

FED. SUPPLY CLASS

5305

TABLE I – APPROXIMATE HOLE SIZES FOR TAPPING METAL

SCREW SIZE	METAL THICKNESS										
	.050	.060	.083	.109	.125	.140	.187	.250	.312	.375	.500
SHEET STEEL											
2-56	.073	.073	.073	.073	.076	.076	—	—	—	—	—
4-40	.089	.089	.094	.096	.098	.098	.102	—	—	—	—
6-32	.110	.113	.116	.116	.116	.120	.125	.125	—	—	—
8-32	.136	.140	.140	.144	.144	.147	.150	.150	.150	—	—
10-24	.152	.154	.161	.161	.166	.170	.173	.173	.173	.173	—
10-32	.159	.166	.166	.170	.170	.170	.177	.177	.177	.177	—
1/4-20	—	—	.213	.219	.221	.221	.228	.228	.228	.228	.228
1/4-28	—	—	.221	.228	.228	.234	.234	.234	.234	.234	.234
5/16-18	—	—	—	.277	.277	.281	.290	.290	.290	.290	.290
3/8-16	—	—	—		.339	.339	.346	.358	.358	.358	.358
SHEET ALUMINUM											
2-56	.070	.073	.073	.073	.073	.073	—	—	—	—	—
4-40	.089	.089	.089	.094	.094	.094	.098	—	—	—	—
6-32	.109	.109	.111	.113	.116	.116	.120	.125	—	—	—
8-32	.136	.136	.136	.140	.140	.144	.147	.150	.150	—	—
10-24	.150	.152	.154	.157	.159	.161	.166	.172	.173	.173	—
10-32	.161	.161	.161	.166	.166	.166	.172	.177	.177	.177	—
1/4-20	—	—	.206	.209	.213	.213	.221	.226	.228	.228	.228
CAST IRON											
2-56	.076	.076	.076	.078	.078	.078	—	—	—	—	—
4-40	.100	.100	.102	.102	.102	.102	.104	—	—	—	—
6-32	.120	.120	.125	.125	.125	.125	.128	.125	—	—	—
8-32	.147	.150	.150	.150	.150	.150	.154	.154	.154	—	—
10-24	.170	.170	.172	.173	.173	.173	.177	.177	.177	.177	—
10-32	.173	.173	.177	.177	.177	.177	.180	.180	.180	.180	—
1/4-20	—	—	.228	.228	.228	.228	.234	.234	.234	.234	.234
DIE CAST ZINC AND ALUMINUM											
2-56	.073	.073	.076	.076	.076	.076	—	—	—	—	—
4-40	.096	.096	.096	.096	.100	.100	.100	—	—	—	—
6-32	.116	.120	.120	.120	.120	.120	.120	.120	—	—	—
8-32	.144	.144	.144	.144	.147	.147	.147	.150	.150	—	—
10-24	.161	.166	.166	.166	.166	.166	.170	.170	.172	.172	—
10-32	.170	.170	.172	.172	.172	.172	.172	.173	.173	.177	—
1/4-20	—	—	.219	.219	.221	.221	.221	.228	.228	.228	.228

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24634, REVISION B.

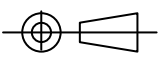
THIRD ANGLE PROJECTION		CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NONE	TITLE SCREW, TAPPING, THREAD CUTTING, TYPES D, F, G AND T, APPROXIMATE HOLE SIZES FOR	①	CLASSIFICATION DESIGN STANDARD MS24634

TABLE II – APPROXIMATE HOLE SIZES FOR TAPPING PLASTIC

SCREW SIZE	PHENOL FORMALDEHYDE				CELLULOSE ACETATE, CELLULOSE NITRATE, ACRYLIC RESIN, STYRENE RESIN			
	HOLE DIA	DRILL SIZE	DEPTH OF PENETRATION		HOLE DIA	DRILL SIZE	DEPTH OF PENETRATION	
			MIN	MAX			MIN	MAX
2-56	.078	5/64	.219	.375	.076	48	.219	.375
4-40	.098	40	.250	.312	.093	42	.250	.312
6-32	.116	32	.250	.312	.116	32	.250	.312
8-32	.144	27	.312	.500	.144	27	.312	.500
10-24	.161	20	.375	.500	.161	20	.375	.500
10-32	.166	19	.375	.500	.166	19	.375	.500
1/4-20	.228	1	.375	.625	.228	1	.375	1.000

Notes:

- Because conditions differ widely, it may be necessary to vary the hole size to suit a particular application.
- Dimensions in inches. Hole diameters are standard drill sizes rounded to the nearest .001 inch.
- For aeronautical applications, more definitive hole dimensions are contained in AND10326.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.
- Unless otherwise specified herein, referenced documents shall be the issue in effect on date of manufacture. However, existing material inventory certified to a previous revision of the applicable material specification(s) is acceptable for use until depletion.
- This is a design standard and shall not be used as a part number.

① COMPLETELY REVISED

REVISION
1
NASM24634
SHEET 2

