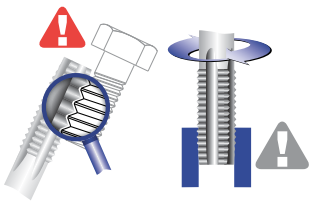
BORDO® INDUSTRIAL TOOLS

powercoil® INSTALLATION

1 DRILL

Drill to clear the damaged thread with a standard twist drill. Thread Repair Kits up to M12 (1/2") include the correct size drill. The required tapping drill size is shown on the front of the kit, bag or clam shell pack.

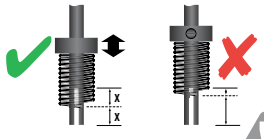
Note: Spark Plug inserts utilise a pilot nose tap which does not require pre-drilling.



2 TAP

Use the specified tap to cut the holding thread into the cleared hole. When tapping a hole, it is recommended to use a suitable cutting lubricant.

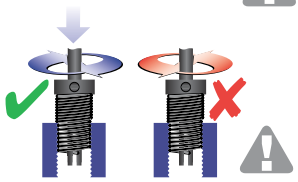
Note: Wire Thread inserts require the use of STI taps which are slightly oversize to provide the correct hole diameter. Always check that the thread and pitch of the tap are the same as the bolt or spark plug you wish to insert into the finished hole.



3 INSERT

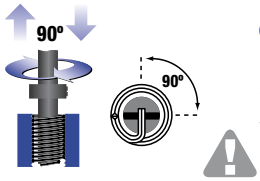
Loosen the grub screw and slide the collar along the insert tool shaft so that the tang on the insert is positioned half way up the insert tool slot.

Note: Do not position tang at the very top or bottom of the insert tool slot.



Use the installation tool to wind the insert into the threaded hole using light downward pressure until half a turn below the surface.

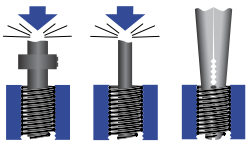
Note: Do not work against the thread direction as the tang may break off.



4 SNAP

Lift installation tool, rotate 90° and tap down sharply to break off wire thread insert tang. Use the tang break off tool to perform this function where supplied.

Note: For spark plug and large inserts use long nose pliers to remove the tang.



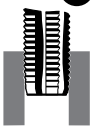
You have succesfully repaired your damaged thread. The new thread is normally stronger than the original.

loksert INSTALLATION

1 DRILL

Drill to clear the damaged thread with a standard twist drill. Chamfer the hole with a standard countersink (82° - 100°)

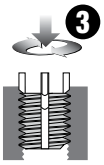
Note: Drill is oversize to accomodate external thread. Check technical charts for correct drill sizes.



2 TAP

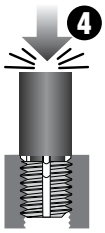
Create new thread using a standard tap. Check technical charts for correct tap size.

Note: Use of a suitable lubricant is essential during all tapping procedures.



3 INSERT

Screw the insert into the threaded hole until slightly below the surface of the parent material.

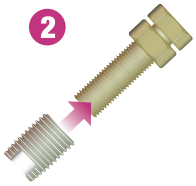


4 DRIVE

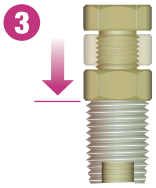
Select the correct size installation tool and place over the insert. Drive locking keys down using several hammer taps on end of installation tool.

tapsert® INSTALLATION

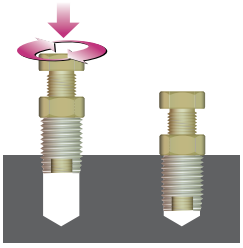
Drill hole to recommended size as shown in the selection table.



Thread the Tapsert on to the bolt ensuring the slot side is down. The insert should be flush with the end of the bolt.



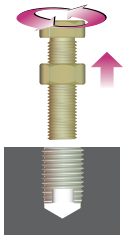
Thread the nut down the bolt until it sits firmly against the top of the Tapsert.



To ensure the Tapsert installation is straight apply downward pressure on the assembly.

If using an open ended wrench apply downward pressure to the bolt head whilst turning the nut to wind the Tapsert in. Alternatively if using a socket for installation apply downward pressure to the socket.

The Tapsert is installed when the nut is flush with the top of the parent material.



Loosen the nut with an open ended wrench and wind the nut and bolt assembly out of the Tapsert.

Congratulations – you have successfully created a new thread.

NOTE Tapping fluid should be used to aid installation.

powercoil®

wire thread insert system

BORDO®

INDUSTRIAL TOOLS

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