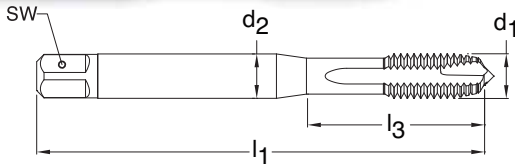
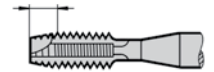


# UNC / STI



**Series 3990**  
**Standard ANSI**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Point Straight flute**  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit 3B STI**



Through holes



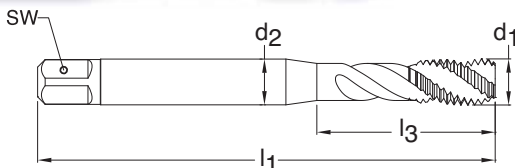
TiN coated



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
4-40	H2/H3	0.118 - 0.125	3	0.141	0.110	2.000	0.748	2.845	9039900028450	●
6-32	H3/H4	0.145 - 0.153	3	0.194	0.152	2.374	0.945	3.505	9039900035050	●
8-32	H3/H4	0.171 - 0.178	3	0.220	0.165	2.374	1.024	4.166	9039900041660	●
10-24	H3/H4	0.199 - 0.208	3	0.255	0.191	2.500	1.181	4.826	9039900048260	●
1/4-20	H4/H5	0.261 - 0.270	3	0.318	0.238	2.721	1.377	6.350	9039900063500	●
5/16-18	H4/H5	0.324 - 0.334	3	0.381	0.286	2.937	1.456	7.938	9039900079380	●
3/8-16	H5/H6	0.389 - 0.399	3	0.367	0.275	3.374	N/A	9.525	9039900095250	●
1/2-13	H5/H6	0.517 - 0.527	4	0.480	0.360	3.811	N/A	12.700	9039900127000	●

# UNC / STI



**Series 3988**  
**Standard ANSI**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Flute 40° Helix**  
**Chamfer Form C • 2-3**  
**Class of Fit 3B STI**



Blind holes



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
4-40	H2/H3	0.118 - 0.125	3	0.141	0.110	2.000	0.748	2.845	9039880028450	●
6-32	H3/H4	0.145 - 0.153	3	0.194	0.152	2.374	0.945	3.505	9039880035050	●
8-32	H3/H4	0.171 - 0.178	3	0.220	0.165	2.374	1.024	4.166	9039880041660	●
10-24	H3/H4	0.199 - 0.208	3	0.255	0.191	2.500	1.181	4.826	9039880048260	●
1/4-20	H4/H5	0.261 - 0.270	3	0.318	0.238	2.721	1.377	6.350	9039880063500	●
5/16-18	H4/H5	0.324 - 0.334	3	0.381	0.286	2.937	1.456	7.938	9039880079380	●
3/8-16	H5/H6	0.389 - 0.399	3	0.367	0.275	3.374	N/A	9.525	9039880095250	●
1/2-13	H5/H6	0.517 - 0.527	4	0.480	0.360	3.811	N/A	12.700	9039880127000	●

## TECH TIP: Heli-Coil STI Taps

An STI Tap thread tap is designed to create an oversized hole so it can accommodate the required Heli-Coil insert.

Screw Thread Inserts are helically formed coils of diamond-shaped stainless steel or phosphorous bronze wire that screw into a threaded hole to form a mating internal thread.

Screw thread inserts are a convenient way of repairing stripped out threads and are also used to provide stronger threads in soft materials than what can be obtained by directly tapping the base material. Aluminum, zinc die cast, magnesium and even wood are some materials an STI may be used in.

