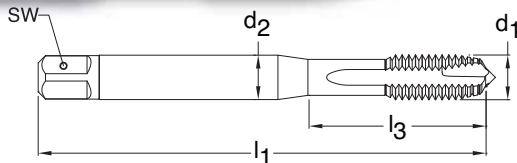


# UNF



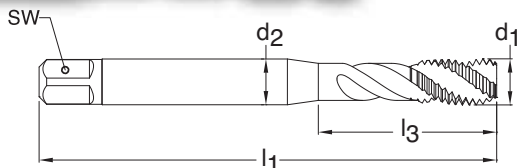
**Series** 3908  
**Standard** ANSI  
**Tool Material** HSS-E PM  
**Spiral Point** Straight flute  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit** 2B



  Through holes     
 S TiN coated     
  External cooling

d1 - P	H Limits	Tap Drill Range inch	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
4-48	H2/H3	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039080028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039080031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039080035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039080041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039080048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039080054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	2.500	1.181	6.350	9039080063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	2.721	1.377	7.938	9039080079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	2.941	1.456	9.525	9039080095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.161	N/A	11.113	9039080111130	●
1/2-20	H4/H5	0.446 - 0.457	3	0.367	0.275	3.382	N/A	12.700	9039080127000	●
9/16-18	H4/H5	0.502 - 0.515	3	0.429	0.322	3.591	N/A	14.288	9039080142880	●
5/8-18	H4/H5	0.565 - 0.578	3	0.480	0.360	3.811	N/A	15.875	9039080158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.252	N/A	19.050	9039080190500	●
7/8-14	H6/H7	0.798 - 0.813	4	0.697	0.523	4.689	N/A	22.225	9039080222250	●
1-12	H6/H7	0.910 - 0.928	4	0.800	0.600	5.130	N/A	25.400	9039080254000	●

# UNF



**Series** 3911  
**Standard** ANSI  
**Tool Material** HSS-E PM  
**Spiral Flute** 40° Helix  
**Chamfer Form C • 2-3**  
**Class of Fit** 2B



  Blind holes     
 S TiN coated     
  External cooling

d1 - P	H Limits	Tap Drill Range inch	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
4-48	H2/H3	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039110028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039110031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039110035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039110041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039110048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039110054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	2.500	1.181	6.350	9039110063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	2.721	1.377	7.938	9039110079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	2.941	1.456	9.525	9039110095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.161	N/A	11.113	9039110111130	●
1/2-20	H4/H5	0.446 - 0.457	3	0.367	0.275	3.382	N/A	12.700	9039110127000	●
9/16-18	H4/H5	0.502 - 0.515	3	0.429	0.322	3.591	N/A	14.288	9039110142880	●
5/8-18	H4/H5	0.565 - 0.578	4	0.480	0.360	3.811	N/A	15.875	9039110158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.252	N/A	19.050	9039110190500	●
7/8-14	H6/H7	0.798 - 0.813	4	0.697	0.523	4.689	N/A	22.225	9039110222250	●
1-12	H6/H7	0.910 - 0.928	4	0.800	0.600	5.130	N/A	25.400	9039110254000	●

"Tap drill Range" given is per the Class of Fit shown per Series #  
 Additional Tap Drill sizes & percent of thread engagement can be found on pages 199 - 206.