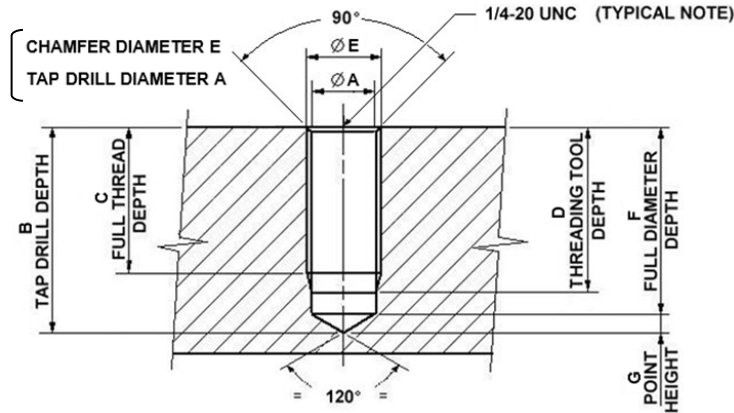


Type 1 - General Purpose Inch Tapped Holes
Standard Thread Length (2 x Nom Dia)
Coarse Pitch - Class 2B

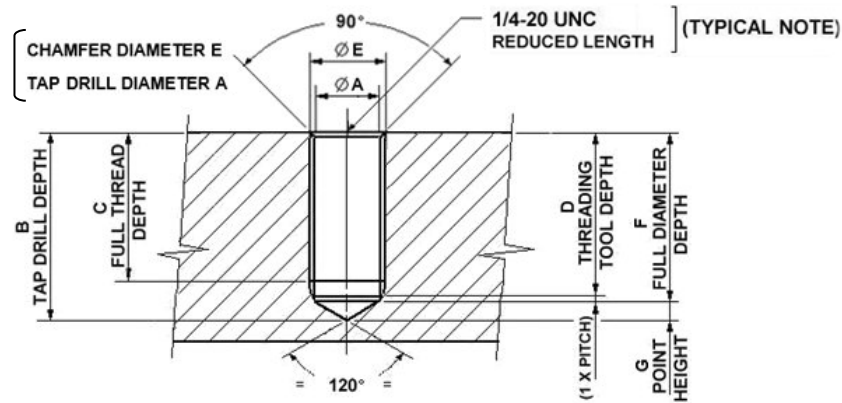


THREAD	THREADS PER INCH	TAP DRILL			TAPPING			CHAMFER		FOR REF.		
		A			B	C	D	E		F	G	
		Nom.	Max.	Min.	± 0.2	(See 2)	(See 2)	Dia. (See 3)		Nom.	Nom.	
Inch	Nom.	Nom.	Max.	Min.	Nom.	Nom.	Nom.	Nom.	Tol.	Nom.	Nom.	
1	#4	40	2.26	2.3851	2.1565	10.4	5.7	7.6	3.213	±0.127	9.747	0.653
	#8	32	3.45	3.5306	3.3020	13.5	8.3	10.68	4.641	±0.159	12.504	0.996
	#10	24	3.80	3.9624	3.6830	16.0	9.7	12.87	5.388	±0.212	14.903	1.097
	1/4	20	5.11	5.2578	4.9784	20.3	12.7	16.51	7.015	±0.254	18.825	1.475
	5/16	18	6.53	6.7310	6.4008	24.4	15.9	20.13	8.647	±0.282	22.515	1.885
	3/8	16	7.94	8.1534	7.7978	28.7	19.1	23.86	10.321	±0.318	26.408	2.292
	1/2	13	10.72	11.0236	10.5918	37.3	25.4	31.26	13.651	±0.391	34.205	3.095
	5/8	11	13.49	13.8684	13.3858	46.0	31.8	38.73	16.954	±0.462	42.106	3.894
	3/4	10	16.67	16.8402	16.3068	54.1	38.1	45.72	20.480	±0.508	49.288	4.812
	1	8	22.23	22.6060	21.9710	70.9	50.8	60.32	26.993	±0.635	64.483	6.417
	1 1/4	7	28.18	28.5242	27.8130	87.1	63.5	74.39	33.623	±0.726	78.965	8.135
	1 1/2	6	34.00	34.2900	33.5280	103.9	76.2	88.9	40.350	±0.847	94.085	9.815
	1 3/4	5	39.29	39.8272	38.9636	121.6	88.9	104.14	46.910	±1.016	110.258	11.342
	2	4.5	45.25	45.5930	44.6786	138.9	101.6	118.53	53.717	±1.129	125.837	13.063

Notes:

