

THREDFLOER HOLE SIZE AND CLASS OF FIT

The following table gives the hole size for three thread percentages when used with the recommended "H" or "D" numbers. The largest "H" or "D" numbers will place the finished thread pitch diameter .0005 to .0010 under the "NO-GO" P.D. limit. They will also provide the longest tap life before the tap wears under size. For a slightly tighter fit, the smaller recommended "H" or "D" numbers may be used.



THREDFLOERS – MACHINE SCREW AND FRACTIONAL SIZE

SIZE	THREADS PER INCH		HOLE SIZES REQUIRED FOR:			TAP DRILL SIZE (65% THREAD)	"H" NUMBER PER CLASS OF FIT			STOCK "H" NUMBER
	NC UNC	NF UNF	75% THREAD	65% THREAD	55% THREAD		2B	3B	2	
000		120	.0303	.0307	.0311	#68	-	-	-	2
00	90		.0417	.0422	.0426	#58	-	-	-	2
		96	.0420	.0425	.0430	#58	-	-	-	
0		80	.0546	.0552	.0558	#54 OR 1.4 mm*	3, 2	2	2	2, 3, 4, 5, 6, 7
1	64		.066	.067	.068	#51 OR 1.7 mm	4, 3	3, 2	3, 2	
		72	.067	.068	.069	#51 OR 1.75 mm	4, 3	3, 2	3, 2	
2	56		.078	.079	.080	#47 OR 2.0 mm	4, 3	3, 2	3, 2	
		64	.079	.080	.081	2.0 mm*	4, 3	3, 2	3, 2	
3	48		.090	.091	.092	2.3 mm*	5, 4	3, 2	3, 2	
		56	.091	.092	.093	2.3 mm*	5, 4	3, 2	3, 2	
4	40		.100	.101	.103	#39	5, 4	4, 3	4, 3	
		48	.103	.104	.105	#37	5, 4	4, 3	3, 2	
5	40		.113	.114	.116	#33 OR 2.9 mm	5, 4	4, 3	4, 3	
		44	.114	.115	.117	#33 OR 2.9 mm	5, 4	4, 3	4, 3	
6	32		.124	.125	.126	3.1 mm	6, 5	4, 3	5, 4	
		40	.126	.127	.128	1/8" OR 3.2 mm*	5, 4	4, 3	4, 3	
8	32		.149	.150	.152	#25 OR 3.8 mm	6, 5	4, 3	4, 3	
		36	.151	.152	.153	#24	5, 4	4, 3	3, 2	
10	24		.170	.172	.174	11/64"	7, 6, 5	5, 4	5, 4	
		32	.175	.176	.178	#16 OR .176**	6, 5	4, 3	4, 3	
12	24		.196	.198	.200	#9 OR 5.0 mm	7, 6, 5	5, 4	5, 4	
		28	.199	.201	.203	#7 OR 5.1 mm	7, 6, 5	4, 3	4, 3	
1/4"	20		.225	.227	.230	5.75 mm*	8, 7, 6	5, 4	5, 4	
		28	.233	.235	.237	"A"	7, 6, 5	5, 4	4, 3	
5/16"	18		.285	.287	.291	7.25 mm*	9, 8, 7	6, 5	6, 5	
		24	.292	.294	.297	.293**	8, 7, 6	5, 4	5, 4	
3/8"	16		.344	.347	.350	"S" OR 11/32"	9, 8, 7	7, 6	7, 6	
		24	.355	.357	.359	9.0 mm*	8, 7, 6	6, 5	5, 4	
7/16"	14		.402	.405	.409	"Y"	10, 9, 8	7, 6	8, 7, 6	
		20	.414	.416	.418	"Z" OR 10.5 mm*	9, 8, 7	6, 5	5, 4	
1/2"	13		.462	.466	.470	.463**	11, 10, 9	8, 7, 6	8, 7, 6	
		20	.475	.477	.480	.476**	9, 8, 7	6, 5	5, 4	
9/16"	12		.520	.524	.528	.521**	11, 10, 9	8, 7, 6	9, 8, 7	
		18	.535	.537	.540	.536**	9, 8, 7	7, 6, 5	7, 6, 5	
5/8"	11		.579	.583	.586	37/64"	12, 11, 10	9, 8, 7	9, 8, 7	
		18	.598	.600	.603	.598**	10, 9, 8	7, 6, 5	7, 6, 5	
3/4"	10		.700	.704	.709	45/64"	13, 12, 11	9, 8, 7	11, 10, 9	
		16	.720	.723	.726	23/32"	11, 10, 9	8, 7, 6	7, 6, 5	
7/8"	9		.818	.823	.829	.823"	14, 13, 12	10, 9, 8	12, 11, 10	
		14	.839	.843	.845	27/32"	12, 11, 10	9, 8, 7	8, 7, 6	
1"	8		.935	.942	.948	15/16"	14, 13, 12	11, 10, 9	13, 12, 11	
		12	.959	.963	.967	.963"	13, 12, 11	10, 9, 8	10, 9, 8	

NOTE: Drill Sizes were selected wherever possible to produce approximately 65% thread. The drills marked * are stocked by Balax.

TECHNICAL INFO
HOLE SIZE