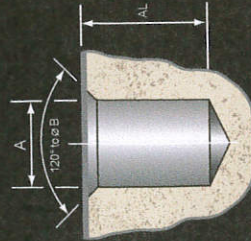


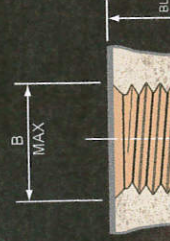
Threads to:-

BS 3643
BS A 358-1
DIN 13-1
ISO 965-1
ISO 5855-1
LN 29580
LN 9163-1
ASME B1.13M
ASME B1.21M
SAE MA 1370
FED-STD-H28/21

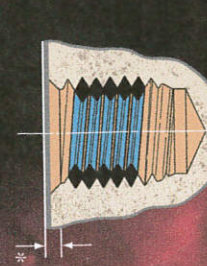
Free diameter values and number of free coils are for guidance purposes only.



DRILLED HOLE
See Note 1 opposite



TAPPED HOLE
See Note 2 opposite



INSTALLED INSERT
See Note 3 opposite

NC (Number of Free Coils)					
1.0D	1.5D	2.0D	2.5D	3.0D	
3.00 - 3.30	5.20 - 5.70	7.40 - 8.10	9.60 - 10.50	11.80 - 13.00	
3.10 - 3.80	5.20 - 6.50	7.40 - 9.20	9.50 - 11.90	11.70 - 14.60	
3.40 - 4.30	5.80 - 7.20	8.20 - 10.10	10.50 - 13.10	12.90 - 16.00	
3.40 - 4.10	5.80 - 7.00	8.20 - 9.80	10.50 - 12.60	12.90 - 15.50	
3.40 - 4.00	5.70 - 6.80	8.10 - 9.60	10.50 - 12.30	12.80 - 15.10	
3.90 - 4.50	6.50 - 7.80	9.20 - 10.60	11.80 - 13.70	14.40 - 16.70	
3.80 - 4.30	6.40 - 7.20	9.10 - 10.1	11.70 - 13.10	14.30 - 16.00	
4.60 - 5.30	7.70 - 8.70	10.70 - 12.10	13.70 - 15.60	16.70 - 19.00	
4.20 - 4.70	7.10 - 7.80	9.90 - 10.90	12.80 - 14.10	15.60 - 17.20	
5.60 - 6.10	9.10 - 10.00	12.50 - 13.80	16.00 - 17.70	19.50 - 21.50	
5.10 - 5.50	8.40 - 9.00	11.70 - 12.50	15.00 - 16.10	18.30 - 19.60	
6.50 - 7.10	10.50 - 11.50	14.50 - 15.80	18.50 - 20.20	22.50 - 24.50	
4.60 - 4.90	7.70 - 8.20	10.80 - 11.50	13.80 - 14.70	16.90 - 18.00	
5.60 - 6.10	9.20 - 10.00	12.70 - 13.80	16.30 - 17.70	19.80 - 21.50	
7.30 - 8.10	11.70 - 12.90	16.10 - 17.80	20.50 - 22.60	24.90 - 27.50	
5.20 - 5.60	8.60 - 9.20	12.00 - 12.80	15.40 - 16.40	18.70 - 20.00	
6.40 - 6.90	10.30 - 11.20	14.20 - 15.40	18.10 - 19.70	22.00 - 23.90	
4.80 - 5.10	7.90 - 8.50	11.10 - 11.90	14.20 - 15.20	17.30 - 18.60	
5.60 - 6.10	9.20 - 10.00	12.70 - 13.80	16.20 - 17.70	19.80 - 21.50	
