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NOTE: This drawing was approved by Joint action of the War and Navy Departments as the Army-Navy standard for this product. This drawing supersedes all antecedent standard drawings for this product, and shall be used for all production not later than six months after the latest date of approval shown. It may be put into effect however at an earlier date after announcement.

Hardest Material Tapped (All 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 .085 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)									
Carbon Mild Quarter-Hard (55,000 p.s.i. Min. T. S.) Spec. AN-Q-3-55	4-40	.086	.086	.086	.093	.093		.096	.096	.096	
	6-32	.104	.104	.104	.113	.113		.113	.120	.120	
	8-32	.128	.128	.128	.140	.140		.140	.144	.144	
	10-24	.149	.149	.149	.154	.154		.154	.161	.161	
	1/4-20	.199	.199	.199	.209	.209		.209	.213	.213	
Chrome-Molybdenum Normalized (1) (90,000 p.s.i. Min. T. S.) Spec. AN-QQ-3-685	4-40	.089	.089	.089	.089	.096	.096		.096		
	6-32	.110	.110	.110	.110	.116	.120		.120		
	8-32	.136	.136	.136	.136	.140	.144		.144		
	10-24	.157	.157	.157	.157	.156	.161		.161		
	1/4-20	.209	.209	.209	.209	.215	.218		.218	.218	
Corrosion Resisting (1) Half Hard (150,000 p.s.i. Min. T. S.)	4-40	.093	.093	.096							
	6-32	.110	.110	.110	.116						
	8-32	.136	.136	.140	.140	.144					
	10-24			.159	.161	.161	.166				
	1/4-20			.205	.205	.209	.213	.218	.221		
Alum.-Magnesium Chrom. Half-Hard (74,000 p.s.i. Min. T. S.) Spec. QQ-A-318	4-40	.086	.086	.086	.086	.089			.093		
	6-32	.104	.104	.104	.104	.106			.106		
	8-32	.128	.128	.128	.128	.136			.140		
	10-24	.149	.149	.149	.149	.152			.154		
	1/4-20	.193	.193	.199	.199	.204			.204		
Alum.-Copper-Magn.-Manganese Heat Treated (52,000 p.s.i. Min. T. S.) Spec. QQ-A-301	4-40	.086	.086	.086	.086	.089	.089		.093		
	6-32	.104	.104	.104	.104	.106	.106		.106		
	8-32	.128	.128	.128	.128	.136	.140		.140		
	10-24	.149	.149	.149	.149	.152	.152		.154		
	1/4-20	.199	.199	.199	.199	.204	.204		.204		
Alum.-Copper-Magn. (1.5% Manganese) Heat Treated (62,000 p.s.i. Min. T. S.) Spec. QQ-A-355	4-40	.086	.086	.086	.089	.089					
	6-32	.104	.104	.104	.109	.109					
	8-32	.129	.129	.129	.136	.136					
	10-24	.149	.149	.149	.152	.152					
	1/4-20	.199	.199	.199	.203	.203					
Castings (Aluminum Alloy or Aluminum)	4-40				.096	.096	.096	.096	.098	.098	.098
	6-32				.116	.116	.116	.116	.120	.120	.120
	8-32				.144	.144	.144	.144	.147	.147	.147
	10-24				.161	.161	.161	.161	.166	.166	.166
	1/4-20				.221	.221	.221	.221	.228	.228	.228

(1) LUBRICATE WITH HEAVY CUTTING OIL.

1 ABOVE HOLE SIZES SHALL APPLY ONLY TO SELF TAPPING SCREWS CORRESPONDING TO DRAWINGS 42506 AND AN506.

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 OF 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.

ARMY-NAVY AERONAUTICAL DESIGN STANDARD

SELF TAPPING SCREWS - MACHINE SCREW THREAD (HOLE SIZES - R)

AND 10326

NOT A PART NUMBER

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