

DRILL CHART and THREAD IDENTIFICATION



Drill sizes are basic recommendations.

For precision and production tolerances, drill chart below is an accurate guide, however final size ultimately depends on material and machining conditions.

METRIC COARSE		
SIZE	mm	inches
2.0 - .4	2.1	
2.2 - .45	2.3	#43
2.5 - .45	2.6	#38
3 - .5	3.2	1/8
3.5 - .6	3.7	#27
4 - .7	4.2	#20
5 - .8	5.2	13/64
6 - 1	6.3	1/4
7 - 1	7.3	9/32
8 - 1.25	8.3	21/64
9 - 1.25	9.5	3/8
10 - 1.5	10.4	13/32
11 - 1.5	11.5	29/64
12 - 1.75	12.5	31/64
13 - 1.75	13.5	17/32
14 - 2	14.5	9/16
15 - 2	15.5	39/64
16 - 2	16.5	21/32
18 - 2.5	18.75	47/64
20 - 2.5	20.75	13/16
22 - 2.5	22.50	57/64
24 - 3	24.50	31/32
27 - 3	28.0	1 3/32
30 - 3.5	30.5	1 13/64
30 - 3	31.0	1 7/32
36 - 4	37.0	1 15/32
39 - 4	40.0	1 9/16
42 - 4.5	43.0	1 11/16
42 - 4	43.0	1 11/16

UNC		
SIZE	mm	inches
#2 - 56	2.3	#43
#3 - 48	2.7	#36
#4 - 40	3.0	#31
#5 - 40	3.4	#29
#6 - 32	3.8	#25
#8 - 32	4.4	#17
#10 - 24	5.1	#8
#12 - 24	5.8	#1
1/4 - 20	6.7	17/64
5/16 - 18	8.3	21/64
3/8 - 16	9.9	25/64
7/16 - 14	11.5	29/64
1/2 - 13	13.0	33/64
9/16 - 12	15.0	19/32
5/8 - 11	16.5	21/32
11/16 - 11	18.0	45/64
3/4 - 10	19.75	25/32
7/8 - 9	23.0	29/32
1 - 8	26.0	1 1/32
1 1/8 - 7	29.5	1 5/32
1 1/4 - 7	33.0	1 19/64
1 3/8 - 6	36.0	1 13/32
1 1/2 - 6	39.0	1 17/32

BSC		
SIZE	mm	inches
1/4 - 26	6.7	17/64
5/16 - 26	8.3	21/64
3/8 - 26	9.9	25/64
7/16 - 26	11.0	7/16
1/2 - 26	12.7	1/2

METRIC MEDIUM		
SIZE	mm	inches
8 - 1	8.30	21/64
9 - 1	9.40	3/8
10 - 1.25	10.40	13/32
11 - 1.25	11.30	7/16
12 - 1.5	12.50	31/64
13 - 1.5	13.20	33/64
14 - 1.5	14.25	9/16
15 - 1.5	15.25	39/64
16 - 1.5	16.50	21/32
18 - 2	18.50	23/32
20 - 2	20.50	13/16
22 - 2	22.50	57/64
24 - 2	24.50	31/32
27 - 2	27.50	1 5/64
30 - 2	30.50	1 13/64
36 - 3	36.50	1 29/64
39 - 3	39.50	1 35/64
42 - 3	43.00	1 11/16

UNF		
SIZE	mm	inches
#3 - 56	2.65	#37
#4 - 48	3.0	#31
#6 - 40	3.8	#25
#8 - 36	4.4	#17
#10 - 32	5.1	#8
1/4 - 28	6.7	17/64
5/16 - 24	8.3	21/64
3/8 - 24	9.9	25/64
7/16 - 20	11.5	29/64
1/2 - 20	13.0	33/64
9/16 - 18	14.5	37/64
5/8 - 18	16.3	41/64
3/4 - 16	19.5	49/64
7/8 - 14	22.5	57/64
1 - 12	26.0	1 1/32
1 - 14	26.0	1 1/32
1 1/8 - 12	29.5	1 5/32
1 1/4 - 12	33.0	1 19/64
1 3/8 - 12	36.0	1 13/32
1 1/2 - 12	39.0	1 17/32

