

Heli-Coil thread data - inch

Nominal Thread Size	Pitch Diameter			Minor Diameter		Max. Major Diameter	Thread Pitch
	Min.	3B Max.	2B Max.	Min.	Max.		
UNIFIED COARSE							
1 (.073)-64	.0832	.0843	.0850	.0764	.0823	.0958	.01563
2 (.086)-56	.0976	.0989	.0996	.0899	.0961	.1117	.01786
3 (.099)-48	.1126	.1140	.1148	.1036	.1104	.1289	.02083
4 (.112)-40	.1283	.1299	.1308	.1175	.1252	.1473	.02500
5 (.125)-40	.1413	.1430	.1438	.1305	.1373	.1603	.02500
6 (.138)-32	.1583	.1601	.1611	.1448	.1527	.1817	.03125
8 (.164)-32	.1843	.1862	.1872	.1708	.1781	.2077	.03125
10 (.190)-24	.2170	.2192	.2203	.1990	.2080	.2475	.04167
12 (.216)-24	.2430	.2453	.2464	.2250	.2340	.2735	.04167
1/4 (.2500)-20	.2825	.2851	.2864	.2608	.2704	.3187	.05000
5/16 (.3125)-18	.3486	.3515	.3529	.3245	.3342	.3884	.05556
3/8 (.3750)-16	.4156	.4189	.4203	.3885	.3987	.4602	.06250
7/16 (.4375)-14	.4839	.4875	.4890	.4530	.4639	.5343	.07143
1/2 (.5000)-13	.5499	.5537	.5554	.5166	.5273	.6042	.07692
9/16 (.5625)-12	.6167	.6208	.6225	.5806	.5918	.6751	.08333
5/8 (.65250)-11	.6841	.6885	.6903	.6447	.6564	.7477	.09091
3/4 (.7500)-10	.8149	.8196	.8216	.7716	.7838	.8850	.10000
7/8 (.8750)-9	.9471	.9522	.9543	.8990	.9119	1.0247	.11111
1 (1.000)-8	1.0812	1.0868	1.0890	1.0271	1.0421	1.1681	.12500
1-1/8 (1.1250)-7	1.2178	1.2239	1.2262	1.1559	1.1730	1.3171	.14286
1-1/4 (1.2500)-7	1.3428	1.3490	1.3514	1.2809	1.2980	1.4421	.14286
1-3/8 (1.3750)-6	1.4832	1.4900	1.4926	1.4110	1.4310	1.5982	.16667
1-1/2 (1.5000)-6	1.6082	1.6151	1.6177	1.5360	1.5560	1.7232	.16667
UNIFIED FINE							
2 (.086)-64	.0962	.0974	.0981	.0894	.0947	.1088	.01563
3 (.099)-56	.1106	.1119	.1126	.1029	.1086	.1247	.01786
4 (.112)-48	.1256	.1271	.1279	.1166	.1229	.1419	.02083
6 (.138)-40	.1543	.1560	.1569	.1435	.1503	.1733	.02500
8 (.164)-36	.1821	.1840	.1849	.1701	.1771	.2032	.02778
10 (.190)-32	.2103	.2123	.2133	.1968	.2041	.2337	.03125
1/4 (.2500)-28	.2732	.2754	.2765	.2577	.2646	.2995	.03571
5/16 (.3125)-24	.3395	.3421	.3433	.3215	.3288	.3700	.04167
3/8 (.3750)-24	.4020	.4047	.4059	.3840	.3910	.4325	.04167
7/16 (.4375)-20	.4700	.4731	.4744	.4483	.4561	.5062	.05000
1/2 (.5000)-20	.5325	.5357	.5371	.5108	.5186	.5687	.05000
9/16 (.5625)-18	.5986	.6020	.6035	.5745	.5826	.6384	.05556
5/8 (.6250)-18	.6611	.6646	.6661	.6370	.6451	.7009	.05556
3/4 (.7500)-16	.7906	.7945	.7961	.7635	.7720	.8352	.06250
7/8 (.8750)-14	.9214	.9257	.9274	.8905	.8994	.9718	.07143
1 (1.000)-14	1.0464	1.0508	1.0527	1.0155	1.0243	1.0968	.07143
1 (1.000)-12	1.0542	1.0589	1.0608	1.0181	1.0281	1.1126	.08333
1-1/8 (1.1250)-12	1.1792	1.1841	1.1860	1.1431	1.1531	1.2376	.08333
1-1/4 (1.2500)-12	1.3042	1.3092	1.3112	1.2681	1.2781	1.3626	.08333
1-3/8 (1.3750)-12	1.4292	1.4343	1.4364	1.3931	1.4031	1.4876	.08333
1-1/2 (1.5000)-12	1.5542	1.5595	1.5615	1.5181	1.5281	1.6126	.08333

