

INCH DRILL SIZES		
Drill/Decimal	Drill/Decimal	Drill/Decimal
80 .0135	9/64 .1406	23/64 .3594
79 .0145	27 .1440	U .3680
1/64 .0156	26 .1470	<b>3/8 .3570</b>
78 .0160	25 .1495	V .3770
77 .0180	24 .1520	W .3860
76 .0200	23 .1540	25/64 .3906
75 .0210	5/32 .1562	X .3970
74 .0225	22 .1570	Y .4040
73 .0240	21 .1590	13/32 .4062
72 .0250	20 .1610	Z .4130
71 .0260	19 .1660	27/64 .4219
70 .0280	18 .1695	<b>7/16 .4375</b>
69 .0292	11/64 .1719	29/64 .4531
68 .0310	17 .1730	15/32 .4688
1/32 .0312	16 .1770	31/64 .4844
67 .0320	15 .1800	<b>1/2 .5000</b>
66 .0330	14 .1820	33/64 .5156
65 .0350	13 .1850	17/32 .5312
64 .0360	<b>3/16 .1875</b>	35/64 .5469
63 .0370	12 .1890	<b>9/16 .5625</b>
62 .0380	11 .1910	37/64 .5781
61 .0390	10 .1935	19/32 .5938
60 .0400	9 .1960	39/64 .6094
59 .0410	8 .1990	<b>5/8 .6250</b>
58 .0420	7 .2010	41/64 .6406
57 .0430	13/64 .2031	21/32 .6562
56 .0465	6 .2040	43/64 .6719
3/64 .0469	5 .2055	<b>11/16 .6875</b>
55 .0520	4 .2090	45/64 .7031
54 .0550	3 .2130	23/32 .7188
53 .0595	7/32 .2188	47/64 .7344
<b>1/16 .0625</b>	2 .2210	<b>3/4 .7500</b>
52 .0635	1 .2280	49/64 .7656
51 .0670	A .2340	25/32 .7812
50 .0700	15/64 .2344	51/64 .7969
49 .0730	B .2380	<b>13/16 .8125</b>
48 .0760	C .2420	53/64 .8281
5/64 .0781	D .2460	27/32 .8438
47 .0785	E .2500	55/64 .8594
46 .0810	<b>1/4 .2500</b>	<b>7/8 .8750</b>
45 .0820	F .2570	57/64 .8906
44 .0860	G .2610	29/32 .9062
43 .0890	17/64 .2656	59/64 .9219
42 .0935	H .2660	<b>15/16 .9375</b>
3/32 .0938	I .2720	61/64 .9531
41 .0960	J .2770	31/32 .9688
40 .0980	K .2810	63/64 .9844
39 .0995	9/32 .2812	<b>1 1.0000</b>
38 .1015	L .2900	
37 .1040	M .2950	+64th increments up to 1-7/8"
36 .1065	19/64 .2969	
7/64 .1094	N .3020	
35 .1100	<b>5/16 .3125</b>	
34 .1110	O .3160	+32nd increments up to 2-1/4"
33 .1130	P .3230	
32 .1160	21/64 .3281	
31 .1200	Q .3320	
<b>1/8 .1250</b>	R .3390	+16th increments up to -1/4"
30 .1285	11/32 .3438	
29 .1360	S .3480	
28 .1405	T .3580	