BA		
SIZE	mm	inches
0 BA	6.2	1/4
1 BA	5.5	7/32
2 BA	4.9	#10
4 BA	3.8	#25
6 BA	2.9	#32

METRIC X-FINE		
SIZE	mm	inches
10 - 1	10.40	13/32
11 - 1	11.30	7/16
12 - 1.25	12.50	31/64
13 - 1.25	13.20	33/64
14 - 1.25	14.50	9/16
18 - 1.5*	18.50	23/32
20 - 1.5	20.50	13/16
22 - 1.5	22.50	57/64
24 - 1.5	24.50	31/32
26 - 1.5	26.50	1 1/32
27 - 1.5	27.50	1 5/64
30 - 1.5	30.50	1 13/64
36 - 1.5	36.50	1 29/64
39 - 2	39.50	1 35/64
42 - 2	43.00	1 11/16

BSP		
SIZE	mm	inches
1/8 - 28	9.5	3/8
1/4 - 19	13.0	33/64
3/8 - 19	16.5	21/32
1/2 - 14	20.5	13/16
5/8 - 14	23.5	59/64
3/4 - 14	26.0	1 1/64
1 - 11	32.5	1 9/32

BSW		
SIZE	mm	inches
1/8 - 40	3.40	#29
3/16 - 24	5.10	13/64
1/4 - 20	6.70	17/64
5/16 - 18	8.30	21/64
3/8 - 16	9.90	25/64
7/16 - 14	11.50	29/64
1/2 - 12	13.00	33/64
9/16 - 12	15.00	19/32
5/8 - 11	16.50	21/32
3/4 - 10	19.75	25/32
7/8 - 9	23.00	29/32
1 - 8	26.00	1 1/32
1 1/8 - 7	29.50	1 5/32
1 1/4 - 7	33.00	1 19/64
1 3/8 - 6	36.00	1 13/32
1 1/2 - 6	39.00	1 17/32

SPECIAL SIZES		
SIZE	mm	inches
UNEF		
1/4 - 32	6.6	17/64
HARLEY		
1/4 - 24	6.6	17/64
7/16 - 16	11.5	29/64
CARBURETTOR		
7/8 - 20		7/8
1 - 20		1"
CUMMINS-HEAD BOLT		
11/16 - 16	18.0	45/64

SPARKPLUG		
SIZE	mm	inches
No drilling required, kits have pilot nose self drill taps		
10 - 1		
12 - 1.25		
14 - 1.25		
18 - 1.5		
8 TPI UN		
SIZE	mm	inches
1 1/8 - 8	28.5	1 1/8
1 1/4 - 8	32.0	1 1/4
1 3/8 - 8	35.0	1 3/8
1 1/2 - 8	38.0	1 1/2
1 5/8 - 8	41.0	1 5/8
1 3/4 - 8	44.5	1 3/4
1 7/8 - 8	47.5	1 7/8
2 - 8		2"

NPT		
SIZE	mm	inches
1/8 - 27	9.9	3/8
1/4 - 18	13.5	33/64
3/8 - 18	17.0	21/32
1/2 - 14	21.5	13/16
3/4 - 14	27.0	1 1/64
1 - 11 1/2	33.5	1 9/32

BSF		
SIZE	mm	inches
3/16 - 32	5.1	13/64
1/4 - 26	6.7	17/64
5/16 - 22	8.3	21/64
3/8 - 20	9.9	25/64
7/16 - 18	11.5	29/64
1/2 - 16	13.0	33/64
9/16 - 16	14.5	37/64
5/8 - 14	16.2	41/64
3/4 - 12	19.5	49/64
7/8 - 11	22.5	57/64
1 - 10	26.0	1 1/32
1 1/4 - 9	33.0	1 9/32