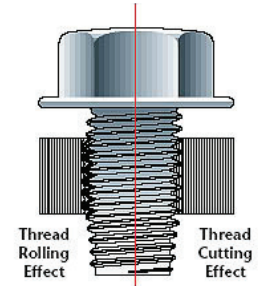


TAPTITE 2000® Screws and Bolts



Recommended pilot hole sizes for TAPTITE 2000® Screws and Bolts at various percentages of thread engagement



Metric Sizes (mm)

NOMINAL SCREW SIZE	PERCENT THREAD													
	100	95	90	85	80	75	70	65	60	55	50	45	40	35
	PILOT HOLE SIZES													
M2.5 x 0.45	2.21	2.22	2.24	2.25	2.27	2.28	2.29	2.31	2.32	2.34	2.35	2.37	2.38	2.40
M3 x 0.5	2.67	2.69	2.71	2.72	2.74	2.76	2.77	2.79	2.80	2.82	2.84	2.85	2.87	2.90
M3.5 x 0.6	3.11	3.13	3.15	3.17	3.19	3.21	3.23	3.25	3.27	3.29	3.30	3.32	3.34	3.36
M4 x 0.7	3.54	3.57	3.59	3.61	3.64	3.66	3.68	3.70	3.73	3.75	3.77	3.79	3.80	3.84
M4.5 x 0.75	4.01	4.04	4.06	4.09	4.11	4.13	4.16	4.18	4.21	4.23	4.26	4.28	4.30	4.33
M5 x 0.8	4.48	4.51	4.53	4.56	4.58	4.61	4.64	4.66	4.69	4.71	4.74	4.77	4.79	4.82
M6 x 1.0	5.35	5.38	5.42	5.45	5.48	5.51	5.54	5.58	5.61	5.64	5.67	5.71	5.74	5.77
M7 x 1.0	6.35	6.38	6.42	6.45	6.48	6.51	6.54	6.58	6.61	6.64	6.67	6.71	6.74	6.77
M8 x 1.25	7.19	7.23	7.27	7.31	7.35	7.39	7.43	7.47	7.51	7.55	7.59	7.63	7.67	7.72
M10 x 1.5	9.03	9.07	9.12	9.17	9.22	9.27	9.32	9.37	9.41	9.46	9.51	9.56	9.61	9.66
M12 x 1.75	10.86	10.92	10.98	11.03	11.09	11.15	11.20	11.26	11.31	11.37	11.43	11.49	11.55	11.60

Inch Sizes (inches)

NOMINAL SCREW SIZE	PERCENT THREAD													
	100	95	90	85	80	75	70	65	60	55	50	45	40	35
	PILOT HOLE SIZES													
2-56	0.0744	0.0750	0.0756	0.0761	0.0767	0.0773	0.0779	0.0785	0.0790	0.0796	0.0802	0.0808	0.0814	0.0819
3-48	0.0855	0.0861	0.0868	0.0875	0.0882	0.0888	0.0895	0.0902	0.0909	0.0916	0.0922	0.0929	0.0936	0.0943
4-40	0.0958	0.0966	0.0974	0.0982	0.0990	0.0998	0.1006	0.1014	0.1023	0.1031	0.1039	0.1047	0.1055	0.1063
5-40	0.1088	0.1096	0.1104	0.1112	0.1120	0.1128	0.1136	0.1144	0.1153	0.1161	0.1169	0.1177	0.1185	0.1193
6-32	0.1177	0.1187	0.1197	0.1207	0.1218	0.1228	0.1238	0.1248	0.1258	0.1268	0.1278	0.1289	0.1299	0.1309
8-32	0.1437	0.1447	0.1457	0.1467	0.1478	0.1488	0.1498	0.1508	0.1518	0.1528	0.1538	0.1549	0.1559	0.1569
10-24	0.1629	0.1643	0.1656	0.1670	0.1683	0.1697	0.1710	0.1724	0.1738	0.1751	0.1765	0.1778	0.1792	0.1805
10-32	0.1697	0.1707	0.1717	0.1727	0.1738	0.1748	0.1758	0.1768	0.1778	0.1788	0.1798	0.1809	0.1819	0.1829
12-24	0.1889	0.1903	0.1916	0.1930	0.1943	0.1957	0.1970	0.1984	0.1998	0.2011	0.2025	0.2038	0.2052	0.2065
1/4-20	0.2175	0.2191	0.2208	0.2224	0.2240	0.2256	0.2273	0.2289	0.2305	0.2321	0.2338	0.2354	0.2370	0.2386
5/16-18	0.2764	0.2782	0.2800	0.2818	0.2836	0.2854	0.2872	0.2890	0.2908	0.2926	0.2944	0.2963	0.2981	0.2999
3/8-16	0.3344	0.3364	0.3384	0.3405	0.3425	0.3445	0.3466	0.3486	0.3506	0.3527	0.3547	0.3567	0.3588	0.3608
7/16-14	0.3911	0.3934	0.3957	0.3980	0.4004	0.4027	0.4050	0.4073	0.4096	0.4120	0.4143	0.4166	0.4189	0.4213
1/2-13	0.4500	0.4525	0.4550	0.4575	0.4600	0.4625	0.4650	0.4675	0.4700	0.4725	0.4750	0.4775	0.4800	0.4825

