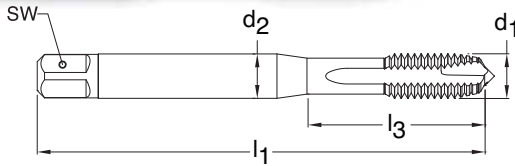


## UNF / STI



**Series** 3991  
**Standard** ANSI  
**Tool Material** HSS-E (Cobalt)  
**Spiral Point** Straight flute  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit** 3B STI



Through holes



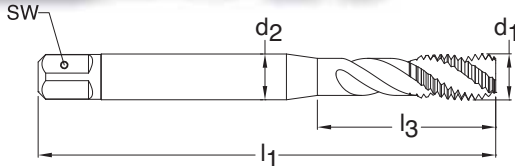
TiN coated



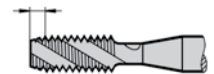
External cooling

d1 - P	H Limits	Tap Drill Range Inch	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
4-48	H2/H3	0.117 - 0.123	3	0.141	0.110	2.000	0.787	2.845	9039910028450	●
6-40	H3/H4	0.143 - 0.150	3	0.168	0.131	2.126	0.984	3.505	9039910035050	●
8-36	H3/H4	0.170 - 0.177	3	0.220	0.165	2.374	1.181	4.166	9039910041660	●
10-32	H3/H4	0.199 - 0.208	3	0.255	0.191	2.500	1.181	4.826	9039910048260	●
1/4-28	H3/H4	0.258 - 0.265	3	0.318	0.238	2.721	1.456	6.350	9039910063500	●
5/16-24	H3/H4	0.324 - 0.334	3	0.381	0.286	2.937	1.456	7.938	9039910079380	●
3/8-24	H5/H6	0.384 - 0.391	3	0.323	0.242	3.374	N/A	9.525	9039910095250	●
1/2-20	H5/H6	0.511 - 0.519	4	0.429	0.322	3.594	N/A	12.700	9039910127000	●

## UNF / STI



**Series** 3989  
**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
4-48	H2/H3	0.117 - 0.123	3	0.141	0.110	2.000	0.787	2.845	9039890028450	●
6-40	H3/H4	0.143 - 0.150	3	0.168	0.131	2.126	0.984	3.505	9039890035050	●
8-36	H3/H4	0.170 - 0.177	3	0.220	0.165	2.374	1.181	4.166	9039890041660	●
10-32	H3/H4	0.199 - 0.208	3	0.255	0.191	2.500	1.181	4.826	9039890048260	●
1/4-28	H3/H4	0.258 - 0.265	3	0.318	0.238	2.721	1.457	6.350	9039890063500	●
5/16-24	H3/H4	0.324 - 0.334	3	0.381	0.286	2.937	1.457	7.938	9039890079380	●
3/8-24	H5/H6	0.384 - 0.391	3	0.323	0.242	3.374	N/A	9.525	9039890095250	●
1/2-20	H5/H6	0.511 - 0.519	4	0.429	0.322	3.594	N/A	12.700	9039890127000	●

### 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.

