QA Technology Company, Inc.

A p p l i c a t i o n s N o t e

Drill and Hole Sizes
Conventional Sockets

QA Technology highly recommends that holes initially drilled in fixture plates be verified using pin gauge tools (PG Tools) due to the tolerances of purchased drill bits which can be undersized by as much as .0005" or more. The machine feed rate, RPM and material used, can also affect the hole size. Undersized holes will not pass go-no-go pin gauge testing. Undersized holes may create problems when inserting the sockets. Therefore, QA Technology strongly suggests the use of pin gauges for hole size verification **before** attempting socket installation during the assembly of the fixture.

(See document #ANQ050 for X-Series hole sizes.)

Socket Series	Hole Specification	Suggested Drill Size	Decimal
025-16	.0205 / .0215 [.520 / .550]	#75	0.0210
039-16 **039-25**	.0307 / .0317 [.078 / .810]	1/32" .80 mm	0.0312 0.0315
050-16 **050-05**	.0368 / .0378 [.935 / .960]	#63 .95 mm	0.0370 0.0374
050-T25 **050-T40** **050-R25**	.0380 / .0390 [.970 / .099]	#62 #61	0.0380 0.0390
075-25 **075-40**	.0530 / .0550 [1.35 / 1.40]	1.35 mm #54	0.0531 0.0550
100-05 **100-16** **100-25** **100-40**	.0670 / .0690 [1.70 / 1.75]	#51 1.75 mm	0.0670 0.0689
125-25	.0940 / .0960 [2.39 / 2.44]	2.4 mm #41	0.0945 0.0960