

# TAP DRILLING SIZE - METRIC



**THE BOLTHOLDER LTD**

www.theboltholder.co.nz

## METRIC COARSE

Size		Root Dia. max. mm	Drill Dia. mm	Size		Root Dia. max. mm	Drill Dia. mm
M	Pitch in mm			M	Pitch in mm		
1.6	0.35	1.321	1.25	12	1.75	10.441	10.2
1.8	0.35	1.521	1.45	14	2	12.210	12
2	0.4	1.679	1.6	16	2	14.210	14
2.2	0.45	1.838	1.75	18	2.5	15.744	15.5
2.5	0.45	2.138	2.05	20	2.5	17.744	17.5
3	0.5	2.599	2.5	22	2.5	19.744	19.5
3.5	0.6	3.010	2.9	24	3	21.252	21
4	0.7	3.422	3.3	27	3	24.252	24
4.5	0.75	3.878	3.7	30	3.5	26.771	26.5
5	0.8	4.334	4.2	33	3.5	29.771	29.5
6	1	5.153	5	36	4	32.270	32
7	1	6.153	6	39	4	35.270	35
8	1.25	6.912	6.8	42	4.5	37.799	37.5
9	1.5	7.676	7.5	45	4.5	40.799	40.5
10	1.5	8.676	8.5	48	5	43.297	43
11	1.5	9.676	9.5				

## METRIC FINE

Size	Root Dia. max. mm	Drill Dia. mm	Size	Root Dia. max. mm	Drill Dia. mm	Size	Root Dia. max. mm	Drill Dia. mm
M			M			M		
3 x 0.35	2.721	2.65	14 x 1.25	12.912	12.8	33 x 1.5	31.676	31.5
3.5 x 0.35	3.221	3.1	14 x 1.5	12.676	12.5	33 x 2	31.210	31
4 x 0.5	3.599	3.5	16 x 1	15.153	15	33 x 3	30.252	30
4.5 x 0.5	4.099	4	16 x 1.5	14.676	14.5	36 x 1.5	34.676	34.5
5 x 0.5	4.599	4.5	18 x 1	17.153	17	36 x 2	34.210	34
6 x 0.75	5.378	5.2	18 x 1.5	16.676	16.5	36 x 3	33.252	33
7 x 0.75	6.378	6.2	18 x 2	16.210	16	39 x 1.5	37.676	37.5
8 x 0.75	7.378	7.2	20 x 1	19.153	19	39 x 2	37.210	37
8 x 1	7.153	7	20 x 1.5	18.676	18.5	39 x 3	36.252	36
9 x 0.75	8.378	8.20	20 x 2	18.210	18	42 x 1.5	40.676	40.5
9 x 1	8.153	8	22 x 1	21.153	21	42 x 2	40.210	40
9 x 1.25	7.912	7.80	22 x 1.5	20.676	20.5	42 x 3	39.252	39
10 x 0.75	9.378	9.2	22 x 2	20.210	20	42 x 4	38.270	38
10 x 1	9.153	9	24 x 1	23.153	23	45 x 1.5	43.676	43.5
10 x 1.25	8.912	8.8	24 x 1.5	22.676	22.5	45 x 2	43.210	43
11 x 0.75	10.378	10.25	24 x 2	22.210	22	45 x 3	42.252	42
11 x 1	10.153	10	27 x 1	26.153	26	45 x 4	41.270	41
11 x 1.25	9.912	9.80	27 x 1.5	25.676	25.5	48 x 1.5	46.676	46.5
12 x 1	11.153	11	27 x 2	25.210	25	48 x 2	46.210	46
12 x 1.25	10.912	10.8	30 x 1	29.153	29	48 x 3	45.252	45
12 x 1.5	10.676	10.5	30 x 1.5	28.676	28.5	48 x 4	44.270	44
14 x 1	13.153	13	30 x 2	28.210	28			

# TAP DRILLING SIZE



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## UNC

Size UNC	Root Dia. Max. mm	Drill Dia. mm
nr 4 - 40	2.385	2.35
nr 5 - 40	2.697	2.65
nr 6 - 32	2.896	2.85
nr 8 - 32	3.531	3.5
nr 10 - 24	3.962	3.9
nr 12 - 24	4.597	4.5
1/4 - 20	5.268	5.1
5/16 - 18	6.734	6.6
3/8 - 16	8.164	8
7/16 - 14	9.550	9.4
1/2 - 13	11.013	10.8
9/16 - 12	12.456	12.2
5/8 - 11	13.868	13.5
3/4 - 10	16.833	16.5
7/8 - 9	19.748	19.5
1 - 8	22.598	22.25
1 1/8 - 7	25.349	25
1 1/4 - 7	28.524	28
1 3/8 - 6	31.120	30.5
1 1/2 - 6	34.295	34
1 3/4 - 5	39.814	39.5
2 - 4 1/2	45.598	45

## UNF FINE/SAE

Size UNF	Root Dia. max. mm	Drill Dia. mm
nr 4-48	2.459	2.4
nr 5-44	2.741	2.7
nr 6-40	3.023	2.95
nr 8-36	3.607	3.5
nr 10-32	4.166	4.1
nr 12-28	4.724	4.7
1/4 - 28	5.580	5.5
5/16 - 24	7.038	6.9
3/8 - 24	8.626	8.5
7/16 - 20	10.030	9.9
1/2 - 20	11.618	11.5
9/16 - 18	13.084	12.9
5/8 - 18	14.671	14.5
3/4 - 16	17.689	17.5
7/8 - 14	20.663	20.5
1 - 14 UNS	23.825	24.00
1 - 12	23.569	23.25
1 1/8 - 12	26.744	26.5
1 1/4 - 12	29.919	29.5
1 3/8 - 12	33.094	33
1 1/2 - 12	36.269	36

## WHITWORTH

Size		Root Dia. max. mm	Drill Dia. mm
W	Pitch per inch		
3/32	48	1.910	1.85
1/8	40	2.590	2.55
5/32	32	3.211	3.2
3/16	24	3.744	3.7
7/32	24	4.538	4.5
1/4	20	5.224	5.1
5/16	18	6.661	6.5
3/8	16	8.052	7.9
7/16	14	9.379	9.2
1/2	12	10.610	10.5
9/16	12	12.176	12
5/8	11	13.598	13.5
3/4	10	16.538	16.5
7/8	9	19.411	19.25
1	8	22.185	22
1 1/8	7	24.879	24.75
1 1/4	7	28.054	28
1 3/8	6	30.555	30.5
1 1/2	6	33.730	33.5
1 5/8	5	35.921	35.5
1 3/4	5	39.096	39
1 7/8	4 1/2	41.648	41.5
2	4 1/2	44.823	44.5

## GAS/PIPE THREAD

Size		Root Dia. max. mm	Drill Dia. mm
GAS	Pitch per inch		
1/8	28	8.848	8.8
1/4	19	11.890	11.8
3/8	19	15.395	15.25
1/2	14	19.172	19
5/8	14	21.128	21
3/4	14	24.658	24.5
7/8	14	28.418	28
1	11	30.931	30.5
1 1/4	11	39.592	39.5
1 1/2	11	45.485	45
1 3/4	11	51.428	51
2	11	57.296	57