7.00 - 7.70	11.20 - 12.40	15.50 - 17.00	19.70 - 21.60	23.90 - 26.30	
5.00 - 5.30	8.20 - 8.70	11.40 - 12.10	14.60 - 15.60	17.90 - 19.00	
6.90 - 7.50	11.10 - 12.00	15.30 - 16.50	19.40 - 21.00	23.60 - 25.50	
8.60 - 9.30	13.60 - 14.70	18.60 - 20.20	23.60 - 25.60	28.60 - 31.00	
5.90 - 6.30	9.50 - 10.20	13.20 - 14.20	16.90 - 18.10	20.50 - 22.00	
8.00 - 8.80	12.80 - 13.90	17.50 - 19.10	22.30 - 24.30	27.00 - 29.40	
5.20 - 5.50	8.60 - 9.00	11.90 - 12.50	15.30 - 16.10	18.60 - 19.60	
6.70 - 7.10	10.90 - 11.50	15.00 - 15.80	19.10 - 20.20	23.20 - 24.50	
5.90 - 6.30	9.60 - 10.20	13.30 - 14.20	16.90 - 18.10	20.60 - 22.00	
7.70 - 8.10	12.20 - 12.90	16.80 - 17.80	21.40 - 22.60	25.90 - 27.50	
10.50 - 11.40	16.40 - 17.90	22.40 - 24.40	28.30 - 30.90	34.30 - 37.40	
6.50 - 7.10	10.50 - 11.40	14.50 - 15.80	18.50 - 20.10	22.50 - 24.50	
8.50 - 9.10	13.40 - 14.40	18.40 - 19.80	23.40 - 25.10	28.40 - 30.40	
11.60 - 12.70	18.10 - 19.90	24.60 - 27.00	31.10 - 34.20	37.60 - 41.30	
5.90 - 6.30	9.70 - 10.20	13.40 - 14.20	17.10 - 18.10	20.90 - 22.00	
9.20 - 10.10	14.60 - 15.90	19.90 - 21.70	25.30 - 27.60	30.60 - 33.40	
6.80 - 7.30	11.00 - 11.70	15.20 - 16.20	19.30 - 20.60	23.50 - 25.10	
10.60 - 11.60	16.70 - 18.10	22.70 - 24.70	28.80 - 31.30	34.80 - 37.90	
6.50 - 6.90	10.50 - 11.10	14.50 - 15.30	18.60 - 19.50	22.60 - 23.80	
7.60 - 8.10	12.20 - 12.90	16.80 - 17.80	21.30 - 22.60	25.90 - 27.50	
7.40 - 7.70	11.80 - 12.40	16.20 - 17.00	20.70 - 22.60	25.10 - 26.40	
6.80 - 7.30	11.20 - 11.70	15.40 - 16.20	19.60 - 20.60	23.80 - 25.10	
9.50 - 10.10	14.90 - 15.90	20.40 - 21.70	25.90 - 27.60	31.40 - 33.40	
7.70 - 8.00	12.20 - 12.90	16.80 - 17.70	21.40 - 22.50	26.00 - 27.30	
7.30 - 7.60	11.80 - 12.20	16.20 - 16.80	20.70 - 21.50	25.10 - 26.10	
11.40 - 12.10	17.80 - 18.90	24.20 - 25.70	30.60 - 32.50	37.10 - 39.30	

