

# DRILL & THREAD CHART

## 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	22.75	57/64
24 - 3	24.75	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

## METRIC MEDIUM

8 - 1	8.3	21/64
9 - 1	9.4	3/8
10 - 1.25	10.4	13/32
11 - 1.25	11.3	7/16
12 - 1.5	12.5	31/64
13 - 1.5	13.2	33/64
14 - 1.5	14.25	9/16
15 - 1.5	15.25	39/64

Size	mm	inches
13 - 1.25	13.20	33/64
14 - 1.25	14.25	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

### SPARK PLUG

No drilling required, kits have pilot nose self drill taps

- 10 - 1
- 12 - 1.25
- 14 - 1.25
- 18 - 1.5

### UNC

#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

### UNF

#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

Size	mm	inches
7/8 - 14	22.5	57/64
1 - 12	26.0	1 1/64
1 - 14	26.0	1 1/64
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
<b>BSW</b>		
1/8 - 40	3.4	#29
3/16 - 24	5.1	13/64
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 - 12	13.0	17/32
9/16 - 12	15.0	19/32
5/8 - 11	16.5	21/32
3/4 - 10	19.8	25/32
7/8 - 9	23.0	29/32
1 - 8	26.0	1.02
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
<b>BSF</b>		
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
<b>BA</b>		
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
<b>BSP</b>		
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
<b>BSC</b>		
1/4 - 26	6.7	17/64
5/16 - 26	8.3	21/64
3/8 - 26	9.9	25/64



Size	mm	inches
7/16 -26	11.0	7/16
1/2 - 26	12.7	1/2
<b>NPT</b>		
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
<b>8 TPI UN</b>		
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"
<b>Special sizes – Drill sizes</b>		
UNEF		
1/4 - 32	6.6	17/64
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