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HARDEST MATERIAL TAPPED (AN AERO. OR FEDERAL SPEC; STEEL OR ALLOY NUMBER)	SCREW SIZE NO.	THICKNESS OF HARDEST MATERIAL TAPPED (INCHES)													
		.015 to .018 incl	.018 to .040 incl	.041 to .056 incl	.057 to .071 incl	.072 to .089 incl	.091 to .110 incl	.103 to .115 incl	.113 to .137 incl	.132 to .148 incl	Over .148				
		DRILL HOLES FOR SCREWS TO DIAMETERS SPECIFIED BELOW (INCHES)													
STEEL	CARBON MILD QUARTER-HARD (55,000 PSI MIN TEN STR) SPEC AN-S-11 (1)	4-24	.086	.091	.096	.099	.101								
		6-20	.104	.106	.111	.116	.120		.128						
		8-18	.116	.116	.128	.136	.140		.149	.149	.152				
		10-16	.144	.144	.144	.152	.157		.161	.169	.169	.173			
		14-14	.185	.185	.191	.199	.204		.209	.228	.228	.234			
	CHROME-POLYBLENDEM NORMALIZED (1) (90,000 PSI MIN TEN STR) SPEC AN-QQ-S-685	4-24	.089	.091	.096	.099	.101								
		6-20	.110	.110	.116	.120	.120	.128							
		8-18	.128	.128	.136	.136	.140	.144		.149					
		10-16	.154	.154	.154	.157	.161	.169		.169	.169	.173			
		14-14	.191	.191	.191	.199	.204	.209		.228	.228	.234			
	CORROSION (1) RESISTING HALF HARD (150,000 PSI MIN TEN STR)	4-24	.091	.093	.099										
		6-20	.110	.110	.116	.116									
		8-18	.128	.128	.136	.140	.144								
		10-16			.157	.161	.166	.169							
		14-14			.191	.199	.204	.209	.213	.228					
ALUMINUM ALLOY	AL-MAGNESIUM CHROM. HALF-HARD (34,000 PSI MIN TEN STR) SPEC QQ-A-318	4-24	.086	.086	.091	.096	.099								
		6-20	.104	.104	.106	.111	.116								
		8-18	.116	.116	.116	.128	.136		.149						
		10-16	.144	.144	.144	.144	.152		.161	.169					
		14-14	.180	.185	.185	.191	.199		.209	.218					
	AL-COPPER-MAGNESIUM-MANGANESE HEAT TREATED (52,000 PSI MIN TEN STR) SPEC QQ-A-362 (1)	4-24	.086	.086	.091	.096	.096	.099							
		6-20	.104	.104	.106	.106	.111	.113		.116					
		8-18	.116	.116	.116	.128	.128	.136		.140					
		10-16	.144	.144	.144	.144	.152	.152		.157	.161				
		14-14	.185	.185	.185	.191	.199	.204		.209	.228				
	AL-COPPER-MAGNESIUM (1.5% MANGANESE) HEAT TREATED (62,000 PSI MIN TEN STR) SPEC QQ-A-355	4-24	.086	.086	.086	.091	.096								
		6-20	.104	.104	.106	.106	.111								
		8-18	.116	.116	.116	.128	.128								
		10-16	.144	.144	.144	.149	.152								
		14-14	.185	.185	.185	.191	.199								
CASTINGS ALUMINUM ALLOY OR ALUMINUM	4-24				.099	.101	.101								
	6-20				.116	.120	.120	.128							
	8-18				.144	.144	.144	.149	.149	.149	.152				
	10-16				.157	.157	.157	.161	.169	.169	.173				
	14-14				.191	.199	.204	.209	.221	.228	.234				

(1) LUBRICATE WITH HEAVY CUTTING OIL.

(1) ABOVE HOLE SIZES SHALL APPLY TO SHEET METAL SCREWS CONFORMING TO DRAWINGS AN530 AND AN511.

DRILL EACH PLY OR PLATE OF THE ASSEMBLY TO THE SIZE STATED FOR ITS HARDNESS AND THICKNESS. FOR ASSEMBLIES ALREADY RIVETED TOGETHER, THE SIZE OF THE HOLE SHALL DEPEND ON THE HARDEST PLY OR PLATE EMPLOYED AS A NUT PLATE OR A TAPPED INTERMEDIATE PLATE.

WHENEVER PRACTICABLE, THE DIAMETER OF THE SCREW SHALL BE SUCH THAT THE DRILL HOLE SIZE WILL FALL BETWEEN THE VERTICAL HEAVY LINES IN THE TABLE.

AIR FORCE - NAVY AERONAUTICAL DESIGN STANDARD
 SIZES TAPPING SCREWS - COARSE THREAD (HOLE SIZES FOR)

AND10325

NOT A PART NUMBER

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