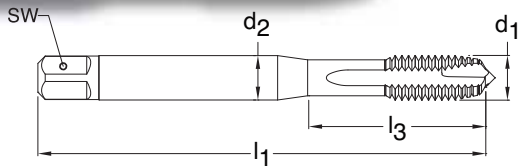


UNF



Series 3997
Standard ANSI
Tool Material HSS-E PM
Spiral Point Straight flute
Chamfer Form B • 3.5 - 5
Class of Fit 3B



Through holes



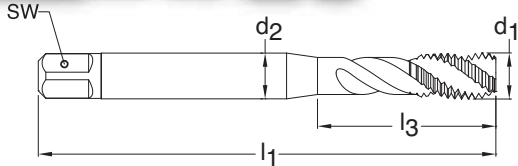
TiN coated



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	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039970028450	●
5-44	H2	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039970031750	●
6-40	H2	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039970035050	●
8-36	H2	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039970041660	●
10-32	H3	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039970048260	●
12-28	H3	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039970054860	●
1/4-28	H3	0.211 - 0.219	3	0.255	0.191	2.500	1.181	6.350	9039970063500	●
5/16-24	H3	0.267 - 0.275	3	0.318	0.238	2.721	1.377	7.938	9039970079380	●
3/8-24	H3	0.330 - 0.337	3	0.381	0.286	2.941	1.456	9.525	9039970095250	●
7/16-20	H3	0.383 - 0.392	3	0.323	0.242	3.161	N/A	11.113	9039970111130	●
1/2-20	H3	0.446 - 0.454	4	0.367	0.275	3.382	N/A	12.700	9039970127000	●
9/16-18	H3	0.502 - 0.511	4	0.429	0.322	3.591	N/A	14.288	9039970142880	●
5/8-18	H3	0.565 - 0.573	4	0.480	0.360	3.811	N/A	15.875	9039970158750	●
3/4-16	H3	0.682 - 0.691	4	0.590	0.442	4.252	N/A	19.050	9039970190500	●
1-12	H4	0.910 - 0.920	4	0.800	0.600	5.130	N/A	25.400	9039970254000	●

UNF



Series 3999
Standard ANSI
Tool Material HSS-E PM
Spiral Flute 40° Helix
Chamfer Form C • 2-3
Class of Fit 3B



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	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039990028450	●
5-44	H2	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039990031750	●
6-40	H2	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039990035050	●
8-36	H2	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039990041660	●
10-32	H3	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039990048260	●
12-28	H3	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039990054860	●
1/4-28	H3	0.211 - 0.219	3	0.255	0.191	2.500	1.181	6.350	9039990063500	●
5/16-24	H3	0.267 - 0.275	3	0.318	0.238	2.721	1.377	7.938	9039990079380	●
3/8-24	H3	0.330 - 0.337	3	0.381	0.286	2.941	1.456	9.525	9039990095250	●
7/16-20	H3	0.383 - 0.392	3	0.323	0.242	3.161	N/A	11.113	9039990111130	●
1/2-20	H3	0.446 - 0.454	3	0.367	0.275	3.382	N/A	12.700	9039990127000	●
9/16-18	H3	0.502 - 0.511	3	0.429	0.322	3.591	N/A	14.288	9039990142880	●
5/8-18	H3	0.565 - 0.573	4	0.480	0.360	3.811	N/A	15.875	9039990158750	●
3/4-16	H3	0.682 - 0.691	4	0.590	0.442	4.252	N/A	19.050	9039990190500	●
1-12	H4	0.910 - 0.920	4	0.800	0.600	5.130	N/A	25.400	9039990254000	●

"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.