

SCREW HOLE SIZE CHART - PAGE 1 OF 2



| Suggested Test Plate Thicknesses & Hole Sizes for Type AB -B - 25 | | | | | |
|---|-----------|--------|--------|------------|------------|
| Nom. Screw Size & No. of Threads Per Inch | Thickness | | | Hole Size | |
| | Gage | Max | Min | Drill Size | Hole Diam. |
| 2-32 | 18 | 0.0500 | 0.0460 | 48 | 0.7600 |
| 3-28 | 18 | 0.0500 | 0.0460 | 46 | 0.0810 |
| 4-24 | 18 | 0.0500 | 0.0460 | 44 | 0.0860 |
| 5-20 | 18 | 0.0500 | 0.0460 | 36 | 0.1065 |
| 6-20 | 14 | 0.0770 | 0.0730 | 32 | 0.1160 |
| 7-19 | 14 | 0.0770 | 0.0730 | 30 | 0.1285 |
| 8-18 | 14 | 0.1270 | 0.1230 | 29 | 0.1360 |
| 10-16 | 1/8 | 0.1270 | 0.1230 | 21 | 0.1590 |
| 12-14 | 1/8 | 0.1270 | 0.1230 | 3/16 | 0.1875 |
| 1/4-14 | 3/16 | 0.1905 | 0.1845 | 5.5 mm | 0.2165 |
| 5/16-12 | 3/16 | 0.1905 | 0.1845 | I | 0.2720 |
| 3/8-12 | 3/16 | 0.1905 | 0.1845 | 21/64 | 0.3281 |

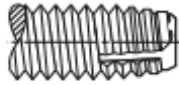
| Suggested Hole Sizes for Type A | | |
|---------------------------------|------------|------------|
| Nom. Screw Size | Hole Size | |
| | Drill Size | Hole Diam. |
| 6-18 | #32 | 0.1160 |
| 7-16 | #30 | 0.1285 |
| 8-15 | #29 | 0.1360 |
| 10-12 | #21 | 0.1590 |
| 12-11 | 3/16 | 0.1875 |
| 14-10 | 5.5 mm | 0.2165 |
| 20-9 | L | 0.2900 |
| 24-9 | 11/32 | 0.3438 |

Notes Regarding Hole Preparation:

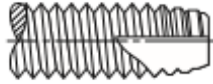
- Performed holes can be drilled, cored, punched, pierced or extruded. If edge burrs can cause assembly difficulty, they should be removed. Wall ovality and/or taper can affect load carrying ability.
- "Minimum torsional strength" is the torque that free standing screws must accept without evidence of damage or failure.

SCREW HOLE SIZE CHART - PAGE 2 OF 2

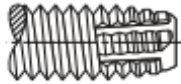
Type 1



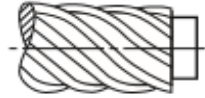
Type 23



Type F



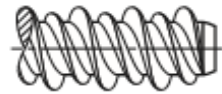
**Type U
Drive Screw**



| Recommended Hole Sizes - Type-U Drive Screws | | |
|--|------------|------------|
| Screw Size | Drill Size | Hole Diam. |
| 00 | 55 | 0.052 |
| 0 | 51 | 0.067 |
| 2 | 44 | 0.086 |
| 4 | 37 | 0.104 |
| 6 | 31 | 0.120 |
| 7 | 29 | 0.136 |
| 8 | 27 | 0.144 |
| 10 | 20 | 0.161 |
| 12 | 11 | 0.191 |
| 14 | 2 | 0.221 |

| Suggested Test Plate Thicknesses & Hole Sizes for Type 1, 25, & F THREAD CUTTING SCREWS | | | | | |
|---|-----------|--------|--------|------------|---------------|
| Nom. Screw Size & No. of Threads Per Inch | Thickness | | | Hole Size | |
| | Gage | Max | Min | Drill Size | Hole Diam. |
| 2-56 | 18 | 0.0800 | 0.0760 | 49 | 0.0730 |
| 3-48 | 18 | 0.0960 | 0.0920 | 46 | 0.0810 |
| 4-40 | 18 | 0.1110 | 0.1070 | 41 | 0.0960 |
| 5-40 | 18 | 0.1110 | 0.1070 | 37 | 0.1010 |
| 6-32 | 14 | 0.1425 | 0.1385 | 31 | 0.1200 |
| 8-32 | 14 | 0.1905 | 0.1845 | 26 | 0.1470 |
| 10-24 | 1/8 | 0.1905 | 0.1845 | 17 | 0.1730 |
| 10-32 | 1/8 | 0.1905 | 0.1845 | 16 | 0.1770 |
| 12-24 | 1/8 | 0.1905 | 0.1845 | 8 | 0.1990 |
| 1/4-20 | 3/16 | 0.2530 | 0.2470 | 1 | 0.2280 |
| 5/16-18 | 3/16 | 0.3155 | 0.3095 | L | 0.2900 |
| 3/8-16 | 3/16 | 0.3780 | 0.3720 | T | 0.3580 |
| 1/2-13 | 3/16 | 0.4710 | 0.4430 | 29/64 | 0.4531 |

**High-
Low**



| Suggested Hole Sizes - High-Low Screws | | |
|--|---|-----------------------|
| Nom. Screw Size & Number of Threads Per Inch | Pilot Hole Dia. Flexural Modulus of Plastics | |
| | Up to 200,000 PSI | 200,000-400,00 PSI |
| 00 | 55 | 0.052 |
| 0 | 51 | 0.067 |
| 2 | 44 | 0.086 |
| 4 | 37 | 0.104 |
| 6 | 31 | 0.120 |
| 7 | 29 | 0.136 |
| 8 | 27 | 0.144 |
| 10 | 20 | 0.161 |
| 12 | 11 | 0.191 |
| 14 | 2 | 0.221 |