Heli-Coil drilling data - inch

INCH - DRILLED HOLE DIMENSIONS

Nominal Thread size	Suggested Drill Size	
	Aluminum	Steel, Magnesium, Plastic
UNIFIED COARSE		
1 (.073)-64	#47 (.0785)	#46 (.0810)
2 (.086)-56	3/32 (.0938)	#41 (.0960)
3 (.099)-48	#36 (.1065)	7/64 (.1094)
4 (.112)-40	#31 (.1200)	#31 (.1200)
5 (.125)-40	3.4mm (.1339)	#29 (.1360)
6 (.138)-32	#26 (.1470)	#25 (.1495)
8 (.164)-32	#17 (.1730)	#16 (.1770)
10 (.190)-24	13/64 (.2031)	#5 (.2055)
12 (.216)-24	#1 (.2280)	#1 (.2280)
1/4 (.2500)-20	H (.2660)	H (.2660)
5/16 (.3125)-18	Q (.3320)	Q (.3320)
3/8 (.3750)-16	X (.3970)	X (.3970)
7/16 (.4375)-14	29/64 (.4531)	29/64 (.4531)
1/2 (.5000)-13	33/64 (.5156)	17/32 (.5312)
9/16 (.5625)-12	37/64 (.5781)	19/32 (.5938)
5/8 (.6250)-11	21/32 (.6562)	21/32 (.6562)
3/4 (.7500)-10	25/32 (.7812)	25/32 (.7812)
7/8 (.8750)-9	29/32 (.9062)	29/32 (.9062)
1 (1.000)-8	1-1/32 (1.0312)	1-1/32 (1.0312)
1-1/8 (1.1250)-7	1-11/64 (1.1719)	1-11/64 (1.1719)
1-1/4 (1.2500)-7	1-19/64 (1.2969)	1-19/64 (1.2969)
1-3/8 (1.3750)-6	1-27/64 (1.4219)	1-27/64 (1.4219)
1-1/2 (1.5000)-6	1-35/64 (1.5469)	1-35/64 (1.5469)
UNIFIED FINE		
2 (.086)-64	2.35mm (.0925)	2.35mm (.0925)
3 (.099)-56	#37 (.1040)	#36 (.1065)
4 (.112)-48	3mm (.1181)	#31 (.1200)
6 (.138)-40	#26 (.1470)	#25 (.1495)
8 (.164)-36	#17 (.1730)	#16 (.1770)
10 (.190)-32	#7 (.2010)	13/64 (.2031)
1/4 (.2500)-28	G (.2610)	6.7mm (.2638)
5/16 (.3125)-24	21/64 (.3281)	21/64 (.3281)
3/8 (.3750)-24	25/64 (.3906)	25/64 (.3906)
7/16 (.4375)-20	29/64 (.4531)	29/64 (.4531)
1/2 (.5000)-20	33/64 (.5156)	33/64 (.5156)
9/16 (.5625)-18	37/64 (.5781)	37/64 (.5781)
5/8 (.6250)-18	41/64 (.6406)	41/64 (.6406)
3/4 (.7500)-16	49/64 (.7656)	49/64 (.7656)
7/8 (.8750)-14	57/64 (.8906)	57/64 (.8906)
1 (1.000)-14	1-1/64 (1.0156)	1-1/32 (1.0312)
1 (1.000)-12	1-1/64 (1.0156)	1-1/32 (1.0312)
1-1/8 (1.1250)-12	1-9/64 (1.1406)	1-5/32 (1.1562)
1-1/4 (1.2500)-12	1-17/64 (1.2656)	1-9/32 (1.2812)
1-3/8 (1.3750)-12	1-25/64 (1.3906)	1-13/32 (1.4062)
1-1/2 (1.5000)-12	1-33/64 (1.5156)	1-17/32 (1.5312)