

## TAPPING DRILL SIZES

### METRIC COARSE AND FINE THREADS

THREAD SIZE	DRILL (mm)	THREAD SIZE	DRILL (mm)	THREAD SIZE	DRILL (mm)
M1x0.25	0.75	M9x0.75	8.3	M18x2	16
M1.2x0.25	0.95	M9x1	8	M18x2.5	15.5
M1.4x0.3	1.1	M9x1.25	7.8	M20x1	19
M1.6x0.35	1.25	M10x0.5	9.5	M20x1.5	18.5
M1.8x0.35	1.45	M10x0.75	9.3	M20x2	18
M2x0.4	1.6	M10x1	9	M20x2.5	17.5
M2.2x0.45	1.75	M10x1.25	8.8	M22x1	21
M2.5x0.45	2.05	M10x1.5	8.5	M22x1.5	20.5
M2.6x0.45	2.15	M11x1	10	M22x2	20
M3x0.35	2.65	M11x1.25	9.8	M22x2.5	19.5
M3x0.5	2.5	M11x1.5	9.5	M24x1	23
M3.5x0.35	3.15	M12x0.5	11.5	M24x1.5	22.5
M3.5x0.6	2.9	M12x0.75	11.3	M24x2	22
M4x0.5	3.5	M12x1	11	M24x3	21
M4x0.7	3.3	M12x1.25	10.3	M25x1.5	23.5
M4.5x0.5	4	M12x1.5	10.5	M25x2	23
M4.5x0.75	3.75	M12x1.75	10.3	M27x3	24
M5x0.5	4.5	M13x1	12	M30x3.5	26.5
M5x0.75	4.25	M14x1	13	M33x3.5	29.5
M5x0.8	4.2	M14x1.25	12.8	M36x4	32
M6x0.5	5.5	M14x1.5	12.5	M39x4	35
M6x0.75	5.25	M14x2	12	M42x4.5	37.5
M6x1	5	M15x1	14	M45x4.5	40.5
M7x0.5	6.5	M15x1.5	13.5	M48x5	43
M7x0.75	6.25	M16x1	15	M52x5	47
M7x1	6	M16x1.25	14.8	M56x5.5	50.5
M8x0.5	7.5	M16x1.5	14.5	M60x5.5	54.5
M8x0.75	7.25	M16x2	14	M64x6	58
M8x1	7	M18x1	17	M68x6	62
M8x1.25	6.8	M18x1.5	16.5	M72x6	66

To calculate tapping drill size for metric threads subtract the pitch from the major diameter,  
Select the next larger standard drill size.

### UNC & UNF THREADS

UNC	DRILL (mm)	UNF	DRILL (mm)
1.64	1.55	0.80	1.25
2.56	1.8	1.72	1.55
3.48	2.1	2.64	1.85
4.40	2.3	3.56	2.1
5.40	2.6	4.48	2.4
6.32	2.8	5.44	2.7
8.32	3.4	6.40	2.9
10.24	3.9	8.36	3.5
12.24	4.5	10.32	4.1
1/4.20	5.1	12.28	4.6
5/16.18	6.6	1/4.28	5.5
3/8.16	8	5/16.24	6.9
7/16.14	9.4	3/8.24	8.5
1/2.13	10.8	7/16.20	9.9
9/16.12	12.2	1/2.20	11.5
5/8.11	13.6	9/16.18	12.9
3/4.10	16.5	5/8.18	14.5
7/8.9	19.5	3/4.16	17.5
1"8	22.2	7/8.14	20.5
1.1/8.7	25	1"12	23.2
1.1/4.7	28.2	1.1/8.12	26.5
1.3/8.6	30.8	1.1/4.12	29.5
1.1/2.6	34	1.3/8.12	32.8
1.3/4.5	39.5	1.1/2.12	36
2"4.1/2	45.3		

### BSW & BSF THREADS

BSW	DRILL(mm)	BSF	DRILL(mm)
1/8.40	2.54	3/16.32	3.97
3/16.24	3.7	1/4.26	5.37
1/4.20	5.08	5/16.22	6.8
5/16.18	6.5	3/8.20	8.3
3/8.16	7.9	7/16.18	9.7
7/16.14	9.3	1/2.16	11.1
1/2.12	10.6	9/16.16	12.7
9/16.12	12.2	5/8.14	14.1
5/8.11	13.6	11/16.14	15.6
3/4.10	16.5	3/4.12	16.9
13/16.10	18.1	13/16.12	18.5
7/8.9	19.4	7/8.11	19.9
15/16.9	21	1"10	22.9
1"8	22.2	1.1/8.9	25.8
1.1/8.7	24.9	1.1/4.9	28.9
1.1/4.7	28.1	1.3/8.8	31.8
1.3/8.6	30.7	1.1/2.8	34.9
1.1/2.6	33.9	1.5/8.8	38.1
1.5/8.5	36.2	1.3/4.7	40.8
1.3/4.5	39.4	1.7/8.7	44
1.7/8.4.1/2	42	2"7	47.2
2"4.1/2	45.2		