<ol style="list-style-type: none"> 1) Not recommended 2) Tolerance: +0.75 x pitch, -0 3) Chamfer $\varnothing = \text{Tap drill } \varnothing + (N \times \text{pitch})$ With $N_{\text{nom}}=1.5, N_{\text{min}}=1.3, N_{\text{max}}=1.7$ Pitch = 25.4 / (Threads per Inch) 	<ul style="list-style-type: none"> - All dimensions in mm unless otherwise specified - ANSI B1.1 Unified Inch screw threads - Inch screw threads are designated 5/16-18 UNC-2B - Typical general inch tapped hole indication at Husky: 1/4-20 UNC - Absence of thread tolerance class means class 2B is specified - Tap thread lead = 3x pitch - The drill tip angle may vary from 120° to 180° due to tooling requirements - Any deviations from this standard must be reviewed, approved and documented at a design review
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Type 2 - Special Purpose Inch Tapped Holes
Reduced Thread Length (1.5 x Nom Dia)
Coarse Pitch - Class 2B



THREAD	THREADS PER INCH	TAP DRILL			TAPPING			CHAMFER		FOR REF.		
		A			B	C	D	E		F	G	
		Nom.	Max.	Min.	± 0.2	(See 2)	(See 2)	Dia. (See 3)		Nom.	Nom.	
Inch	Nom.	Nom.	Max.	Min.	Nom.	Nom.	Nom.	Nom.	Tol.	Nom.	Nom.	
1 {	#8	32	3.45	3.5306	3.3020	10.419	6.248	8.630	4.641	±0.159	9.423	0.996
	#10	24	3.80	3.9624	3.6830	12.569	7.239	10.414	5.388	±0.212	11.472	1.097
	1/4	20	5.11	5.2578	4.9784	16.080	9.525	13.335	7.015	±0.254	14.605	1.475
	5/16	18	6.53	6.7310	6.4008	19.436	11.906	16.140	8.647	±0.282	17.551	1.885
	3/8	16	7.94	8.1534	7.7978	22.930	14.288	19.050	10.321	±0.318	20.638	2.292
	1/2	13	10.72	11.0236	10.5918	29.960	19.050	24.912	13.651	±0.391	26.865	3.095
	5/8	11	13.49	13.8684	13.3858	36.943	23.813	30.740	16.954	±0.462	33.049	3.894
	3/4	10	16.67	16.8402	16.3068	43.547	28.575	36.195	20.480	±0.508	38.735	4.812
	1	8	22.23	22.6060	21.9710	57.217	38.100	47.625	26.993	±0.635	50.800	6.417
	1 1/4	7	28.18	28.5242	27.8130	70.274	47.625	58.511	33.623	±0.726	62.139	8.135
	1 1/2	6	34.00	34.2900	33.5280	83.898	57.150	69.850	40.350	±0.847	74.083	9.815
	1 3/4	5	39.29	39.8272	38.9636	98.337	66.675	81.915	46.910	±1.016	86.995	11.342
	2	4.5	45.25	45.5930	44.6786	111.841	76.200	93.133	53.717	±1.129	98.778	13.063

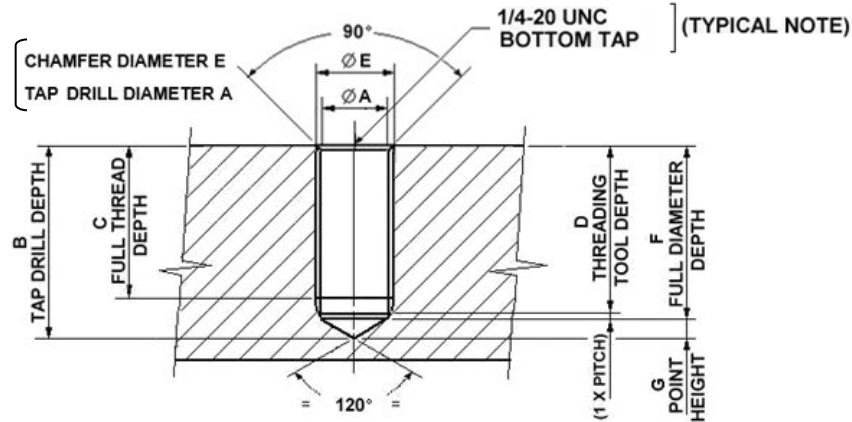
Notes:

