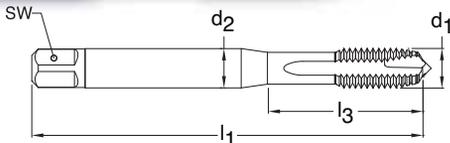


# UNF



Through holes

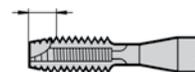


TiCN coated



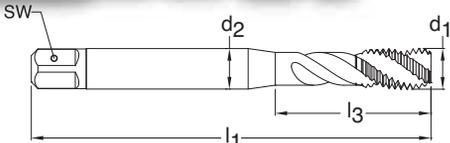
External cooling

**Series 3947**  
**Standard ANSI**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Point Straight flute**  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit 2B**



d1 - P	H Limits	Tap Drill Range inch	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
2-64	H2/H3	0.069 - 0.075	3	0.141	0.110	1.752	0.441	2.184	9039470021840	●
3-56	H2/H3	0.080 - 0.086	3	0.141	0.110	1.811	0.500	2.515	9039470025150	●
4-48	H2/H3	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039470028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039470031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039470035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039470041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039470048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039470054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	2.500	1.181	6.350	9039470063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	2.721	1.377	7.938	9039470079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	2.941	1.456	9.525	9039470095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.161	N/A	11.113	9039470111130	●
1/2-20	H4/H5	0.446 - 0.457	4	0.367	0.275	3.382	N/A	12.700	9039470127000	●
9/16-18	H4/H5	0.502 - 0.515	4	0.429	0.322	3.591	N/A	14.288	9039470142880	●
5/8-18	H4/H5	0.565 - 0.578	4	0.480	0.360	3.811	N/A	15.875	9039470158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.252	N/A	19.050	9039470190500	●
7/8-14	H6/H7	0.798 - 0.813	4	0.697	0.523	4.689	N/A	22.225	9039470349250	●
1-12	H6/H7	0.910 - 0.928	4	0.800	0.600	5.130	N/A	25.400	9039470254000	●
1 1/8- 12	H6/H7	1.035 - 1.053	4	0.896	0.672	5.441	N/A	28.575	9039470285750	●
1 1/4-12	H7/H8	1.160 - 1.178	4	1.021	0.766	5.748	N/A	31.750	9039470317500	●
1 3/8- 12	H7/H8	1.285 - 1.303	6	1.108	0.831	6.063	N/A	34.925	9039470349250	●
1 1/2-12	H7/H8	1.410 - 1.428	6	1.233	0.925	6.378	N/A	38.100	9039470381000	●

# UNF



Blind holes



TiCN coated



External cooling

**Series 3950**  
**Standard ANSI**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Flute 40° Helix**  
**Chamfer Form C • 2-3**  
**Class of Fit 2B**



d1 - P	H Limits	Tap Drill Range inch	Number of Flutes	d2 inch	SW inch	l1 inch	l3 inch	Order Code	EDP Number	Stock
2-64	H2/H3	0.069 - 0.075	3	0.141	0.110	1.752	0.441	2.184	9039500021840	●
3-56	H2/H3	0.080 - 0.086	3	0.141	0.110	1.811	0.500	2.515	9039500025150	●
4-48	H2/H3	0.089 - 0.097	3	0.141	0.110	1.882	0.709	2.845	9039500028450	●
5-44	H2/H3	0.100 - 0.108	3	0.141	0.110	1.941	0.709	3.175	9039500031750	●
6-40	H2/H3	0.111 - 0.119	3	0.141	0.110	2.000	0.748	3.505	9039500035050	●
8-36	H2/H3	0.134 - 0.142	3	0.168	0.131	2.130	0.827	4.166	9039500041660	●
10-32	H3/H4	0.156 - 0.164	3	0.194	0.152	2.382	0.945	4.826	9039500048260	●
12-28	H3/H4	0.177 - 0.186	3	0.220	0.165	2.382	1.024	5.486	9039500054860	●
1/4-28	H3/H4	0.211 - 0.220	3	0.255	0.191	2.500	1.181	6.350	9039500063500	●
5/16-24	H3/H4	0.267 - 0.277	3	0.318	0.238	2.721	1.377	7.938	9039500079380	●
3/8-24	H3/H4	0.330 - 0.340	3	0.381	0.286	2.941	1.456	9.525	9039500095250	●
7/16-20	H4/H5	0.383 - 0.395	3	0.323	0.242	3.161	N/A	11.113	9039500111130	●
1/2-20	H4/H5	0.446 - 0.457	3	0.367	0.275	3.382	N/A	12.700	9039500127000	●
9/16-18	H4/H5	0.502 - 0.515	3	0.429	0.322	3.591	N/A	14.288	9039500142880	●
5/8-18	H4/H5	0.565 - 0.578	4	0.480	0.360	3.811	N/A	15.875	9039500158750	●
3/4-16	H5/H6	0.682 - 0.696	4	0.590	0.442	4.252	N/A	19.050	9039500190500	●
7/8-14	H6/H7	0.798 - 0.813	4	0.697	0.523	4.689	N/A	22.225	9039500222250	●
1-12	H6/H7	0.910 - 0.928	4	0.800	0.600	5.130	N/A	25.400	9039500254000	●
1 1/8- 12	H6/H7	1.035 - 1.053	4	0.896	0.672	5.441	N/A	28.575	9039500285750	●
1 1/4-12	H6/H7	1.160 - 1.178	4	1.021	0.766	5.748	N/A	31.750	9039500317500	●
1 1/2-12	H6/H7	1.410 - 1.428	6	1.233	0.925	6.378	N/A	38.100	9039500381000	●

"Tap drill Range" given is per the Class of Fit shown per Series #  
 Additional Tap Drill sizes & percent of thread engagement can be found on pages 199 - 206.