

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) | |