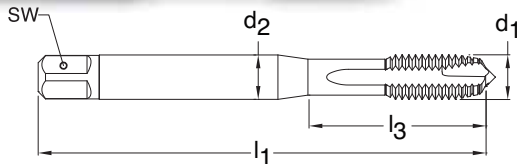


METRIC FINE



Series 3973
Standard ANSI
Tool Material HSS-E (Cobalt)
Spiral Point Straight flute
Chamfer Form B • 3.5 - 5
Class of Fit ISO 2(6H)



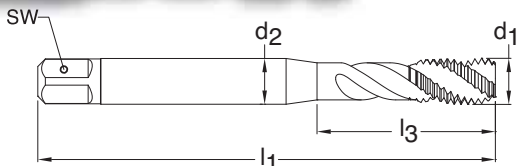
Through holes

TiN coated

External cooling

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
M6 X 0.75	D4/D5	5.188 - 5.378	3	0.255	0.191	2.500	1.181	6.004	9039730060040	●
M8 X 1.00	D4/D5	6.917 - 7.153	3	0.318	0.238	2.721	1.377	8.005	9039730080050	●
M10 X 1.00	D4/D5	8.917 - 9.153	3	0.381	0.286	2.941	1.378	10.005	9039730100050	●
M10 X 1.25	D4/D5	8.647 - 8.912	3	0.381	0.286	2.941	1.535	10.006	9039730100060	●
M12 X 1.00	D4/D5	10.917 - 11.153	4	0.367	0.275	3.382	N/A	12.005	9039730120050	●
M12 X 1.25	D4/D5	10.647 - 10.912	4	0.367	0.275	3.382	N/A	12.006	9039730120060	●
M12 X 1.50	D4/D5	10.376 - 10.676	4	0.367	0.275	3.382	N/A	12.007	9039730120070	●
M14 X 1.25	D4/D5	12.647 - 12.912	4	0.429	0.322	3.591	N/A	14.006	9039730140060	●
M14 X 1.50	D4/D5	12.376 - 12.676	4	0.429	0.322	3.591	N/A	14.007	9039730140070	●
M16 X 1.50	D4/D5	14.376 - 14.676	4	0.480	0.360	3.811	N/A	16.007	9039730160070	●
M18 X 1.50	D4/D5	16.376 - 16.676	4	0.542	0.406	4.032	N/A	18.007	9039730180070	●
M20 X 1.50	D6/D7	18.376 - 18.676	4	0.652	0.489	4.469	N/A	20.007	9039730200070	●
M22 X 1.50	D6/D7	20.376 - 20.676	4	0.697	0.523	4.689	N/A	22.007	9039730220070	●
M24 X 1.50	D6/D7	22.376 - 23.676	4	0.760	0.570	4.910	N/A	24.007	9039730240070	●

METRIC FINE



Series 3974
Standard ANSI
Tool Material HSS-E (Cobalt)
Spiral Flute 40° Helix
Chamfer Form C • 2-3
Class of Fit ISO 2(6H)



Blind holes

TiN coated

External cooling

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
M6 X 0.75	D3/D4	5.188 - 5.378	3	0.255	0.191	2.500	1.181	6.004	9039740060040	●
M8 X 1.00	D4/D5	6.917 - 7.153	3	0.318	0.238	2.721	1.377	8.005	9039740080050	●
M10 X 1.00	D4/D5	8.917 - 9.153	3	0.381	0.286	2.941	1.377	10.005	9039740100050	●
M10 X 1.25	D4/D5	8.647 - 8.912	3	0.381	0.286	2.941	1.535	10.006	9039740100060	●
M12 X 1.00	D4/D5	10.917 - 11.153	3	0.367	0.275	3.382	N/A	12.005	9039740120050	●
M12 X 1.25	D4/D5	10.647 - 10.912	3	0.367	0.275	3.382	N/A	12.006	9039740120060	●
M12 X 1.50	D5/D6	10.376 - 10.676	3	0.367	0.275	3.382	N/A	12.007	9039740120070	●
M14 X 1.25	D4/D5	12.647 - 12.912	3	0.429	0.322	3.591	N/A	14.006	9039740140060	●
M14 X 1.50	D4/D5	12.376 - 12.676	3	0.429	0.322	3.591	N/A	14.007	9039740140070	●
M16 X 1.50	D4/D5	14.376 - 14.676	4	0.480	0.360	3.811	N/A	16.007	9039740160070	●
M18 X 1.50	D4/D5	16.376 - 16.676	4	0.542	0.406	4.032	N/A	18.007	9039740180070	●
M20 X 1.50	D6/D7	18.376 - 18.676	4	0.652	0.489	4.469	N/A	20.007	9039740200070	●
M22 X 1.50	D6/D7	20.376 - 20.676	4	0.697	0.523	4.689	N/A	22.007	9039740220070	●
M24 X 1.50	D6/D7	22.376 - 23.676	4	0.760	0.570	4.910	N/A	24.007	9039740240070	●

"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.