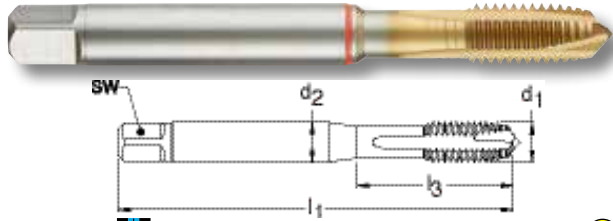


UNF

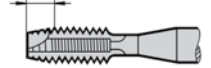


Through holes

S TiN coated

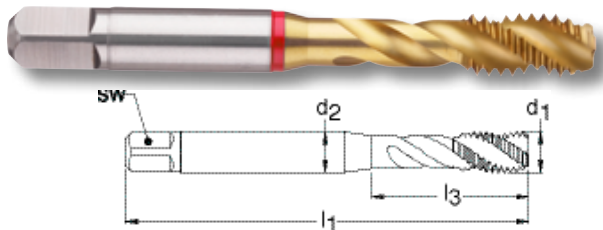
External cooling

Series 3994
Standard DIN/ANSI
Tool Material HSS-E PM
Spiral Point Straight flute
Chamfer Form B • 3.5 - 5
Class of Fit 2B



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	2.205	0.709	2.845	9039940028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	2.205	0.709	3.175	9039940031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.205	0.748	3.505	9039940035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.480	0.827	4.166	9039940041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.756	0.945	4.826	9039940048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	3.150	1.024	5.486	9039940054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	3.150	1.181	6.350	9039940063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	3.543	1.377	7.938	9039940079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	3.543	1.456	9.525	9039940095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.937	N/A	11.113	9039940111130	●
1/2-20	H4/H5	0.446 - 0.457	4	0.367	0.275	3.937	N/A	12.700	9039940127000	●
9/16-18	H4/H5	0.472 - 0.490	4	0.429	0.322	3.937	N/A	14.288	9039940142880	●
5/8-18	H4/H5	0.565 - 0.578	4	0.480	0.360	3.937	N/A	15.875	9039940158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.331	N/A	19.050	9039940190500	●
7/8-14	H6/H7	0.798 - 0.813	4	0.697	0.523	4.921	N/A	22.225	9039940222250	●
1-12	H6/H7	0.910 - 0.928	4	0.800	0.600	5.512	N/A	25.400	9039940254000	●
1 1/8- 7	H6/H7	0.970 - 0.998	4	0.896	0.672	5.906	N/A	28.575	9039940285750	●
1 1/4-12	H6/H7	1.160 - 1.178	4	1.021	0.766	5.906	N/A	31.750	9039940317500	●
1 3/8- 6	H6/H7	1.195 - 1.225	6	1.108	0.831	6.693	N/A	34.925	9039940349250	●
1 1/2-12	H6/H7	1.410 - 1.428	6	1.233	0.925	6.693	N/A	38.100	9039940381000	●

UNF



Blind holes

S TiN coated

External cooling

Series 3995
Standard DIN/ANSI
Tool Material HSS-E PM
Spiral Flute 40° Helix
Chamfer Form C • 2-3
Class of Fit 2B



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	2.205	0.709	2.845	9039950028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	2.205	0.709	3.175	9039950031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.205	0.748	3.505	9039950035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.480	0.827	4.166	9039950041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.756	0.945	4.826	9039950048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	3.150	1.024	5.486	9039950054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	3.150	1.181	6.350	9039950063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	3.543	1.377	7.938	9039950079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	3.543	1.456	9.525	9039950095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.937	N/A	11.113	9039950111130	●
1/2-20	H4/H5	0.446 - 0.457	3	0.367	0.275	3.937	N/A	12.700	9039950127000	●
9/16-18	H4/H5	0.502 - 0.515	3	0.429	0.322	3.937	N/A	14.288	9039950142880	●
5/8-18	H4/H5	0.565 - 0.578	4	0.480	0.360	3.937	N/A	15.875	9039950158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.331	N/A	19.050	9039950190500	●
7/8-14	H6/H7	0.798 - 0.813	5	0.697	0.523	4.921	N/A	22.225	9039950222250	●
1-12	H6/H7	0.910 - 0.928	5	0.800	0.600	5.512	N/A	25.400	9039950254000	●
1 1/8- 12	H6/H7	1.035 - 1.053	5	0.896	0.672	5.906	N/A	28.575	9039950285750	●
1 1/4-12	H6/H7	1.160 - 1.178	5	1.021	0.766	5.906	N/A	31.750	9039950317500	●
1 3/8- 12	H6/H7	1.285 - 1.303	5	1.108	0.831	6.693	N/A	34.925	9039950349250	●
1 1/2-12	H6/H7	1.410 - 1.428	6	1.233	0.925	6.693	N/A	38.100	9039950381000	●

"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.

High-Tensile, Heat-Treatable Hardened and Tool Steels