<p>1) Not recommended</p> <p>2) Tolerance: +0.75 x pitch, -0</p> <p>3) Chamfer $\varnothing = \text{Tap drill } \varnothing + (N \times \text{pitch})$ With $N_{\text{nom}}=1.5$, $N_{\text{min}}=1.3$, $N_{\text{max}}=1.7$ Pitch = $25.4 / (\text{Threads per Inch})$</p>	<ul style="list-style-type: none"> - All dimensions in mm unless otherwise specified - ANSI B1.1 Unified Inch screw threads - Inch screw threads are designated 5/16-18 UNC-2B - Type 2 tap inch hole indication at Husky: 1/4-20 UNC REDUCED LENGTH - Absence of thread tolerance class means class 2B is specified - Tap thread lead = 3x pitch - The drill tip angle may vary from 120° to 180° due to tooling requirements - Any deviations from this standard must be reviewed, approved and documented at a design review
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Type 3 - True Bottom Inch Tapped Holes
1.5x and 2x Nom Dia Thread Lengths
Coarse Pitch - Class 2B



**HAND TAPPING - FOR REFERENCE ONLY - NOT RECOMMENDED FOR USE
INSTALLATIONS TO BE FULLY DIMENSIONED ON DRAWINGS**



THREAD	THREADS PER INCH	TAP DRILL				TAPPING				CHAMFER		FOR REF.				
		A				B		C		D		E		F		G
						1.5xDia	2.0xDia	1.5xDia	2.0xDia	1.5xDia	2.0xDia	Dia. (See 2)	1.5xDia	2.0xDia		
		±0.2	±0.2	±0.2	±0.2	±0.2	±0.2									
Inch	Nom.	Nom.	Max.	Min.	Nom.	Nom.	Nom.	Nom.	Nom.	Nom.	Nom.	Tol.	Nom.	Nom.	Nom.	
1	#8	32	3.45	3.5306	3.3020	9.45	11.5	6.248	8.3	7.45	9.5	4.641	±0.159	8.45	10.50	0.996
	#10	24	3.80	3.9624	3.6830	10.94	13.4	7.239	9.7	8.84	11.3	5.388	±0.212	9.84	12.30	1.097
	1/4	20	5.11	5.2578	4.9784	13.93	17.1	9.525	12.7	11.43	14.6	7.015	±0.254	12.45	15.63	1.475
	5/16	18	6.53	6.7310	6.4008	16.91	20.9	11.906	15.9	14.01	18.0	8.647	±0.282	15.02	19.02	1.885
	3/8	16	7.94	8.1534	7.7978	19.89	24.7	14.288	19.1	16.59	21.4	10.321	±0.318	17.60	22.41	2.292
	1/2	13	10.72	11.0236	10.5918	26.05	32.4	19.050	25.4	21.95	28.3	13.651	±0.391	22.96	29.31	3.095
	5/8	11	13.49	13.8684	13.3858	32.21	40.2	23.813	31.8	27.21	35.2	16.954	±0.462	28.32	36.31	3.894
	3/4	10	16.67	16.8402	16.3068	38.28	47.8	28.575	38.1	32.48	42.0	20.480	±0.508	33.46	42.99	4.812
	1	8	22.23	22.6060	21.9710	50.30	63.0	38.100	50.8	42.90	55.6	26.993	±0.635	43.88	56.58	6.417
	1 1/4	7	28.18	28.5242	27.8130	62.13	78.0	47.625	63.5	53.03	68.9	33.623	±0.726	53.99	69.87	8.135
	1 1/2	6	34.00	34.2900	33.5280	74.25	93.3	57.150	76.2	63.45	82.5	40.350	±0.847	64.44	83.49	9.815
	1 3/4	5	39.29	39.8272	38.9636	86.68	108.9	66.675	88.9	74.28	96.5	46.910	±1.016	75.33	97.56	11.342

Notes:

<p>1) Not recommended 2) Chamfer $\varnothing = \text{Tap drill } \varnothing + (N \times \text{pitch})$ With $N_{\text{nom}}=1.5, N_{\text{min}}=1.3, N_{\text{max}}=1.7$ Pitch = $25.4 / (\text{Threads per Inch})$</p>	<ul style="list-style-type: none"> - All dimensions in mm unless otherwise specified - ANSI B1.1 Unified Inch screw threads - Inch screw threads are designated 5/16-18 UNC-2B - Type 3 tap inch hole indication at Husky: 1/4-20 UNC BOTTOM TAP - Absence of thread tolerance class means class 2B is specified - The drill tip angle may vary from 120° to 180° due to tooling requirements - Any deviations from this standard must be reviewed, approved and documented at a design review
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	Revision Level - 2 - Published	Security Level - Public	Standard No.	HS 260

Revision Log

Rev	Revision Description
0	Original issue
1	Tolerance value for thread depth D updated
2	New chamfer specifications added to type 1, 2 and 3 tapped holes (See diameter E)