ISO Metric

As with all engineering practice, the success of any drilling & tapping operation is dependent on many factors, including the quality of the tool, the skill of the operator, the speed / feed / coolant / type etc. Due to the vast range of parent materials now available to the engineer, it is not possible to give specific recommendations. However, when using Wire Thread Inserts it is important that the correct size for diameter & length are achieved and the necessary fit class exists in the tapped hole.

Note 1:
The minimum drilling depth for blind holes is 16 equivalent thread pitches for 1.0D, 1.5D, 2.0D, 2.5D, 3.0D, 3.5D, 4.0D, 4.5D, 5.0D, 5.5D, 6.0D, 6.5D, 7.0D, 7.5D, 8.0D, 8.5D, 9.0D, 9.5D, 10.0D, 10.5D, 11.0D, 11.5D, 12.0D, 12.5D, 13.0D, 13.5D, 14.0D, 14.5D, 15.0D, 15.5D, 16.0D, 16.5D, 17.0D, 17.5D, 18.0D, 18.5D, 19.0D, 19.5D, 20.0D, 20.5D, 21.0D, 21.5D, 22.0D, 22.5D, 23.0D, 23.5D, 24.0D, 24.5D, 25.0D, 25.5D, 26.0D, 26.5D, 27.0D, 27.5D, 28.0D, 28.5D, 29.0D, 29.5D, 30.0D, 30.5D, 31.0D, 31.5D, 32.0D, 32.5D, 33.0D, 33.5D, 34.0D, 34.5D, 35.0D, 35.5D, 36.0D, 36.5D, 37.0D, 37.5D, 38.0D, 38.5D, 39.0D, 39.5D, 40.0D, 40.5D, 41.0D, 41.5D, 42.0D, 42.5D, 43.0D, 43.5D, 44.0D, 44.5D, 45.0D, 45.5D, 46.0D, 46.5D, 47.0D, 47.5D, 48.0D, 48.5D, 49.0D, 49.5D, 50.0D, 50.5D, 51.0D, 51.5D, 52.0D, 52.5D, 53.0D, 53.5D, 54.0D, 54.5D, 55.0D, 55.5D, 56.0D, 56.5D, 57.0D, 57.5D, 58.0D, 58.5D, 59.0D, 59.5D, 60.0D, 60.5D, 61.0D, 61.5D, 62.0D, 62.5D, 63.0D, 63.5D, 64.0D, 64.5D, 65.0D, 65.5D, 66.0D, 66.5D, 67.0D, 67.5D, 68.0D, 68.5D, 69.0D, 69.5D, 70.0D, 70.5D, 71.0D, 71.5D, 72.0D, 72.5D, 73.0D, 73.5D, 74.0D, 74.5D, 75.0D, 75.5D, 76.0D, 76.5D, 77.0D, 77.5D, 78.0D, 78.5D, 79.0D, 79.5D, 80.0D, 80.5D, 81.0D, 81.5D, 82.0D, 82.5D, 83.0D, 83.5D, 84.0D, 84.5D, 85.0D, 85.5D, 86.0D, 86.5D, 87.0D, 87.5D, 88.0D, 88.5D, 89.0D, 89.5D, 90.0D, 90.5D, 91.0D, 91.5D, 92.0D, 92.5D, 93.0D, 93.5D, 94.0D, 94.5D, 95.0D, 95.5D, 96.0D, 96.5D, 97.0D, 97.5D, 98.0D, 98.5D, 99.0D, 99.5D, 100.0D, 100.5D, 101.0D, 101.5D, 102.0D, 102.5D, 103.0D, 103.5D, 104.0D, 104.5D, 105.0D, 105.5D, 106.0D, 106.5D, 107.0D, 107.5D, 108.0D, 108.5D, 109.0D, 109.5D, 110.0D, 110.5D, 111.0D, 111.5D, 112.0D, 112.5D, 113.0D, 113.5D, 114.0D, 114.5D, 115.0D, 115.5D, 116.0D, 116.5D, 117.0D, 117.5D, 118.0D, 118.5D, 119.0D, 119.5D, 120.0D, 120.5D, 121.0D, 121.5D, 122.0D, 122.5D, 123.0D, 123.5D, 124.0D, 124.5D, 125.0D, 125.5D, 126.0D, 126.5D, 127.0D, 127.5D, 128.0D, 128.5D, 129.0D, 129.5D, 130.0D, 130.5D, 131.0D, 131.5D, 132.0D, 132.5D, 133.0D, 133.5D, 134.0D, 134.5D, 135.0D, 135.5D, 136.0D, 136.5D, 137.0D, 137.5D, 138.0D, 138.5D, 139.0D, 139.5D, 140.0D, 140.5D, 141.0D, 141.5D, 142.0D, 142.5D, 143.0D, 143.5D, 144.0D, 144.5D, 145.0D, 145.5D, 146.0D, 146.5D, 147.0D, 147.5D, 148.0D, 148.5D, 149.0D, 149.5D, 150.0D, 150.5D, 151.0D, 151.5D, 152.0D, 152.5D, 153.0D, 153.5D, 154.0D, 154.5D, 155.0D, 155.5D, 156.0D, 156.5D, 157.0D, 157.5D, 158.0D, 158.5D, 159.0D, 