

Recommended drill diameters for various threads



Table I 12 Metric coarse thread

Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter
M1	0,75	M2,2	1,75	M 6	5	M14	12	M30	26,5	M52	47
M1,1	0,85	M2,5	2,05	M 7	6	M16	14	M33	29,5	M56	50,5
M1,2	0,95	M3	2,5	M 8	6,8	M18	15,5	M36	32	M60	54,5
M1,4	1,1	M3,5	2,9	M 9	7,8	M20	17,5	M39	35	M64	58
M1,6	1,25	M4	3,3	M10	8,5	M22	19,5	M42	37,5	M68	62
M1,8	1,45	M4,5	3,7	M11	9,5	M24	21	M45	40,5		
M2	1,6	M5	4,2	M12	10,2	M27	24	M48	43		

Table I 13 Metric fine thread

Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter
M3 x0,35	2,65	M 5 x0,5	4,5	M10x1,25	8,8	M14x1,5	12,5	M20x1,5	18,5	M24x1,5	22,5
M3,5x0,35	3,15	M 6 x0,75	5,2	M12x1	11	M16x1,5	14,5	M20x2	18	M24x2	22
M4 x0,5	3,5	M 8 x1	7	M12x1,25	10,8	M18x1,5	16,5	M22x1,5	20,5	M27x1,5	25,5
M4,5x0,5	4	M10x1	9	M12x1,5	10,5	M18x2	16	M22x2	20	M27x2	25

Table I 14 Unified thread UNC

Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter
1/4 x20	5,1	7/16x14	9,4	5/8x11	13,5	1 x8	22,25	1 3/8x6	30,75	2 x4 1/2	45
5/16x18	6,6	1/2 x13	10,8	3/4x10	16,5	1 1/8 x7	25	1 1/2x6	34	2 1/2x4 1/2	51,5
3/8 x16	8	9/16x12	12,2	7/8x9	19,5	1 1/4 x7	28	1 3/4x5	39,5	2 1/2x4	57

Table I 15 Unified thread UNF

Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter
1/4 x28	5,5	7/16 x20	9,9	5/8 x18	14,5	1 x12	23,25	1 3/8 x12	32,75		
5/16x24	6,9	1/2 x20	11,5	3/4 x16	17,5	1 1/8 x12	26,5	1 1/2 x12	36		
3/8 x24	8,5	9/16 x18	12,9	7/8 x14	20,4	1 1/4 x12	29,5				

Table I 16 Pipe thread G ISO 228

Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter	Screw thread	Drill diameter
G 1/8x28	8,8	G 3/8x19	15,25	G 5/8x14	21	G 7/8x14	28,25	G 1 1/8x11	35,3	G 1 1/2x11	45
G 1/4x19	11,8	G 1/2x14	19	G 3/4x14	24,5	G 1 x11	30,75	G 1 1/4x11	39,5	G 1 3/4x11	51