

# DECIMAL AND METRIC EQUIVALENTS OF DRILL SIZES

DRILL SIZE	MM	DECIMAL INCHES	DRILL SIZE	MM	DECIMAL INCHES	DRILL SIZE	MM	DECIMAL INCHES
—	0.10	.0039	—	3.00	.1181	R	8.61	.3390
—	0.20	.0079	31	3.05	.1200	11/32	8.73	.3438
—	0.25	.0098	1/8	3.18	.1250	S	8.84	.3480
—	0.30	.0118	30	3.26	.1285	—	9.00	.3543
80	0.34	.0135	29	3.45	.1360	T	9.09	.3580
79	0.37	.0145	28	3.57	.1405	23/64	9.13	.3594
1/64	0.40	.0156	9/64	3.57	.1406	U	9.35	.3680
78	0.41	.0160	27	3.66	.1440	3/8	9.53	.3750
77	0.46	.0180	26	3.73	.1470	V	9.56	.3770
—	.050	.0197	25	3.80	.1495	W	9.80	.3860
76	0.51	.0200	24	3.86	.1520	25/64	9.92	.3906
75	0.53	.0210	23	3.91	.1540	—	10.00	.3937
74	0.57	.0225	5/32	3.97	.1562	X	10.08	.3970
—	0.60	.0236	22	3.99	.1570	Y	10.26	.4040
73	0.61	.0240	—	4.00	.1575	13/32	10.32	.4062
72	0.64	.0250	21	4.04	.1590	Z	10.49	.4130
71	0.66	.0260	20	4.09	.1610	27/64	10.72	.4219
—	0.70	.0276	19	4.22	.1660	—	11.00	.4331
70	0.71	.0280	18	4.31	.1695	7/16	11.11	.4375
69	0.74	.0292	11/64	4.37	.1719	29/64	11.51	.4531
—	0.75	.0295	17	4.39	.1730	15/32	11.91	.4688
68	0.79	.0310	16	4.50	.1770	—	12.00	.4724
1/32	0.79	.0313	15	4.57	.1800	31/64	12.30	.4844
—	0.80	.0315	14	4.62	.1820	1/2	12.70	.5000
67	0.81	.0320	13	4.70	.1850	—	13.00	.5118
66	0.84	.0330	3/16	4.76	.1875	33/64	13.10	.5156
65	0.89	.0350	12	4.80	.1890	17/32	13.49	.5312
—	0.90	.0354	11	4.85	.1910	35/64	13.89	.5469
64	0.91	.0360	10	4.91	.1935	—	14.00	.5512
63	0.94	.0370	9	4.98	.1960	9/16	14.29	.5625
62	0.97	.0380	—	5.00	.1968	37/64	14.68	.5781
61	0.99	.0390	8	5.05	.1990	—	15.00	.5906
—	1.00	.0394	7	5.11	.2010	19/32	15.08	.5938
60	1.02	.0400	13/64	5.16	.2031	39/64	15.48	.6094
59	1.04	.0410	6	5.18	.2040	5/8	15.88	.6250
58	1.07	.0420	5	5.22	.2055	—	16.00	.6299
57	1.09	.0430	4	5.31	.2090	41/64	16.27	.6406
56	1.18	.0465	3	5.41	.2130	21/32	16.67	.6562
3/64	1.19	.0469	7/32	5.56	.2188	—	17.00	.6693
55	1.32	.0520	2	5.61	.2210	43/64	17.07	.6719
54	1.40	.0550	1	5.79	.2280	11/16	17.46	.6875
53	1.51	.0595	A	5.94	.2340	45/64	17.86	.7031
1/16	1.59	.0625	15/64	5.95	.2344	—	18.00	.7087
52	1.61	.0635	—	6.00	.2362	23/32	18.26	.7188
51	1.70	.0670	B	6.05	.2380	47/64	18.65	.7344
50	1.78	.0700	C	6.15	.2420	—	19.00	.7480
49	1.85	.0730	D	6.25	.2460	3/4	19.05	.7500
48	1.93	.0760	1/4	6.35	.2500	49/64	19.45	.7656
5/64	1.98	.0781	E	6.35	.2500	25/32	19.84	.7812
47	1.99	.0785	F	6.53	.2570	—	20.00	.7874
—	2.00	.0787	G	6.63	.2610	51/64	20.24	.7969
46	2.06	.0810	17/64	6.75	.2656	13/16	20.64	.8125
45	2.08	.0820	H	6.76	.2660	—	21.00	.8268
44	2.18	.0860	I	6.91	.2720	53/64	21.03	.8281
43	2.26	.0890	—	7.00	.2756	27/32	21.43	.8438
42	2.37	.0935	J	7.04	.2770	55/64	21.84	.8594
3/32	2.38	.0938	K	7.14	.2810	—	22.00	.8661
41	2.44	.0960	9/32	7.14	.2812	7/8	22.23	.8750
40	2.50	.0980	L	7.37	.2900	57/64	22.62	.8906
39	2.53	.0995	M	7.49	.2950	—	23.00	.9055
38	2.58	.1015	19/64	7.54	.2969	29/32	23.02	.9062
37	2.64	.1040	N	7.67	.3020	59/64	23.42	.9219
36	2.71	.1065	5/16	7.94	.3125	15/16	23.81	.9375
7/64	2.78	.1094	—	8.00	.3150	—	24.00	.9449
35	2.79	.1100	O	8.03	.3160	61/64	24.21	.9531
34	2.82	.1110	P	8.20	.3230	31/32	24.61	.9688
33	2.87	.1130	21/64	8.33	.3281	—	25.00	.9842
32	2.95	.1160	Q	8.43	.3320	63/64	25.00	.9844
						1"	25.40	1.0000

For exact decimal equivalent, multiply mm times .03937. For exact mm equivalent multiply decimal times 25.4.

