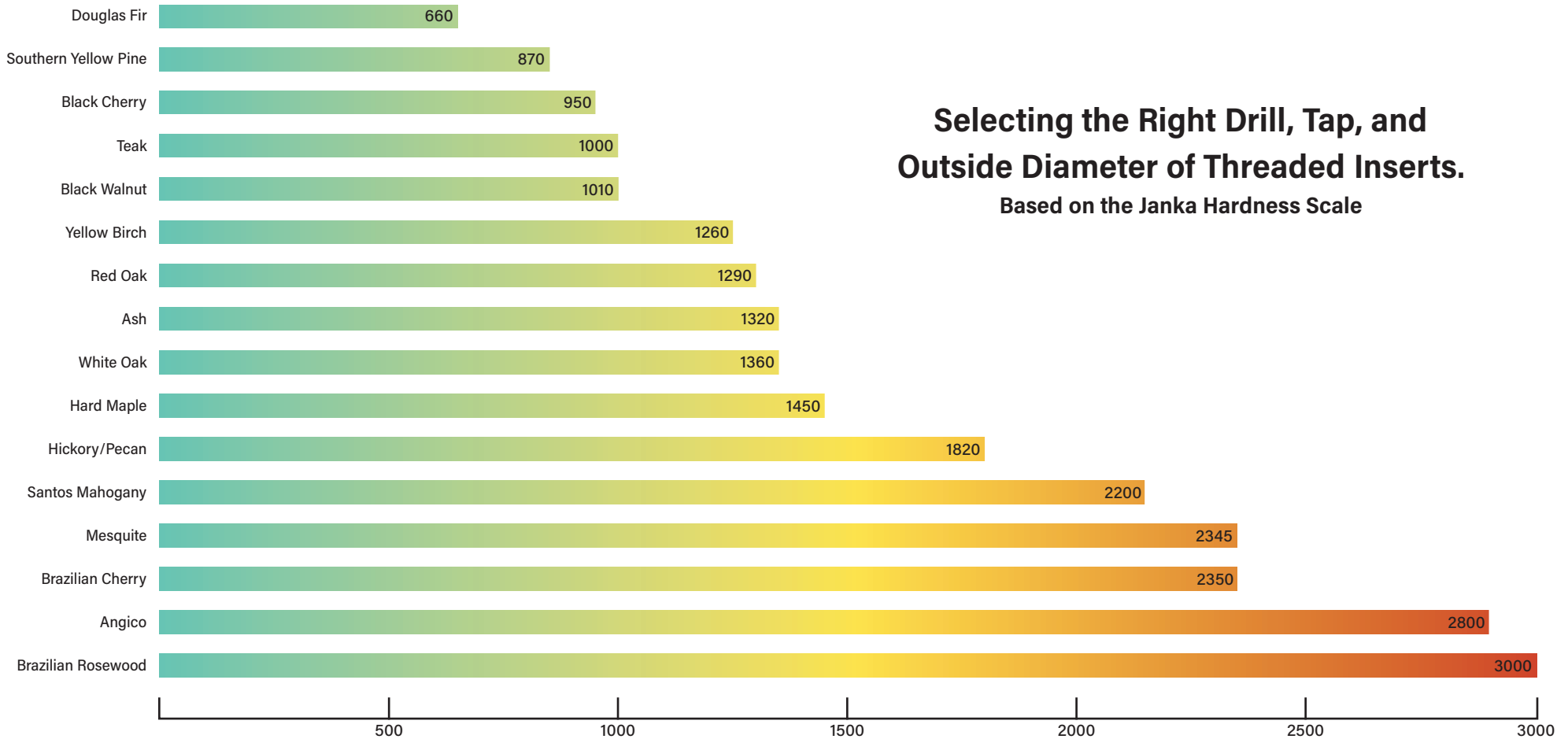


# Strong Reusable Threads Made Easy



**Selecting the Right Drill, Tap, and Outside Diameter of Threaded Inserts.**  
Based on the Janka Hardness Scale

## Recommendations

Drill hole with recommended drill size Lubricate insert (e.g., wax, varnish; if required)	Increase drill size 1/64 Lubricate insert (e.g., wax, varnish, liquid soap) Consider threading the hole with a tap before installation	Increase drill size 1/64 Lubricate insert (e.g., wax, varnish, liquid soap) Required: thread the hole with a tap before installation
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Drill Size	Recommended Tap Size
17/64 or 9/32	5/16-18
25/64 or 13/32	7/16-14
33/64 or 17/32	9/16-12

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