METRIC DRILL SIZES		
Drill/Decimal	Drill/Decimal	Drill/Decimal
.35mm .0138	3.60 mm .1417	8.70mm .3425
.38mm .0150	3.70mm .1457	8.75mm .3445
.40mm .0157	3.75mm .1476	8.80mm .3465
.42mm .0165	3.80mm .1496	8.90mm .3504
.45mm .0177	3.90mm .1535	<b>9.00mm .3543</b>
.48mm .0189	<b>4.00mm .1575</b>	9.10mm .3583
.50mm .0197	4.10mm .1614	9.20mm .3622
.55mm .0217	4.20mm .1654	9.25mm .3642
.60mm .0236	4.25mm .1673	9.30mm .3661
.65mm .0256	4.30mm .1693	9.40mm .3701
.70mm .0276	4.40mm .1732	9.50mm .3740
.75mm .0295	4.50mm .1772	9.60mm .3780
.80mm .0315	4.60mm .1811	9.70mm .3819
.85mm .0335	4.70mm .1850	9.75mm .3839
.90mm .0354	4.75mm .1870	9.80mm .3858
.95mm .0374	4.80mm .1890	9.90mm .3898
<b>1.00mm .0394</b>	4.90mm .1929	<b>10.00mm .3937</b>
1.05mm .0413	<b>5.00mm .1969</b>	10.20mm .4016
1.10mm .0433	5.10mm .2008	10.50mm .4134
1.15mm .0453	5.20mm .2047	10.80mm .4252
1.20mm .0472	5.25mm .2067	<b>11.00mm .4331</b>
1.25mm .0492	5.30mm .2087	11.20mm .4409
1.30mm .0512	5.40mm .2126	11.50mm .4528
1.35mm .0531	5.50mm .2165	11.80mm .4646
1.40mm .0551	5.60mm .2205	<b>12.00mm .4724</b>
1.45mm .0571	5.70mm .2244	12.20mm .4803
1.50mm .0591	5.75mm .2264	12.50mm .4921
1.55mm .0610	5.80mm .2283	<b>13.00mm .5118</b>
1.60mm .0630	5.90mm .2323	13.50mm .5315
1.65mm .0650	<b>6.00mm .2362</b>	<b>14.00mm .5512</b>
1.70mm .0669	6.10mm .2402	14.50mm .5709
1.75mm .0689	6.20mm .2441	<b>15.00mm .5906</b>
1.80mm .0709	6.25mm .2461	15.50mm .6102
1.85mm .0728	6.30mm .2480	<b>16.00mm .6299</b>
1.90mm .0748	6.40mm .2520	16.50mm .6496
1.95mm .0768	6.50mm .2559	<b>17.00mm .6693</b>
<b>2.00mm .0787</b>	6.60mm .2598	17.50mm .6890
2.05mm .0807	6.70mm .2638	<b>18.00mm .7087</b>
2.10mm .0827	6.75mm .2657	18.50mm .7283
2.15mm .0846	6.80mm .2677	<b>19.00mm .7480</b>
2.20mm .0866	6.90mm .2717	19.50mm .7677
2.25mm .0886	<b>7.00mm .2756</b>	<b>20.00mm .7874</b>
2.30mm .0906	7.10mm .2795	20.50mm .8071
2.35mm .0925	7.20mm .2835	<b>21.00mm .8268</b>
2.40mm .0945	7.25mm .2854	21.50mm .8465
2.45mm .0965	7.30mm .2874	<b>22.00mm .8661</b>
2.50mm .0984	7.40mm .2913	22.50mm .8858
2.55mm .1004	7.50mm .2953	<b>23.00mm .9055</b>
2.60mm .1024	7.60mm .2992	23.50mm .9252
2.65mm .1043	7.70mm .3031	<b>24.00mm .9449</b>
2.70mm .1063	7.75mm .3051	24.50mm .9646
2.75mm .1083	7.80mm .3071	<b>25.00mm .9843</b>
2.80mm .1102	7.90mm .3110	
2.90mm .1142	<b>8.00mm .3150</b>	+1.00mm increments up to 48mm
<b>3.00mm .1181</b>	8.10mm .3189	
3.10mm .1220	8.20mm .3228	
3.20mm .1260	8.25mm .3248	
3.25mm .1280	8.30mm .3268	+5.00mm increments from 50mm-105mm
3.30mm .1299	8.40mm .3307	
3.40mm .1339	8.50mm .3346	
3.50mm .1378	8.60mm .3386	

TAP GUIDE SIZES		
Tap Size*	Tap Guide Nominal ID Size	Tap Drill Size**
#0-80	.0616	3/64
<b>#2-56</b>	.0883	#50
#2-64	.0880	#50
<b>#4-40</b>	.1152	#43
#4-48	.1147	#42
<b>#5-40</b>	.1282	#38
#5-44	.1280	#37
<b>#6-32</b>	.1421	#36
#6-40	.1412	#33
<b>#8-32</b>	.1681	#29
#8-36	.1676	#29
<b>#10-24</b>	.1954	#25
#10-32	.1941	#21
<b>1/4-20</b>	.2565	#7
1/4-28	.2546	#3
<b>5/16-18</b>	.3197	F
5/16-24	.3179	I
<b>3/8-16</b>	.3831	5/16
3/8-24	.3804	Q
<b>7/16-14</b>	.4468	U
7/16-20	.4440	25/64
<b>1/2-13</b>	.5100	27/64
1/2-20	.5065	29/64
<b>9/16-12</b>	.5733	31/64
9/16-18	.5697	33/64
<b>5/8-11</b>	.6368	17/32
5/8-18	.6322	37/64
<b>3/4-10</b>	.7630	21/32
3/4-16	.7581	11/16
<b>7/8-9</b>	.8894	49/64
7/8-14	.8843	13/16
<b>1-8</b>	1.0162	7/8
1-14	1.0093	15/16
METRIC		
<b>M1.6x0.35</b>	.0651	1.25mm or #55
<b>M2x0.4</b>	.0810	1.60mm or #52
<b>M2.5x0.45</b>	.1008	2.05mm or #46
<b>M3x0.5</b>	.1207	2.50mm or #39
<b>M3.5x0.6</b>	.1407	2.90mm or #32
<b>M4x0.7</b>	.1613	3.30mm or #30
<b>M5x0.8</b>	.2010	4.20mm or #19
<b>M6x1</b>	.2410	5.00mm or #8
<b>M8x1.25</b>	.3214	6.80mm or H
<b>M8x1</b>	.3197	7.00mm or J
<b>M10x1.5</b>	.4009	8.50mm or R
M10x1.25	.4002	8.80mm or 11/32
<b>M12x1.75</b>	.4805	10.20mm or 13/32
M12x1.25	.4789	10.80mm or 27/64
<b>M14x2</b>	.5600	12.00mm or 15/32
M14x1.5	.5584	12.50mm or 1/2
<b>M16x2</b>	.6387	14.00mm or 35/64
M16x1.5	.6372	14.50mm or 37/64
<b>M18x2.5</b>	.7191	15.50mm or 39/64
M18x1.5	.7159	16.50mm or 21/32
<b>M20x2.5</b>	.7978	17.50mm or 11/16
M20x1.5	.7946	18.50mm or 47/64
<b>M22x2.5</b>	.8765	19.50mm or 49/64
M22x1.5	.8734	20.50mm or 13/16
<b>M24x3</b>	.9583	21.00mm or 53/64
M24x2	.9537	22.00mm or 7/8

\*Coarse series shown in bold. Pitch callout not required on metric coarse series.

\*\*Closest size for 75% theoretical thread.