EXAMPLE - The shaded area indicates that an M5 - 0.8 screw size in a 4.58 hole size provides 80% thread engagement. Because the above values are based on a linear relation between hole size and percentage thread engagement, the hole data becomes less accurate for engagements less than 70%.

Pilot Hole Tolerance - in terms of radial thread engagement, min hole = nominal hole + 10%, max hole = nominal - 5%.

Example: M8 - 1.25 in 6.0mm thick steel, nominal hole = 70% thread (7.43mm) per page 5 table.
Min. hole = 80% thread (7.35mm), max hole = 65% thread (7.47mm).

NOTE: All Data Tables in this brochure are for guidance purposes only.



TAPTITE 2000® Screws and Bolts

Recommended pilot hole sizes for TAPTITE 2000® Screws and Bolts in steel nut members

Metric Sizes (mm)

Application Duty Class	Light 0.3 Diameter of Material			Medium-Light 0.5 Diameter of Material			Medium-Heavy 0.75 Diameter of Material			Full Strength 1.0 Diameter of Material			Extended 1.25 Diameter of Material		
	90%			80%			70%			65%			60%		
Percentage of Thread	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size
M2.5 x 0.45	0.5-0.9	2.24	2.25	0.9-1.5	2.27	#43 2.26	1.5-2.1	2.3	2.3	2.1-2.7	2.31	2.3	2.7-3.5	2.32	2.3
M3 x 0.5	0.5-1.1	2.71	#36 2.71	1.1-1.7	2.74	2.75	1.7-2.7	2.77	7/64 2.78	2.7-3.3	2.79	7/64 2.78	3.3-4.0	2.8	2.8
M3.5 x 0.6	0.6-1.4	3.15	1/8 3.18	1.4-2.0	3.19	3.2	2.0-2.9	3.23	3.25	2.9-3.8	3.25	3.25	3.8-4.5	3.27	#30 3.27
M4 x 0.7	0.8-1.4	3.59	3.6	1.4-2.4	3.64	#27 3.66	2.4-3.3	3.68	3.7	3.3-4.4	3.7	3.7	4.4-5.5	3.73	#26 3.73
M4.5 x 0.75	0.9-1.7	4.06	#21 4.04	1.7-2.7	4.11	4.1	2.7-3.9	4.16	4.2	3.9-4.9	4.18	4.2	4.9-6.4	4.21	4.2
M5 x 0.8	1.0-2.1	4.53	4.5	2.1-2.9	4.58	#15 4.57	2.9-4.4	4.64	#14 4.62	4.4-5.9	4.66	4.65	5.9-7.1	4.69	4.7
M6 x 1.0	1.2-2.4	5.42	#3 5.41	2.4-3.6	5.48	5.5	3.6-4.9	5.55	7/32 5.56	4.9-6.9	5.58	5.6	6.9-8.1	5.61	5.6
M7 x 1.0	1.4-2.4	6.42	6.4	2.4-4.4	6.48	6.5	4.4-6.5	6.55	F 6.53	6.5-7.7	6.58	6.6	7.7-9.5	6.61	6.6
M8 x 1.25	1.6-3.1	7.27	7.25	3.1-4.9	7.35	L 7.37	4.6-6.9	7.43	7.4	6.9-8.9	7.47	M 7.49	8.9-10.9	7.51	7.5
M10 x 1.5	1.9-3.9	9.12	23/64 9.1	3.9-5.9	9.22	9.25	5.9-8.3	9.32	9.3	8.3-10.9	9.37	U 9.35	10.9-12.9	9.41	9.4
M12 x 1.75	2.4-4.9	10.98	11.0	4.9-7.4	11.09	7/16 11.11	7.4-10.5	11.2	7/16 11.11	10.5-14.5	11.26	11.3	14.5-17.0	11.31	11.3

