

Bohrer und Gewinde

Drillbits, Tabs & Dies

Decimal and metric equivalents of drill sizes (1/128" - 1/2")

Decimal and metric equivalents of drill sizes (2)

American National Taps & Dies

Tap Drills

British Taps & Dies

Metric Taps & Dies



Bohrer und Gewinde

Drillbits, Tabs & Dies

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Fraction of Inch	Decimals of Inch	mm	Drill Number	Fraction of Inch	Decimals of Inch	mm	Drill Number	Fraction of Inch	Decimals of Inch	mm	Drill Number
1/128	0,0078	0,1984			0,1160	2,9464	32	35/128	0,2734	6,9453	
	0,0135	0,3429	80	15/128	0,1172	2,9766			0,2770	7,0358	J
	0,0145	0,3683	79		0,1200	3,0480	31		0,2810	7,1374	K
1/64	0,0156	0,3969		1/8	0,1250	3,1750		9/32	0,2813	7,1438	
	0,0160	0,4064	78		0,1285	3,2639	30	37/128	0,2891	7,3422	
	0,0180	0,4572	77	17/128	0,1328	3,3734			0,2900	7,3660	L
	0,0200	0,5080	76		0,1360	3,4544	29		0,2950	7,4930	M
	0,0210	0,5334	75		0,1405	3,5687	28	19/64	0,2969	7,5406	
	0,0225	0,5715	74	9/64	0,1406	3,5719			0,3020	7,6708	N
3/128	0,0234	0,5953			0,1440	3,6576	27	39/128	0,3047	7,7391	
	0,0240	0,6096	73		0,1470	3,7338	26	5/16	0,3125	7,9375	
	0,0250	0,6350	72	19/128	0,1484	3,7703			0,3160	8,0264	O
	0,0260	0,6604	71		0,1495	3,7973	25	41/128	0,3203	8,1359	
	0,0270	0,6858			0,1520	3,8608	24		0,3230	8,2042	P
	0,0280	0,7112	70		0,1540	3,9116	23	21/64	0,3281	8,3344	
	0,0292	0,7417	69	5/32	0,1563	3,9688			0,3320	8,4328	Q
	0,0310	0,7874	68		0,1570	3,9878	22	43/128	0,3359	8,5328	
1/32	0,0313	0,7938			0,1590	4,0386	21		0,3390	8,6106	R
	0,0320	0,8128	67		0,1610	4,0894	20	11/32	0,3438	8,7313	
	0,0330	0,8382	66	21/128	0,1641	4,1672			0,3480	8,8392	S
	0,0350	0,8890	65		0,1660	4,2164	19	45/128	0,3516	8,9297	
	0,0360	0,9144	64		0,1695	4,3053	18		0,3580	9,0932	T
	0,0370	0,9398	63	11/64	0,1719	4,3656		23/64	0,3594	9,1281	
	0,0380	0,9652	62		0,1730	4,3942	17	47/128	0,3672	9,3266	
5/128	0,0391	0,9922	61		0,1770	4,4958	16		0,3680	9,3472	U
	0,0400	1,0160	60	23/128	0,1797	4,5641		3/8	0,3750	9,5250	
	0,0410	1,0414	59		0,1800	4,5720	15		0,3770	9,5758	V
	0,0420	1,0668	58		0,1820	4,6228	14	49/128	0,3828	9,7234	
	0,0430	1,0922	57		0,1850	4,6990	13		0,3860	9,8044	W
	0,0465	1,1811	56	3/16	0,1875	4,7625		25/64	0,3906	9,9219	
3/64	0,0469	1,1906			0,1890	4,8006	12		0,3970	10,084	X
	0,0520	1,3208	55		0,1910	4,8514	11	51/128	0,3984	10,120	
7/128	0,0547	1,3891			0,1935	4,9149	10		0,4040	10,262	Y
	0,0550	1,3970	54	25/128	0,1953	4,9609		13/32	0,4063	10,319	
	0,0595	1,5113	53		0,1960	4,9784	9		0,4130	10,490	Z
1/16	0,0625	1,5875			0,1990	5,0546	8	53/128	0,4141	10,517	
	0,0635	1,6129	52		0,2010	5,1054	7	27/64	0,4219	10,716	
	0,0670	1,7018	51	13/64	0,2031	5,1594		55/128	0,4297	10,914	
9/128	0,0703	1,7859	50		0,2040	5,1816	6	7/16	0,4375	11,113	
	0,0730	1,8542	49		0,2055	5,2197	5	57/128	0,4453	11,311	
	0,0760	1,9304	48		0,2090	5,3086	4	29/64	0,4531	11,509	
5/64	0,0781	1,9844		27/128	0,2109	5,3578		59/128	0,4609	11,708	
	0,0785	1,9939	47		0,2130	5,4102	3	15/32	0,4688	11,906	
	0,0810	2,0574	46	7/32	0,2188	5,5563		61/128	0,4766	12,105	
	0,0820	2,0828	45		0,2210	5,6134	2	31/64	0,4844	12,303	
11/128	0,0859	2,1828	44	29/128	0,2266	5,7547		63/128	0,4922	12,502	
	0,0890	2,2606	43		0,2280	5,7912	1	1/2	0,5000	12,700	
	0,0935	2,3749	42		0,2340	5,9436	A				
3/32	0,0938	2,3813		15/64	0,2344	5,9531					
	0,0960	2,4384	41		0,2380	6,0452	B				
	0,0980	2,4892	40		0,2420	6,1468	C				
	0,0995	2,5273	39	31/128	0,2422	6,1516					
	0,1015	2,5781	38		0,2460	6,2484	D				
13/128	0,1016	2,5797		1/4	0,2500	6,3500	E				
	0,1040	2,6416	37		0,2570	6,5278	F				
	0,1065	2,7051	36	33/128	0,2578	6,5484					
7/64	0,1094	2,7781			0,2610	6,6294	G				
	0,1100	2,7940	35	17/64	0,2656	6,7469					
	0,1110	2,8194	34		0,2660	6,7564	H				
	0,1130	2,8702	33		0,2720	6,9088	I				

