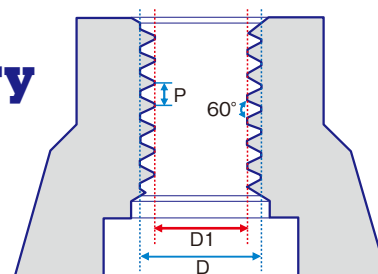


Threads for the aerospace industry

Recommended Drill Sizes for Tapping Internal UNJ Threads



UNJC

Unified coarse thread SAE AS8879D

Nominal size (inch) D	P [T.P.I.]	Minor dia. of the internal thread D1		Recommended drill size	
		min[inch]	max[inch]	Drill size	Decimal inch
No.4 (0.112)	40	0.0877	0.0942	2.30mm	0.0906
No.5 (0.125)	40	0.1007	0.1072	2.60mm	0.1024
No.6 (0.138)	32	0.1076	0.1157	#33	0.1130
No.8 (0.164)	32	0.1336	0.1417	3.50mm	0.1378
No.10 (0.190)	24	0.1494	0.1600	3.90mm	0.1535
No.12 (0.216)	24	0.1754	0.1852	4.60mm	0.1811
1/4 (0.250)	20	0.2013	0.2121	5.30mm	0.2087
5/16 (0.313)	18	0.2584	0.2690	6.70mm	0.2638
3/8 (0.375)	16	0.3141	0.3250	8.10mm	0.3189
7/16 (0.438)	14	0.3680	0.3795	9.50mm	0.3740
1/2 (0.500)	13	0.4251	0.4368	10.90mm	0.4291
9/16 (0.563)	12	0.4814	0.4914	31/64"	0.4844
5/8 (0.625)	11	0.5365	0.5474	13.80mm	0.5433
3/4 (0.750)	10	0.6526	0.6646	16.75mm	0.6594
7/8 (0.875)	9	0.7668	0.7801	19.60mm	0.7717
1 (1.000)	8	0.8783	0.8933	22.50mm	0.8858

UNJF

Unified fine thread SAE AS8879D

Nominal size (inch) D	P [T.P.I.]	Minor dia. of the internal thread D1		Recommended drill size	
		min[inch]	max[inch]	Drill size	Decimal inch
No.4 (0.112)	48	0.0917	0.0971	2.40mm	0.0945
No.5 (0.125)	44	0.1029	0.1088	2.70mm	0.1063
No.6 (0.138)	40	0.1137	0.1202	3.00mm	0.1181
No.8 (0.164)	36	0.1370	0.1442	#28	0.1405
No.10 (0.190)	32	0.1596	0.1675	4.20mm	0.1654
No.12 (0.216)	28	0.1812	0.1896	#13	0.1850
1/4 (0.250)	28	0.2152	0.2229	7/32"	0.2188
5/16 (0.313)	24	0.2719	0.2799	7.00mm	0.2756
3/8 (0.375)	24	0.3344	0.3417	8.60mm	0.3386
7/16 (0.438)	20	0.3888	0.397	10.00mm	0.3937
1/2 (0.500)	20	0.4513	0.4591	11.60mm	0.4567
9/16 (0.563)	18	0.5084	0.5166	13.00mm	0.5118
5/8 (0.625)	18	0.5709	0.5788	14.60mm	0.5748
3/4 (0.750)	16	0.6892	0.6977	17.60mm	0.6929
7/8 (0.875)	14	0.8055	0.8152	13/16"	0.8125
1 (1.000)	12	0.9189	0.9289	59/64"	0.9219



For Aerospace Tap Series

YAMAWA has assorted "ZELX series" taps for threading stainless steel, titanium alloys and nickel-based alloys that are used in many aircraft parts.

◇For through hole◇

Spiral Pointed Taps for Stainless Steels

ZELX® SS



Size Ranges
UNJC...No.4~1"
UNJF...No.4~1"



List No.

- 3218 Machine Screw sizes with oxide surface treatment
- 3228 Fractional sizes with oxide surface treatment
- 3218T Machine Screw sizes with TiN (Titanium Nitride)
- 3228T Fractional sizes with TiN (Titanium Nitride)

Suitable work materials

303 STAINLESS STEEL
304 STAINLESS STEEL
410 STAINLESS STEEL
8740 (SNM240)

Spiral Pointed Taps for Nickel Base Alloys

ZELX® NI



Size Ranges
UNJC...No.4~3/4
UNJF...No.6~3/4



List No.

- 3612 Machine Screw sizes
- 3622 Fractional sizes

Suitable work materials

INCONEL718, 750
Waspalloy
Hastelloy
A286
15-5PH
17-4PH (SUS630)
316 STAINLESS STEEL

Left Hand Spiral Fluted Taps for Titanium Alloys

ZELX® TI



Size Ranges
UNJC...No.4~1/2
UNJF...No.10~1/2



List No.

- 3613 Machine Screw sizes
- 3623 Fractional sizes

Suitable work materials

Titanium alloys (Ti-6Al-4V)

◇For blind hole◇

Spiral Fluted Taps for Stainless Steels

ZELX® SS



Size Ranges
UNJC...No.4~1"
UNJF...No.4~1"



List No.

- 3318 Machine Screw sizes with oxide surface treatment
- 3328 Fractional sizes with oxide surface treatment
- 3318T Machine Screw sizes with TiN (Titanium Nitride)
- 3328T Fractional sizes with TiN (Titanium Nitride)

Suitable work materials

303 STAINLESS STEEL
304 STAINLESS STEEL
410 STAINLESS STEEL
8740 (SNM240)

Spiral Fluted Taps for Nickel Base Alloys

ZELX® NI



Size Ranges
UNJC...No.4~3/4
UNJF...No.4~5/8



List No.

- 3615 Machine Screw sizes
- 3625 Fractional sizes

Suitable work materials

INCONEL718, 750
Waspalloy
Hastelloy
A286
15-5PH
17-4PH (SUS630)
316 STAINLESS STEEL

Spiral Fluted Taps for Titanium Alloys

ZELX® TI



Size Ranges
UNJC...No.4~1/2
UNJF...No.10~1/2



List No.

- 3613 Machine Screw sizes
- 3623 Fractional sizes

Suitable work materials

Titanium alloys (Ti-6Al-4V)