Inch Sizes (inches)

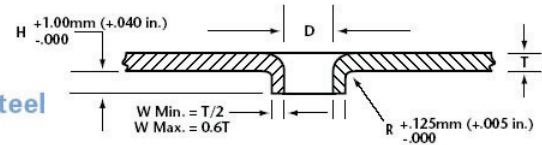
Application Duty Class	Light 0.3 Diameter of Material			Medium-Light 0.5 Diameter of Material			Medium-Heavy 0.75 Diameter of Material			Full Strength 1.0 Diameter of Material			Extended 1.25 Diameter of Material		
	90%			80%			70%			65%			60%		
Percentage of Thread	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size	Material Thickness	Pilot Hole	Drill Size
2-56	.017-.034	0.0756	1.9mm 0.0748	.034-.052	0.0767	1.95mm 0.0763	.052-.073	0.0779	5/64 0.0781	.073-.095	0.0785	#47 0.0785	.095-.169	0.0790	2mm 0.0787
3-48	.020-.040	0.08680	2.2mm 0.0866	.040-.059	0.0882	#43 0.089	.059-.084	0.0895	#43 0.089	.084-.110	0.0902	2.3mm 0.0906	.110-.141	0.0909	2.3mm 0.0906
4-40	.022-.045	0.0974	#40 0.098	.045-.067	0.0990	#39 0.0995	.067-.095	0.1006	#39 0.0995	.095-.126	0.1014	#38 0.1015	.126-.157	0.1023	2.6mm 0.0906
5-40	.025-.051	0.1104	2.8mm 0.1102	.051-.075	0.1120	#33 0.113	.075-.106	0.1136	#33 0.113	.106-.141	0.1144	2.9mm 0.1142	.141-.175	0.1153	2.9mm 0.1142
6-32	.028-.066	0.1197	#31 0.120	.066-.083	0.1218	3.1mm 0.122	.083-.117	0.1238	1/8 0.125	.117-.152	0.1248	1/8 0.125	.152-.193	0.1258	3.2mm 0.126
8-32	.033-.066	0.1457	3.7mm 0.1457	.066-.098	0.1478	3.75mm 0.1476	.098-.141	0.1498	3.8mm 0.1496	.141-1.80	0.1508	3.8mm 0.1491	.180-.230	0.1518	#24 0.152
10-24	.038-.079	0.1656	#19 0.166	.079-.114	0.1683	#18 0.1695	.114-.162	0.1710	11/64 0.1719	.162-.209	0.1724	11/64 0.1719	.209-.266	0.1738	4.4mm 0.1732
10-32	.038-.079	0.1717	11/64 0.1719	.079-.114	0.1738	#17 0.173	.114-.162	.01758	#16 0.177	.162-.209	0.1768	#16 0.177	.209-.266	0.1778	4.5mm 0.1772
12-24	.043-.086	0.1916	#11 0.191	.086-.130	0.1943	#9 0.196	.130-.184	0.1970	5mm 0.1969	.184-.238	0.1984	#8 0.199	.238-.302	0.1998	5.1mm 0.2008
1/4-20	.050-.100	0.2208	#2 0.221	.100-.150	0.2240	5.7mm 0.2244	.150-.213	0.2273	#1 0.228	.213-.275	0.2289	5.8mm 0.2283	.275-.350	0.2309	5.8mm 0.2283
5/16-18	.062-.126	0.2800	7.1mm 0.2795	.126-.188	0.2836	7.2mm 0.2835	.188-.266	0.2872	7.3mm 0.2874	.266-.345	0.2890	L 0.29	.345-.438	0.2908	7.4mm 0.2913
3/8-16	.075-.150	0.3384	8.6mm 0.3386	.150-.225	0.3425	8.7mm 0.3425	.225-.319	0.3466	8.8mm 0.3465	.319-.413	0.3486	Size 0.348	.413-.525	0.3506	8.9mm 0.3504
7/16-14	.087-.174	0.3957	X 0.397	.174-.262	0.4004	X 0.397	.262-.371	.04050	Y 0.404	.371-.481	0.4073	13/32 0.4063	.481-.612	0.4096	13/32 0.4063
1/2-13	.100-.200	0.4550	29/64 0.4531	.200-.300	0.4600	29/64 0.4531	.300-.425	0.4650	15/32 0.4688	.425-.550	0.4675	15/32 0.4688	.550-.700	0.4700	15/32 0.4688

APPLICATION DUTY CLASS - A general term used here to group material thickness in terms of screw diameters. For example, the average material thickness listed under "medium-heavy" equals 75% of the screw diameter.