Decimal and metric equivalents of drill sizes (1/128" - 1/2")

DRILL SIZE	DEC.	mm	DRILL SIZE	DEC.	mm	DRILL SIZE	DEC.	mm	DRILL SIZE	DEC.	mm
80	.0135	.34	42	.0935	2.35	13/64	.2031		X	.3970	10.0
79	.0145	.36	3/32	.0938		6	.2040		Y	.4040	
1/64	.0156	.38	41	.0960	2.40	5	.2055	5.20	13/32	.4062	
78	.0160	.40	40	.0980	2.45	4	.2090	5.30	Z	.4130	
77	.0180	.45	39	.0995	2.50	3	.2130	5.40	27/64	.4219	10.5
76	.2000	.50	38	.1015		7/32	.2188	5.50	7/16	.4375	11.0
75	.0210		37	.1040	2.60	2	.2210	5.60	29/64	.4531	11.5
74	.0225	.55	36	.1065	2.70	1	.2280	5.75	15/32	.4688	
73	.0240	.60	7/64	.1094	2.75	A	.2340	5.90	31/64	.4844	12.0
72	.0250		35	.1100		15/64	.2344		1/2	.5000	12.5
71	.0260	.65	34	.1110	2.80	B	.2380	6.00	33/64	.5156	13.0
70	.0280	.70	33	.1130		C	.2420	6.10	17/32	.5312	
69	.0292		32	.1160	2.90	D	.2460	6.20	35/64	.5469	13.5
68	.0310	.75	31	.1200	3.00	1/4	.2500	6.30	9/16	.5625	
1/32	.0312		1/8	.1250	3.10	E	.2500		37/64	.5781	14.5
67	.0320	.80	30	.1285	3.25	F	.2570	6.50	19/32	.5938	
66	.0330		29	.1360	3.40	G	.2610	6.60	39/64	.6094	
65	.0350	.85	28	.1405	3.50	17/64	.2656	6.70	5/8	.6250	15.5
64	.0360	.90	9/64	.1406		H	.2660	6.75	41/64	.6406	16.0
63	.0370		27	.1440	3.60	I	.2720	6.90	21/32	.6562	16.5
62	.0380	.95	26	.1470	3.70	J	.2770	7.00	43/64	.6719	17.0
61	.0390		25	.1495	3.75	K	.2810		11/16	.6875	
60	.0400	1.00	24	.1520	3.80	9/32	.2812		45/64	.7031	17.5
59	.0410		23	.1540	3.90	L	.2900	7.30	23/32	.7188	18.0
58	.0420	1.05	5/32	.1562		M	.2950	7.40	47/64	.7344	18.5
57	.0430		22	.1570		19/64	.2969	7.50	3/4	.7500	19.0
56	.0465	1.15	21	.1590	4.00	N	.3020	7.60	49/64	.7656	
3/64	.0469		20	.1610		5/16	.3125	7.90	25/32	.7812	19.5
55	.0520	1.30	19	.1660	4.20	O	.3160	8.00	51/64	.7969	20.0
54	.0550	1.35	18	.1695	4.30	P	.3230	8.20	13/16	.8125	20.5
53	.0595	1.50	11/64	.1719		21/64	.3281	8.30	53/64	.8281	21.0
1/16	.0625	1.55	17	.1730		Q	.3320	8.40	27/32	.8438	
52	.0635	1.60	16	.1770	4.40	R	.3390	8.60	55/64	.8594	21.5
51	.0670	1.70	15	.1800	4.50	11/32	.3438	8.70	7/8	.8750	22.0
50	.0700	1.75	14	.1820	4.60	S	.3480	8.80	57/64	.8906	22.5
49	.0730	1.85	13	.1850	4.70	T	.3580	9.00	29/32	.9062	23.0
48	.0760	1.90	3/16	.1875	4.75	23/64	.3594	9.10	59/64	.9219	
5/64	.0781	1.95	12	.1890	4.80	U	.3680	9.30	15/16	.9375	23.5
47	.0785		11	.1910		3/8	.3750	9.50	61/64	.9531	24.0
46	.0810	2.05	10	.1935	4.90	V	.3770		31/32	.9688	24.5
45	.0820		9	.1960		W	.3860	9.80	63/64	.9844	25.0
44	.0860	2.15	8	.1990	5.00	25/64	.3906	9.90	1	1.000	
43	.0890	2.25	7	.2010	5.10						

