



## Assembly instructions for tapping screws

| Nominal thread diameter d <sub>t</sub> | Sheet thickness* s |                          | Drilling hole Ø (Tol. H 12) for tapping screws from material |                          |   |                 | Stainless steels            |         |
|--|--------------------|--------------------------|--|--------------------------|---|-----------------|-----------------------------|---------|
|  |                    |                          | Hardened steel (min 450 HV)                                  |                          |   |                 | A 2/A 4 (approx. 250 HV) ** |         |
|  |                    |                          | Drift-enlarged/Continuous hole<br>Sheet from material        |                          | Drilled/Punched hole<br>Sheet from material |                 | Sheet from material         |         |
| >                                      | ≤                  | St, Ni, MS,<br>Cu, Monel | Al   | St, Ni, MS,<br>Cu, Monel | Al  | Steel<br>St. 37 | Al                          |         |
| <b>4.2 mm</b>                          | –                  | 0.50                     | 3.50   | –                        | –   | –               | –                           | –       |
|  | 0.50               | 0.63                     | 3.50   | 3.50                     | 3.20  | –               | –                           | –       |
|  | 0.63               | 0.88                     | 3.50   | 3.50                     | 3.20  | 2.95            | –                           | –       |
|  | 0.8                | 1.13                     | 3.50   | 3.50                     | 3.20  | 3.00            | 3.20                        | 3.30    |
|  | 1.13               | 1.38                     | 3.50   | 3.50                     | 3.30  | 3.20            | 3.20                        | 3.30    |
|  | 1.38               | 2.50                     | –  | –                        | 3.50  | 3.50            | 3.30                        | 3.40    |
|  | 2.50               | 3.00                     | –  | –                        | 3.80  | 3.70            | 3.30                        | 3.40    |
|  | 3.00               | 3.50                     | –  | –                        | 3.90  | 3.80            | 3.40                        | 3.50    |
|  | 3.50               | 10.00                    | –  | –                        | –   | 3.90            | 3.5–3.6                     | 3.6–3.7 |
|  | <b>4.8 mm</b>      | –                        | 0.50   | 4.00                     | –   | –               | –                           | –       |
| 0.50                                   |                    | 0.75                     | 4.00   | 4.00                     | 3.70  | –               | –                           | –       |
| 0.75                                   |                    | 1.13                     | 4.00   | 4.00                     | 3.70  | 3.70            | –                           | –       |
| 1.13                                   |                    | 1.38                     | 4.00   | 4.00                     | 3.90  | 3.70            | 3.70                        | 3.90    |
| 1.38                                   |                    | 1.75                     | –  | –                        | 3.90  | 3.70            | 3.70                        | 3.90    |
| 1.75                                   |                    | 2.50                     | –  | –                        | 4.00  | 3.80            | 3.80                        | 3.90    |
| 2.50                                   |                    | 3.00                     | –  | –                        | 4.10  | 3.80            | 3.80                        | 3.90    |
| 3.00                                   |                    | 3.50                     | –  | –                        | 4.30  | 3.90            | 3.90                        | 4.00    |
| 3.50                                   |                    | 4.00                     | –  | –                        | 4.40  | 3.90            | 3.90                        | 4.00    |
| 4.00                                   |                    | 4.75                     | –  | –                        | 4.40  | 4.00            | 4.00                        | 4.10    |
| 4.75                                   |                    | 10.00                    | –  | –                        | –   | 4.20            | 4.1–4.2                     | 4.2–4.3 |
| <b>5.5 mm</b>                          | –                  | 1.13                     | 4.70   | –                        | 4.20  | –               | –                           | –       |
|  | 1.13               | 1.38                     | 4.70   | –                        | 4.30  | 4.10            | –                           | –       |
|  | 1.38               | 1.50                     | –  | –                        | 4.30  | 4.10            | –                           | –       |
|  | 1.50               | 1.75                     | –  | –                        | 4.50  | 4.20            | –                           | –       |
|  | 1.75               | 2.25                     | –  | –                        | 4.60  | 4.40            | 4.50                        | 4.60    |
|  | 2.25               | 3.00                     | –  | –                        | 4.70  | 4.60            | 4.50                        | 4.60    |
|  | 3.00               | 3.50                     | –  | –                        | 5.00  | 4.60            | 4.60                        | 4.70    |
|  | 3.50               | 4.00                     | –  | –                        | 5.00  | 4.80            | 4.60                        | 4.70    |
|  | 4.00               | 4.75                     | –  | –                        | 5.10  | 4.80            | 4.70                        | 4.80    |
|  | 4.75               | 10.00                    | –  | –                        | –   | 4.90            | 4.7–4.9                     | 4.8–5.0 |
| <b>6.3 mm</b>                          | –                  | 1.38                     | 5.30   | –                        | 4.90  | –               | –                           | –       |
|  | 1.38               | 1.75                     | –  | –                        | 5.00  | 5.00            | –                           | –       |
|  | 1.75               | 2.00                     | –  | –                        | 5.20  | 5.00            | –                           | –       |
|  | 2.00               | 3.00                     | –  | –                        | 5.30  | 5.20            | 5.30                        | 5.40    |
|  | 3.00               | 4.00                     | –  | –                        | 5.80  | 5.30            | 5.40                        | 5.50    |
|  | 4.00               | 4.75                     | –  | –                        | 5.90  | 5.40            | 5.50                        | 5.60    |
|  | 4.75               | 5.00                     | –  | –                        | –   | 5.60            | 5.50                        | 5.60    |
|  | 5.00               | 10.00                    | –  | –                        | –   | 5.80            | 5.6–5.7                     | 5.7–5.8 |