

THREDFLOER HOLE SIZE AND CLASS OF FIT – CONTINUED

THREDFLOERS – METRIC

SIZE	HOLE SIZES REQUIRED FOR 6H TOLERANCE			TAP DRILL SIZE	HOLE SIZES REQUIRED FOR 4H TOLERANCE			TAP DRILL SIZE	STOCK "D" NUMBER PER CLASS OF FIT	
	75% THREAD	65% THREAD	55% THREAD		75% THREAD	65% THREAD	55% THREAD		6H TOLERANCE	4H TOLERANCE
M1.6 X .35	.057	.058	.059	1.45 mm	.056	.057	.058	#54	D5	D3
M1.7 X .35	.061	.062	.063	1.55 mm	.060	.061	.062	#53	D5	D3
M2 X .4	.072	.073	.074	1.85 mm	.071	.072	.073	1.80 mm	D5	D3
M2.5 X .45	.091	.092	.093	2.30 mm	.089	.090	.091	#43	D6	D3
M2.6 X .45	.095	.096	.097	2.40 mm	.093	.094	.095	2.35 mm	D6	D3
M3 X .5	.110	.111	.112	#35	.108	.109	.110	2.75 mm	D6	D3
M3.5 X .6	.128	.129	.130	#30	.126	.127	.128	3.2 mm	D7	D4
M4 X .7	.145	.146	.148	3.7 mm	.144	.145	.147	#27	D7	D4
M5 X .8	.183	.184	.185	#14	.181	.182	.184	4.6 mm	D8	D4
M6 X 1	.218	.220	.222	5.5 mm	.216	.218	.220	5.5 mm	D9	D5
M8 X 1.25	.291	.294	.296	7.4 mm	.289	.291	.294	7.3 mm	D10	D5
M10 X 1	.375	.377	.379	9.5 mm	.373	.375	.377	9.5 mm	D9	D5
M10 X 1.25	.370	.373	.375	9.4 mm	.368	.370	.373	9.3 mm	D10	D5
M10 X 1.5	.365	.368	.371	9.3 mm	.362	.365	.368	9.2 mm	D11	D6
M12 X 1.75	.439	.442	.446	7/16"	.436	.439	.443	11.0 mm	D12	D6
M14 X 1.25	.527	.530	.532	13.4 mm	.525	.528	.530	13.3 mm	D10	D5
M14 X 1.5	.522	.525	.528	13.3 mm	.519	.522	.525	13.2 mm	D11	D6
M14 X 2	.512	.516	.520	13.0 mm	.509	.513	.517	12.9 mm	D14	D7
M16 X 1.5	.601	.604	.607	15.3 mm	.598	.601	.604	15.2 mm	D11	D6
M16 X 2	.591	.595	.599	15.0 mm	.588	.592	.596	14.9 mm	D14	D7
M18 X 1.5	.680	.683	.686	17.3 mm	.677	.680	.683	17.2 mm	D11	D6

STI THREDFLOERS – MACHINE SCREW AND FRACTIONAL SIZE

STI THREAD SIZE	HOLE SIZES REQUIRED FOR				TAP DRILL SIZE	"H" NUMBER PER CLASS OF FIT		BLANK SIZE
	85% THREAD	75% THREAD	65% THREAD	55% THREAD		2B	3B	
2-56	.099	.100	.101	.102	#39	2	2	#5
4-40	.130	.131	.132	.134	3.3 mm	3, 2	2	#8
6-32	.161	.162	.163	.165	4.1 mm	3, 2	2	#10
8-32	.187	.188	.189	.191	3/16	3, 2	2	#12
10-24	.221	.222	.224	.226	#2	4, 3	3, 2	1/4
10-32	.213	.214	.215	.217	#3	4, 3	3, 2	1/4
1/4-20	.287	.288	.290	.293	7.3 mm	4, 3	3, 2	5/16
1/4-28	.276	.278	.279	.281	J	4, 3	3, 2	5/16
5/16-18	.353	.355	.357	.360	9.0 mm	5, 4	4, 3	7/16
3/8-16	.420	.422	.425	.428	27/64"	5, 4	4, 3	1/2

STI THREDFLOERS – METRIC

STI THREAD SIZE	HOLE SIZES REQUIRED FOR				TAP DRILL SIZE	"D" NUMBER PER CLASS OF FIT		BLANK SIZE
	85% THREAD	75% THREAD	65% THREAD	55% THREAD		5H	4H	
M2 X .4	.091	.091	.092	.093	2.3 mm	D3	D2	#4
M2.5 X .45	.112	.112	.113	.114	#34	D3	D2	#5
M3 X .5	.133	.133	.134	.135	3.4 mm	D3	D2	#8
M3.5 X .6	.156	.157	.158	.159	#22	D4	D3	#10
M4 X .7	.178	.179	.180	.182	#15	D4	D3	#10
M5 X .8	.220	.221	.223	.225	#2	D4	D3	1/4
M6 X 1.0	.266	.267	.269	.271	6.8 mm	D5	D4	5/16
M8 X 1.25	.352	.353	.355	.358	9 mm	D6	D5	3/8