

Limits per ASME B1.1-2024 (UN, UNJ), SAE AS8879B (UNJ 3B), ASME B1.13M-1995 / ISO 965-1 and ISO 261 (M), ASME B1.21M-1978 (MJ). % thread = 100 (D - drill) / 1.299P Forming-tap holes use the tap makers' formula D - 0.0068 %P; confirm with your tap maker. Drills cut oversize; gage Class 3B and UNJ holes. Drill sizes per ASME B94.11M. Reference only; the controlling standard governs.