

THREAD DESIGNATION	Minor Diameter for a Class 3B Thread		Recommendations for High Performance Drills for a Class 3B Thread Available from Stock										
	Hole size for <u>lowest</u> % of thread		For <u>Lowest</u> % of Thread Engagement			For an <u>Intermediate</u> % of Thread Engagement			For <u>Highest</u> % of Thread Engagement			For Thread Milling	
	Maximum	Minimum	Drill Size	Decimal Equivalent	Actual % of Thread Engagement	Drill Size	Decimal Equivalent	Actual % of Thread Engagement	Drill Size	Decimal Equivalent	Actual % of Thread Engagement	Drill Size	Decimal Equivalent
8-32	0.1389	0.1300	3.5	0.1378	64%				3.4	0.1339	74%	3.2	0.1260
8-36	0.1416	0.1340	3.5	0.1378	73%				3.5	0.1378	73%	3.4	0.1339
10-24	0.1555	0.1450	3.9	0.1535	67%	3.8	0.1496	75%	3.7	0.1457	82%	3.6	0.1417
10-32	0.1641	0.1560	4.1	0.1614	70%	4.0	0.1575	80%	5/32	0.1563	83%	3.9	0.1535
12-24	0.1807	0.1710	4.5	0.1772	72%	4.4	0.1732	79%	#17	0.1730	79%	4.3	0.1693
12-28	0.1857	0.1770	4.7	0.1850	67%	#13	0.1850	67%	4.6	0.1811	75%	4.4	0.1732
1/4-20	0.2067	0.1960	5.2	0.2047	70%	5.1	0.2008	76%	5.0	0.1969	82%	4.9	0.1929
1/4-28	0.2190	0.2110	7/32	0.2188	67%	5.5	0.2165	72%	5.4	0.2126	81%	#4	0.2090
5/16-18	0.2630	0.2520	6.6	0.2598	73%				6.5	0.2559	78%	1/4"	0.2500
5/16-24	0.2754	0.2670	Ltr l	0.2720	75%	6.9	0.2717	75%	6.8	0.2677	83%	17/64"	0.2656
3/8-16	0.3182	0.3070	8.0	0.3150	74%	5/16	0.3125	77%	7.9	0.3110	79%	7.7	0.3031
3/8-24	0.3372	0.3300	8.5	0.3346	75%				8.4	0.3307	82%	21/64"	0.3281
7/16-14	0.3717	0.3600	9.4	0.3701	73%	9.3	0.3661	77%	9.2	0.3622	81%	9.1	0.3583
7/16-20	0.3916	0.3830	25/64	0.3906	72%	9.9	0.3898	73%	9.8	0.3858	80%	9.7	0.3819
1/2-13	0.4284	0.4170	10.8	0.4252	75%	10.7	0.4213	79%	10.6	0.4173	83%	10.5	0.4134
1/2-20	0.4537	0.4460	29/64	0.4531	72%	11.5	0.4528	73%	11.4	0.4488	79%	11.3	0.4449
9/16-12	0.4843	0.4720	12.0	0.4724	83%				12.0	0.4724	83%	15/32"	0.4688
9/16-18	0.5106	0.5020	12.8	0.5039	81%				12.8	0.5039	81%	1/2"	0.5000
5/8-11	0.5391	0.5270	13.5	0.5315	79%				13.5	0.5315	79%	13.0	0.5118
5/8-18	0.5730	0.5650	14.5	0.5709	75%				14.5	0.5709	75%	9/16"	0.5625
3/4-10	0.6545	0.6420	16.5	0.6496	77%				16.5	0.6496	77%	16.0	0.6299
3/4-16	0.6908	0.6820	17.5	0.6890	75%				11/16	0.6875	77%	17.0	0.6693