

Borehole diameters, guidelines for Types 307, 308 and 308 2

Material	Light alloys with tensile strength R_m (MPa)	< 250			
		< 300			
		< 350			
	Brass, bronze, non-ferrous metal with tensile strength R_m (MPa)			≥ 350	
				≥ 350	
	Cast iron with Brinell hardness (HB)	< 150			
< 200					
			≥ 200		
	M3	4.6	4.7	4.7	4.8
	M4	6	6.1	6.1	6.2
	M5	7.4	7.5	7.6	7.7
	M6	9.3	9.4	9.5	9.6
	M8	11.1	11.2	11.3	11.5
	M10	13.1	13.2	13.3	13.5
	M12	15	15.1	15.2	15.4
	M16	19	19.1	19.2	19.4
Flank overlap (approximately)		60%	50%	40%	30%

Recommended hole diameters for easy assembly. Other diameters may require lubrication. These specifications are recommendations only and apply to hardened and plated steel inserts.