

Drill Depth Clearance in Blind Holes

Chamfer Teeth + One Pitch + 1mm = Clearance

- Bottom Tap has 1 to 2 teeth in chamfer or lead.
- Semi Bottom Tap has 2 to 3 teeth in lead.
- Modified Bottom has 2 to 4 teeth in lead.
- Plug Tap has 3 to 5 teeth in lead.
- Modified Plug has 5 to 7.
- Roll Form Tap has typically 2 1/2.

Example:

1/4-20 Roll Form tap 1/2" deep.

Chamfer Teeth = 2.5 X pitch (.050) = .125

Chamfer Teeth + one pitch + 1mm = Clearance

.125 + .050 + .039 = .214