159.5D, 160.0D, 160.5D, 161.0D, 161.5D, 162.0D, 162.5D, 163.0D, 163.5D, 164.0D, 164.5D, 165.0D, 165.5D, 166.0D, 166.5D, 167.0D, 167.5D, 168.0D, 168.5D, 169.0D, 169.5D, 170.0D, 170.5D, 171.0D, 171.5D, 172.0D, 172.5D, 173.0D, 173.5D, 174.0D, 174.5D, 175.0D, 175.5D, 176.0D, 176.5D, 177.0D, 177.5D, 178.0D, 178.5D, 179.0D, 179.5D, 180.0D, 180.5D, 181.0D, 181.5D, 182.0D, 182.5D, 183.0D, 183.5D, 184.0D, 184.5D, 185.0D, 185.5D, 186.0D, 186.5D, 187.0D, 187.5D, 188.0D, 188.5D, 189.0D, 189.5D, 190.0D, 190.5D, 191.0D, 191.5D, 192.0D, 192.5D, 193.0D, 193.5D, 194.0D, 194.5D, 195.0D, 195.5D, 196.0D, 196.5D, 197.0D, 197.5D, 198.0D, 198.5D, 199.0D, 199.5D, 200.0D, 200.5D, 201.0D, 201.5D, 202.0D, 202.5D, 203.0D, 203.5D, 204.0D, 204.5D, 205.0D, 205.5D, 206.0D, 206.5D, 207.0D, 207.5D, 208.0D, 208.5D, 209.0D, 209.5D, 210.0D, 210.5D, 211.0D, 211.5D, 212.0D, 212.5D, 213.0D, 213.5D, 214.0D, 214.5D, 215.0D, 215.5D, 216.0D, 216.5D, 217.0D, 217.5D, 218.0D, 218.5D, 219.0D, 219.5D, 220.0D, 220.5D, 221.0D, 221.5D, 222.0D, 222.5D, 223.0D, 223.5D, 224.0D, 224.5D, 225.0D, 225.5D, 226.0D, 226.5D, 227.0D, 227.5D, 228.0D, 228.5D, 229.0D, 229.5D, 230.0D, 230.5D, 231.0D, 231.5D, 232.0D, 232.5D, 233.0D, 233.5D, 234.0D, 234.5D, 235.0D, 235.5D, 236.0D, 236.5D, 237.0D, 237.5D, 238.0D, 238.5D, 239.0D, 239.5D, 240.0D, 240.5D, 241.0D, 241.5D, 242.0D, 242.5D, 243.0D, 243.5D, 244.0D, 244.5D, 245.0D, 245.5D, 246.0D, 246.5D, 247.0D, 247.5D, 248.0D, 248.5D, 249.0D, 249.5D, 250.0D, 250.5D, 251.0D, 251.5D, 252.0D, 252.5D, 253.0D, 253.5D, 254.0D, 254.5D, 255.0D, 255.5D, 256.0D, 256.5D, 257.0D, 257.5D, 258.0D, 258.5D, 259.0D, 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384.5D, 385.0D, 385.5D, 386.0D, 386.5D, 387.0D, 387.5D, 388.0D, 388.5D, 389.0D, 389.5D, 390.0D, 390.5D, 391.0D, 391.5D, 392.0D, 392.5D, 393.0D, 393.5D, 394.0D, 394.5D, 395.0D, 395.5D, 396.0D, 396.5D, 397.0D, 397.5D, 398.0D, 398.5D, 399.0D, 399.5D, 400.0D, 400.5D, 401.0D, 401.5D, 402.0D, 402.5D, 403.0D, 403.5D, 404.0D, 404.5D, 405.0D, 405.5D, 406.0D, 406.5D, 407.0D, 407.5D, 408.0D, 408.5D, 409.0D, 409.5D, 410.0D, 410.5D, 411.0D, 411.5D, 412.0D, 412.5D, 413.0D, 413.5D, 414.0D, 414.5D, 415.0D, 415.5D, 416.0D, 416.5D, 417.0D, 417.5D, 418.0D, 418.5D, 419.0D, 419.5D, 420.0D, 420.5D, 421.0D, 421.5D, 422.0D, 422.5D, 423.0D, 423.5D, 424.0D, 424.5D, 425.0D, 425.5D, 426.0D, 426.5D, 427.0D, 427.5D, 428.0D, 428.5D, 429.0D, 429.5D, 430.0D, 430.5D, 431.0D, 431.5D, 432.0D, 432.5D, 433.0D, 433.5D, 434.0D, 434.5D, 435.0D, 435.5D, 436.0D, 436.5D, 437.0D, 437.5D, 438.0D, 438.5D, 439.0D, 439.5D, 440.0D, 440.5D, 441.0D, 441.5D, 442.0D, 442.5D, 443.0D, 443.5D, 444.0D, 444.5D, 445.0D, 445.5D, 446.0D, 446.5D, 447.0D, 447.5D, 448.0D, 448.5D, 449.0D, 449.5D, 450.0D, 450.5D, 451.0D, 451.5D, 452.0D, 452.5D, 453.0D, 453.5D, 454.0D, 454.5D, 455.0D, 455.5D, 456.0D, 456.5D, 457.0D, 457.5D, 458.0D, 458.5D, 459.0D, 459.5D, 460.0D, 460.5D, 461.0D, 461.5D, 462.0D, 462.5D, 463.0D, 463.5D, 464.