

WORLDWIDE FASTENER STANDARD

Date: 2000-11-22

WD 900

APPENDIX A

General Specifications for Spaced Thread Tapping Screws

Approximate hole sizes for tapping screws in sheet metals

Type B

Type AB



Dimensions in mm

Nominal Size	Material Thickness		Nominal Hole Diameter			
			Pierced or Extruded		Drilled or Punched	
	over	up to and including	Steel, Stainless Steel, Drawn Monel etc.	Aluminum Alloys	Steel, Stainless Steel, Drawn Monel etc.	Aluminum Alloys
ST2.9	-	0.56	2.2	-	2.2	-
	0.56	0.63	2.5	2.2	2.25	-
	0.63	0.75	2.5	2.2	2.25	2.2
	0.75	0.88	2.5	2.2	2.4	2.2
	0.88	1.25	-	2.2	2.4	2.2
	1.25	1.38	-	-	2.4	2.2
	1.38	1.75	-	-	2.5	2.25
ST3.5	1.75	2.5	-	-	2.6	2.4
	-	0.56	2.8	-	2.6	-
	0.56	0.75	2.8	2.8	2.7	-
	0.75	0.80	2.8	2.8	2.7	2.65
	1	1.25	-	2.8	2.8	2.65
	1.25	1.38	-	-	2.8	2.65
	1.38	1.75	-	-	2.9	2.75
ST4.2	1.75	2.5	-	-	3	2.85
	2.5	3	-	-	3.2	3
	3	6	-	-	-	3
	-	0.5	3.5	-	-	-
	0.5	0.63	3.5	3.5	3.2	-
	0.63	0.88	3.5	3.5	3.2	2.95
	0.88	1.13	3.5	3.5	3.2	3
ST4.8	1.13	1.38	3.5	3.5	3.3	3.2
	1.38	2.5	-	-	3.5	3.5
	2.5	3	-	-	3.8	3.7
	3	3.5	-	-	3.9	3.8
	3.5	10	-	-	-	3.9
	-	0.5	4	-	-	-
	0.5	0.75	4	4	3.7	-
ST6.3	0.75	1.13	4	4	3.7	3.7
	1.13	1.38	4	4	3.9	3.7
	1.38	1.75	-	-	3.9	3.7
	1.75	2.5	-	-	4	3.8
	2.5	3	-	-	4.1	3.8
	3	3.5	-	-	4.3	3.9
	3.5	4	-	-	4.4	3.9
ST6.3	4	4.75	-	-	4.4	4
	4.75	10	-	-	-	4.2
	-	1.38	5.3	-	4.9	-
	1.38	1.75	-	-	5	5
	1.75	2	-	-	5.2	5
	2	3	-	-	5.3	5.2
	3	4	-	-	5.8	5.3
ST6.3	4	4.75	-	-	5.9	5.4
	4.75	5	-	-	-	5.6
	5	10	-	-	-	5.6

NOTE: Because conditions differ widely, it may be necessary to vary the hole size to suit a particular application. The hole sizes tabulated above represent recommendations based on practical experience of screw producers and users as presented in ISO and are for information only.

* Hole sizes shown for metal thickness greater than 1.9 are recommended for types B only. Hole tolerance +/- 0.05mm

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Dimensions in mm

Nominal Size	Nominal Hole Diameter	
	Phenol - Formaldehyde	Cellulose - Acetate Cellulose - Nitrate Polyacrylate, Polystyrene
ST2.9	2.55	2.4
ST3.5	3.2	3
ST4.2	3.8	3.7
ST4.8	4.5	4.3
ST6.3	6	5.6

NOTE: Because conditions differ widely, it may be necessary to vary the hole size to suit a particular application. The hole sizes tabulated above represent recommendations based on practical experience of screw producers and users as presented in ISO and are for information only.