

Borehole diameters, guidelines for Types 302 and 302 2

Material	Light alloys with tensile strength R_m (MPa)	< 250				
		< 300				
		< 350				≥ 350
	Brass, bronze, non-ferrous metal with tensile strength R_m (MPa)					≥ 350
	Cast iron with Brinell hardness (HB)	< 150				
		< 200				≥ 200
			≥ 200			
Thread insert	M2,5		4.1	4.2	4.3	
	M3		4.6	4.7	4.8	
	M4	5.9	6	6.1	6.2	
	M5	7.2	7.3	7.5	7.6	
	M6	8.8	9	9.2	9.4	
	M8	10.8	11	11.2	11.4	
	M10	12.8	13	13.2	13.4	
	M12	14.8	15	15.2	15.4	
	M14	16.8	17	17.2	17.4	
	M16	18.8	19	19.2	19.4	
	M18	20.8	21	21.2	21.4	
	M20	24.8	25	25.2	25.4	
	M22	24.8	25	25.2	25.4	
	M24	28.8	29	29.2	29.4	
	M27	32.8	33	33.2	33.4	
M30	34.8	35	35.2	35.4		
Flank overlap (approximately)		80%	70%	60%	50%	

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