

# RECOMMENDED HOLE SIZES FOR SWAGEFORM® TAPPING SCREWS

NOTE: Because conditions vary widely, it may be necessary to change hole size to suit a particular application

## MATERIAL THICKNESS

SCREW SIZE	MATERIAL	.020 - .078		.063 - .140		.125 - .266		.250 - .328		.313 - .500	
		DRILL	DEC.	DRILL	DEC.	DRILL	DEC.	DRILL	DEC.	DRILL	DEC.
2-56	Steel	48	.076	47	.079	46	.081				
	Alum.	48	.076	47	.079	47	.079				
3-48	Steel	44	.086	43	.089	2.35M	.092				
	Alum.	44	.086	43	.089	2.35M	.092				
4-40	Steel	40	.098	38	.102	37	.104				
	Alum.	40	.098	39	.100	38	.102	38	.102		
5-40	Steel	34	.111	33	.113	32	.116				
	Alum.	35	.110	34	.111	33	.113	33	.113	32	.116
6-32	Steel			31	.120	1/8	.125	30	.129		
	Alum.	31	.120	31	.120	1/8	.125	1/8	.125	1/8	.125
8-32	Steel			26	.147	25	.150	23	.154		
	Alum.			26	.147	25	.150	24	.152	24	.152
10-24	Steel			19	.166	11/64	.172	16	.177		
	Alum.			19	.166	19	.166	18	.170	17	.173
10-32	Steel			17	.173	16	.177	15	.180		
	Alum.			17	.173	17	.173	16	.177	15	.180
12-24	Steel			10	.194	8	.199	13/64	.203		
	Alum.			11	.191	9	.196	8	.199	13/64	.203
1/4-20	Steel			7/32	.219	5.7M	.224	1	.228	A	.234
	Alum.			7/32	.219	2	.221	5.7M	.224	1	.228
5/16-18	Steel			K	.281	K	.281	7.25M	.285	L	.290
	Alum.			K	.281	K	.281	7.25M	.285	7.3M	.287
3/8-16	Steel					11/32	.344	S	.348	9M	.355
	Alum.					R	.399	11/32	.344	S	.348

## APPLICATION INFORMATION

### IN SHEET METAL AND STRUCTURAL STEEL

When two parts of sheet metal are to be joined, holes in both may be drilled or cleanpunched same size, using hole size recommended for total metal thickness. In heavy gauge sheet metal and structural steel, punch or drill recommended hole sizes. In such assemblies a clearance hole should be provided in part to be fastened.

### IN ZINC AND ALUMINUM CASTINGS

Holes for Screws may be cored if practicable to maintain close enough tolerance. Otherwise drill holes to size recommended. Hole should be deeper than Screw penetration. To facilitate driving, in some cases, apply a lubricant to Screws.

### IN STEEL, BRASS, AND BRONZE FORGINGS

Because of the wide range of physical characteristics of forgings, it is not practical to give hole size recommendations.

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