

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

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