

USEFUL DATA

BA THREADS RECOMMENDED TAPPING AND CLEARANCE DRILLS

BA Size	Tapping		Clearance	
	No.	mm	No.	mm
0	8	5.1	D	6.1
1	16	4.5	2	5.4
2	22	4.0	10	4.80
3	29	3.40	18	4.20
4	31	3.00	24	3.70
5	37	2.65	29	3.30
6	43	2.30	32	2.90
7	46	2.05	36	2.60
8	50	1.80	41	2.25
9	53	1.55	45	1.95
10	54	1.40	49	1.75
12	59	1.05	54	1.40

MODEL ENGINEER THREADS TAPPING DRILL SIZES

Size	Drill Size	
	No.	mm
$\frac{1}{8} \times 40$	38	2.55
$\frac{5}{32} \times 40$	30	3.25
$\frac{3}{16} \times 40$	21	4.00
$\frac{7}{32} \times 40$	11	4.80
$\frac{1}{4} \times 26$	4	5.30
$\frac{1}{4} \times 32$	} $\frac{7}{32}$	5.50
$\frac{1}{4} \times 40$		
$\frac{5}{16} \times 32$	J	7.00
$\frac{5}{16} \times 40$	$\frac{9}{32}$	7.10
$\frac{3}{8} \times 32$	} $\frac{11}{32}$	8.70
$\frac{3}{8} \times 40$		
$\frac{7}{16} \times 40$	$\frac{13}{32}$	10.30
$\frac{1}{2} \times 40$	$\frac{15}{32}$	11.90

BA HEXAGON SCREW SIZES

	Standard Head A/F	Size Smaller Head A/F	Overall Thread Dia.
0BA	0.413	-	0.236
2BA	0.324	7.0mm	0.185
3BA	0.282	-	0.161
4BA	0.248	5.5mm	0.141
5BA	0.218	5.0mm	0.126
6BA	0.193	4.5mm	0.110
7BA	0.172	4.0mm	0.098
8BA	0.152	3.5mm	0.086
9BA	0.131	-	0.074
10BA	0.117	-	0.066

B.S.B. THREADS - TAPPING DRILL SIZES

Size	Drill Size	
	No.	mm
$\frac{5}{16} \times 26$	I	6.9
$\frac{3}{8} \times 26$	Q	8.4
$\frac{7}{16} \times 26$	$\frac{25}{64}$	9.92
$\frac{1}{2} \times 26$	$\frac{29}{64}$	11.50
$\frac{5}{8} \times 26$	$\frac{37}{64}$	14.50

ALLEN KEY SIZES

Size	Cap Head	CSK	Grub
2BA	$\frac{5}{32}$	$\frac{3}{32}$	$\frac{3}{32}$
4BA	$\frac{3}{32}$	$\frac{1}{16}$	$\frac{1}{16}$
5BA	$\frac{3}{32}$		
6BA	$\frac{5}{64}$	0.050	0.050
8BA	$\frac{1}{16}$	0.035	0.035