

# ME THREAD CHART

DIA		CLEARING		TAPPING							
		Dia		60 TPI		40 TPI		32 TPI			
Frac	Dec	Drill	Clearance	Drill	%	Drill	%	Drill	%		
1/8	0.125	30	3.5 thou	37	98	3/32	97				
				36	87	41	91				
						40	84				
5/32	0.156	21	2.8 thou	29	95	1/8	97				
						3.5mm	86	30	86		
3/16	0.1875	11	2.2 thou	18	89	5/32	97				
								22	93		
								21	86		
7/32	0.2187	2	22 thou			3/16	97				
								12	93		
								11	86		
1/4	0.25	F	7 thou	5.9mm	83	7/32	97	3	93		
								2	91	7/32	76
9/32	0.281	L	8.8 thou			1/4	97				
								F	78		
5/16	0.312	O	3.5 thou			9/32	97	J	89		
								L	78	K	79
3/8	0.375	V	2 thou			11/32	97	R	84		
								S	84	11/32	78
7/16	0.4375	11.2mm	3.4 thou			13/32	97	Y	84		
								X	83		
1/2	0.500	12.8mm	3.9 thou			15/32	97	11.8mm	89		
								12mm	86	15/32	78
								11/32	78		

Depth of thread: 60 TPI – 0.107    40 TPI - 0.16    32 TPI - 0.200

## ME Thread Chart Notes.

For each thread size a number of different tapping drill options are give. For each tapping drill size a % value is given. The larger the drill size, the smaller the % of thread that will be engaged. The larger the percentage size the stronger will be the thread, but the more difficult it will be to tap the hole. In practice, (with several thread engaged) there is not a great deal of difference between the strength at the different % values listed. However drills tend to drill oversize and if you choose a small theoretical percentage value, in practice it may be even smaller than you anticipate.

**Dennis Postelthwaite**