

# 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        |