

# 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  |