

THREDSHAVER CUTTING TAP DRILL SIZES

THREDSHAVERS – MACHINE SCREW AND FRACTIONAL

SIZE	THEORETICAL HOLE SIZES FOR				CLASS 2B				CLASS 3B				UNJ3B			
	85% THREAD	75% THREAD	65% THREAD	55% THREAD	MINOR DIAMETER		RECOMMENDED DRILL SIZE		MINOR DIAMETER		RECOMMENDED DRIELL SIZE		MINOR DIAMETER		RECOMMENDED DRIELL SIZE	
					MIN	MAX			MIN	MAX			MIN	MAX		
2-56	.066	.069	.071	.073	.0667	.0737	#50 (.070)		.0667	.0737	#50 (.070)		.0686	.0732	#50 (.070)	
2-64	.069	.071	.073	.075	.0691	.0753	#50 (.070)		.0691	.0753	#50 (.070)		.0708	.0749	#49 (.073)	
3-48	.076	.079	.081	.084	.0764	.0845	#47 (.0785)		.0764	.0845	#47 (.0785)		.0787	.0841	#45 (.082)	
3-56	.079	.082	.084	.086	.0797	.0865	#45 (.082)		.0797	.0865	#45 (.082)		.0816	.0862	2.15mm (.0846)	
4-40	.084	.088	.091	.094	.0849	.0939	#43 (.089)		.0849	.0939	#43 (.089)		.0877	.0942	2.35mm (.0925)	
4-48	.089	.092	.094	.097	.0894	.0968	#42 (.0935)		.0894	.0968	#42 (.0935)		.0917	.0971	3/32 (.0938)	
5-40	.097	.101	.104	.107	.0979	.1062	#38 (.1015)		.0979	.1020	#38 (.1015)		.1007	.1072	#37 (.104)	
5-44	.100	.103	.106	.109	.1004	.1079	#37 (.104)		.1004	.1079	#37 (.104)		.1029	.1088	#36 (.1065)	
6-32	.103	.108	.112	.116	.104	.114	#35 (.110)		.1040	.1140	#35 (.110)		.1076	.1157	#33 (.113)	
6-40	.110	.114	.117	.120	.111	.119	#33 (.113)		.1110	.1186	#33 (.113)		.1137	.1202	#32 (.116)	
8-32	.129	.134	.138	.142	.130	.139	#29 (.136)		.1300	.1389	#29 (.136)		.1336	.1417	#29 (.136)	
8-36	.133	.137	.141	.144	.134	.142	#29 (.136)		.1340	.1416	#29 (.136)		.1370	.1442	#28 (.1405)	
10-24	.144	.149	.155	.160	.145	.156	#24 (.152)		.1450	.1555	#24 (.152)		.1494	.1600	#23 (.154)	
10-32	.155	.160	.164	.168	.156	.164	#20 (.161)		.1560	.1641	#20 (.161)		.1596	.1675	#20 (.161)	
12-24	.170	.175	.181	.186	.171	.181	#16 (.177)		.1710	.1807	#16 (.177)		.1754	.1852	#15 (.180)	
12-28	.177	.181	.186	.190	.177	.186	#14 (.182)		.1770	.1857	#14 (.182)		.1812	.1896	#13 (.185)	
1/4-20	.195	.201	.208	.214	.196	.207	13/64 (.2031)		.1960	.2067	13/64 (.2031)		.2013	.2121	#5 (.2055)	
1/4-28	.211	.215	.220	.224	.211	.220	5.5mm (.2165)		.2110	.2190	5.5mm (.2165)		.2152	.2229	7/32 (.2188)	
5/16-18	.251	.258	.266	.273	.252	.265	G (.261)		.2520	.2630	F (.257)		.2584	.2690	G (.261)	
5/16-24	.266	.272	.277	.283	.267	.277	I (.272)		.2670	.2754	I (.272)		.2719	.2799	I (.272)	
3/8-16	.306	.314	.322	.330	.307	.321	O (.316)		.3070	.3182	5/16 (.3125)		.3141	.3250	O (.316)	
3/8-24	.329	.334	.340	.345	.330	.340	Q (.332)		.3300	.3372	Q (.332)		.3344	.3417	8.5mm (.3346)	
7/16-14	.359	.368	.377	.386	.360	.376	U (.368)		.3600	.3717	U (.368)		.3680	.3795	3/8 (.375)	
7/16-20	.382	.389	.395	.402	.383	.395	25/64 (.3906)		.3830	.3916	W (.386)		.3888	.3970	25/64 (.3906)	
1/2-13	.415	.425	.435	.445	.417	.434	27/64 (.4219)		.4170	.4284	27/64 (.4219)		.4251	.4368	11mm (.433)	
1/2-20	.445	.451	.458	.464	.446	.457	29/64 (.4531)		.4460	.4537	11.4mm (.4488)		.4513	.4591	29/64 (.4531)	
9/16-12	.470	.481	.492	.503	.472	.490	31/64 (.4844)		.4720	.4843	12.1mm (.4763)		.4814	.4914	31/64 (.4844)	
9/16-18	.501	.508	.516	.523	.502	.515	13mm (.5118)		.5020	.5106	12.9mm (.5079)		.5084	.5166	33/64 (.5156)	
5/8-11	.525	.536	.548	.560	.527	.546	17/32 (.5312)		.5270	.5391	17/32 (.5312)		.5365	.5474	13.7mm (.5394)	
5/8-18	.564	.571	.578	.585	.565	.578	14.5mm (.5709)		.5650	.5730	14.5mm (.5709)		.5709	.5788	14.5mm (.5709)	
3/4-10	.639	.652	.665	.678	.642	.663	21/32 (.6562)		.6420	.6545	16.5mm (.6496)		.6526	.6646	21/32 (.6562)	
3/4-16	.681	.689	.697	.705	.682	.696	11/16 (.6875)		.6820	.6908	11/16 (.6875)		.6892	.6977	17.5mm (.689)	
7/8-9	.752	.767	.781	.796	.755	.778	49/64 (.7656)		.7550	.7681	49/64 (.7656)		.7668	.7801	19.6mm (.7716)	
7/8-14	.796	.805	.815	.824	.798	.814	13/16 (.8125)		.7980	.8068	2.4mm (.8031)		.8055	.8152	13/16 (.8125)	
1-8	.862	.878	.894	.911	.865	.890	7/8 (.875)		.8650	.8797	7/8 (.875)		.8783	.8933	57/64 (.8906)	
1-12	.908	.919	.930	.940	.910	.928	59/64 (.9219)		.9100	.9198	23.2mm (.9134)		.9189	.9289	23.5mm (.9252)	