# TAP / DRILL SIZES

American Std. and Unified Form Threads							
Tap Drill Size is approximately 75% Thread							
THREAD NOMINAL SIZE	Pitch Series	DRILL		THREAD NOMINAL SIZE	Pitch Series	DRILL	
		SIZE	DECIMAL			SIZE	DECIMAL
0-80	NF	3/64	.047	3/16-12	NC-UNC	31/64	.484
1-64	NC	53	.060	18	NF-UNF	33/64	.516
72	NF	53	.060	5/8-11	NC-UNC	17/32	.531
2-56	NC	50	.070	18	NF-UNF	37/64	.578
64	NF	50	.070	3/4-10	NC-UNC	21/32	.656
3-48	NC	47	.079	16	NF-UNF	11/16	.688
56	NF	45	.082	7/8-9	NC-UNC	49/64	.766
4-40	NC-UNC	43	.089	14	NF-UNF	13/16	.813
48	NF	42	.094	1-8	NC-UNC	7/8	.875
5-40	NC	38	.102	14	NS	15/16	.938
44	NF	37	.104	1 1/8-7	NC-UNC	63/64	.984
6-32	NC-UNC	36	.107	12	NF-UNF	13/64	1.047
40	NF	33	.113	1 1/4-7	NC-UNC	17/64	1.109
8-32	NC-UNC	29	.136	12	NF-UNF	111/64	1.172
36	NF	29	.136	1 3/8-6	NC-UNC	17/32	1.219
10-24	NC-UNC	25	.150	12	NF-UNF	119/64	1.297
32	NF-UNF	21	.159	1 1/2-6	NC-UNC	111/32	1.344
12-24	NC	16	.177	12	NF-UNF	127/64	1.422
28	NF	14	.182	1 3/4-5	NC-UNC	19/16	1.563
1/4-20	NC-UNC	7	.201	2 1/2-4	NC-UNC	125/32	1.781
28	NF-UNF	3	.213	2 1/4-4 1/2	NC-UNC	21/32	2.031
5/16-18	NC-UNC	F	.257	2 1/2-4	NC-UNC	21/4	2.250
24	NF-UNF	I	.272	2 3/4-4	NC-UNC	21/2	2.500
3/8-16	NC-UNC	5/16	.313	3-4	NC-UNC	23/4	2.750
24	NF-UNF	Q	.332	3 1/4-4	NC-UNC	3	3.000
7/16-14	NC-UNC	U	.368	3 1/4-4	NC-UNC	3 1/4	3.250
20	NF-UNF	25/64	.391	3 3/4-4	NC-UNC	3 1/2	3.500
1/2-13	NC-UNC	27/64	.422	4-4	NC-UNC	3 3/4	3.750
20	NF-UNF	29/64	.453				

*TAPER PIPE	
THREAD	DRILL
1/16	D
1/8	R
1/4	7/16
3/8	37/64
1/2	45/64
3/4	59/64
1	15/32
1 1/4	1 1/2

*TAPER PIPE	
THREAD	DRILL
1 1/2	1 7/8
2	2 1/8
2 1/2	2 5/8
3	3 1/4
3 1/2	3 3/4
4	4 1/4
*For tapping without reaming	

STRAIGHT PIPE	
THREAD	DRILL
1/16	1/4
1/8	11/32
1/4	7/16
3/8	37/64
1/2	23/32
3/4	59/64
1	15/32
1 1/4	1 1/2
1 1/2	1 3/4
2	2 1/8
2 1/2	2 1/4

METRIC THREADS			
French and International Standard (D.I.N.)			
TAP SIZE	STD.	DRILL	
		STD.	DC.
2.5-45	French	5/64	.0781
2.6-45	D.I.N.	#45	.082
3-50	D.I.N.	#39	.0995
.60	French	3/32	.0937
.75	Optional	#43	.089
3.5-60	French & D.I.N.	#33	.113
4-70	D.I.N.	#30	.1285
-.75	French	1/8	.125
4.5-75	French & D.I.N.	#26	.147
5-75	Optional	#19	.166
.80	D.I.N.	#19	.166
.90	French	#20	.161
1.00	Optional	5/32*	.156
5.5-75	Optional	3/16	.1875
.90	French & D.I.N.	#14	.182
6-100	French & D.I.N.	#9	.196
1.25	Optional	3/16	.1875
7-100	French & D.I.N.	15/64	.234
1.25	Optional	#1	.228
8-100	French	J	.277
1.25	D.I.N.	17/64	.265
9-100	French	5/16	.3125
1.25	D.I.N.	5/16	.3125
10-100	Optional	23/64	.359
1.25	Optional	11/32	.3437
1.50	French & D.I.N.	R	.339
11-150	D.I.N.	3/8	.375
12-125	Optional	7/16	.4375
1.50	French	13/32	.406
1.75	D.I.N.	13/32	.406
13-150	Optional	29/64	.453
1.75	Optional	29/64	.453
2.00	Optional	7/16	.4375
14-125	Optional	33/64	.5156
1.75	Optional	1/2	.500
2.00	French & D.I.N.	15/32	.4687
15-1.75	Optional	17/32	.531
2.00	Optional	33/64	.5156
16-2.00	French & D.I.N.	35/64	.5468
17-2.00	Optional	19/32	.5937
18-1.50	Optional	21/32	.656
1/8-28	BSP	21/64	.3281

**MAGNA**  
PROFESSIONAL TOOLS  
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ELIZABETHTOWN, KY 42701 U.S.A.

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