



Assembly Preparation for Countr-Bor and Hex Socket Head Capscrews

Dia./Pitch	Tap Drill Size	Shank Drill Size	Countr-Bor Drill (Inches)
1/4-20	No. 6	K	27/64
1/4-28	No. 3	K	27/64
5/16-18	G	11/32"	33/64
5/16-24	I	11/32"	33/64
3/8-16	O	13/32"	39/64
3/8-24	Q	13/32"	39/64
7/16-14	U	15/32"	45/64
7/16-20	25/64"	15/32"	45/64
1/2-13	27/64"	17/32"	51/64
1/2-20	29/64"	17/32"	51/64

Dia./Pitch	Tap Drill Size	Shank Drill Size	Countr-Bor Drill (Inches)
9/16-12	31/64"	19/32"	57/64
9/16-18	1/2"	19/32"	57/64
5/8-11	17/32"	21/32"	1
5/8-18	37/64"	21/32"	1
3/4-10	21/32"	25/32"	1-3/16
3/4-16	11/16"	25/32"	1-3/16
7/8-9	49/64"	29/32"	1-3/8
7/8-14	13/16"	29/32"	1-3/8
1-8	7/8"	1-1/32"	1-9/16
1-14	15/16"	1-1/32"	1-9/16

Shank and Countr-Bor drill sizes are based on maximum allowable runout and bow of longest standard screws and also have allowances for minor misalignment of holes in parts to be assembled. On hard mating surfaces, chamfering of shank hole should be considered.