TAPTITE 2000® Screws and Bolts



Recommended extruded pilot hole sizes in light-gauge steel for TAPTITE 2000® Screws and Bolts



Metric Sizes (mm)

Material Thickness	0.5 - 0.69	0.7 - .99	1.0 - 1.49	1.5 - 2.49	2.5 - 3.0
Screw Size	Hole Size Diameter - D				
M2.5 x .045	2.22	2.23	2.24	—	—
M3 x 0.5	2.70	2.71	2.72	—	—
M4 x 0.7	3.57	3.59	3.61	3.64	—
M5 x 0.8	—	4.53	4.56	4.59	—
M6 x 1.0	—	5.42	5.45	5.48	5.51
M8 x 1.25	—	—	7.27	7.31	7.35

Extruding holes for fasteners in light-gauge steel nearly doubles the length of thread engagement over the original material thickness.

TAPTITE 2000® screws and bolts develop almost twice the failure torque in extruded holes, providing maximum joint integrity.

Example: The chart shows that for a M4 x 0.7 screw in a material thickness of 0.75mm the suggested hole diameter is 3.59mm. The corresponding "H" dimension is the 1.35mm minimum, making the total length of engagement 2.1mm minimum.

Metric Hole Dia.-D	Approximate Material Thickness "T"									
	0.6 - 1.0		1.0 - 1.2		1.2 - 2.0		2.0 - 2.5		2.5 - 3.0	
	H	R	H	R	H	R	H	R	H	R
2.00 - 2.55	1.00	0.13	1.00	0.13	1.00	0.15	1.10	0.25	—	—
2.56 - 3.20	1.20	0.13	1.20	0.13	1.20	0.15	1.30	0.25	1.35	0.25
3.21 - 3.80	1.35	0.13	1.35	0.13	1.35	0.15	1.50	0.25	1.60	0.25
3.81 - 4.60	—	—	1.50	0.13	1.55	0.15	1.80	0.25	1.90	0.25
4.61 - 5.60	—	—	1.80	0.13	1.80	0.15	2.30	0.25	2.40	0.25
5.61 - 6.60	—	—	—	—	1.90	0.15	2.55	0.25	2.65	0.25
6.61 - 7.60	—	—	—	—	2.10	0.15	2.95	0.25	3.20	0.25

Inch Sizes (inches)

Material Thickness	.020 - .029	.030 - .039	.040 - .059	.060 - .099	.100 - .130
Screw Size	Hole Size Diameter - D				
4-40	0.097	0.097	0.098	—	—
6-32	0.119	0.120	0.121	0.122	—
8-32	0.145	0.146	0.147	0.148	—
10-24	0.164	0.166	0.168	0.170	0.170
10-32	0.171	0.172	0.173	0.174	0.174
1/4-20	—	0.221	0.223	0.225	0.225
5/16-18	—	—	0.282	0.285	0.285

Inch Hole Dia. D	Approximate Material Thickness "T"									
	0.020 - 0.035		0.035 - 0.050		0.050 - 0.075		0.075 - .100		0.100 - 0.125	
	H	R	H	R	H	R	H	R	H	R
.081 - .100	0.040	0.005	0.040	0.005	0.040	0.006	0.043	0.010	—	—
.101 - .125	0.047	0.005	0.047	0.005	0.047	0.006	0.052	0.010	0.054	0.010
.126 - .150	0.053	0.005	0.053	0.005	0.053	0.006	0.060	0.010	0.063	0.010
.151 - .180	—	—	0.060	0.005	0.060	0.006	0.070	0.010	0.075	0.010
.181 - .220	—	—	0.070	0.005	0.070	0.006	0.090	0.010	0.095	0.010
.221 - .260	—	—	—	—	0.075	0.006	0.100	0.010	0.105	0.010
.261 - .300	—	—	—	—	0.083	0.006	0.116	0.010	0.125	0.010