Decimal and metric equivalents of drill sizes

...for exact decimal equivalent, multiply mm times 0.3937.

...for exact mm equivalent, multiply decimal times 25.4.

Thread	Fine Threads			Coarse Threads		
	Threads per inch	Tap Drill		Threads per inch	Tap Drill	
		Inch & No.	mm		Inch & No.	mm
# 0	80	3/64	1,2			
# 1	72	# 53	1,5	64	# 53	1,5
# 2	64	# 50	1,8	56	# 50	1,8
# 3	56	# 46	2,0	48	# 47	2,0
# 4	48	# 42	2,4	40	# 43	2,3
1/8	40	# 38	2,6	32	3/32	2,4
# 5	44	# 37	2,7	40	# 38	2,6
# 6	40	# 33	2,9	32	# 36	2,7
# 8	36	# 29	3,5	32	# 29	3,5
3/16	32	# 22	4,0	24	# 26	3,7
# 10	32	# 21	4,0	24	# 25	3,8
# 12	28	# 14	4,6	24	# 16	4,5
1/4	28	# 3	5,4	20	# 7	5,1
5/16	24	I	6,9	18	F	6,5
3/8	24	Q	8,4	16	5/16	7,9
7/16	20	25/64	9,9	14	U	9,3
1/2	20	29/64	11,5	13	27/64	10,5
9/16	18	33/64	13,0	12	31/64	12,5
5/8	18	37/64	14,5	11	17/32	13,5
3/4	16	11/16	17,5	10	21/32	16,5
7/8	14	13/16	20,5	9	49/64	19,5
1	12	59/64	23,5	8	7/8	22,0
1-1/8	12	1-3/64	26,5	7	63/64	25,0
1-1/4	12	1-11/64	29,5	7	1-7/64	28,0
1-3/8	12	1-19/64	33,0	6	1-7/32	31,0
1-1/2	12	1-27/64	36,0	6	1-11/32	34,0
1-3/4				5	1-35/64	39,0
2				4-1/2	1-25/32	45,0
2-1/4				4-1/2	2-1/32	51,5
2-1/2				4	2-1/4	57,0
2-3/4				4	2-1/2	63,5
3				4	2-3/4	70,0
3-1/4				4	3	76,0
3-1/2				4	3-1/4	82,5
3-3/4				4	3-1/2	89,0
4				4	3-3/4	95,0

...the threads shown in the table are the most common out of hundreds other available sizes

American Std. and Unified Form Threads			
Tap Drill Size is approxim. 75% Thread			
THREAD NOMINAL SIZE	Pitch Series	DRILL	
		SIZE	DECIMAL
0-80	NF	3/64	.047
1-64	NC	53	.060
1-72	NF	53	.060
2-56	NC	50	.070
2-64	NF	50	.070
3-48	NC	47	.079
3-56	NF	45	.082
4-40	NC-UNC	43	.089
4-48	NF	42	.094
5-40	NC	38	.102
5-44	NF	37	.104
6-32	NC-UNC	36	.107
6-40	NF	33	.113
8-32	NC-UNC	29	.136
8-36	NF	29	.136
10-24	NC-UNC	25	.150
10-32	NF-UNF	21	.159
12-24	NC	16	.177
12-28	NF	14	.182
1/4-20	NC-UNC	7	.201
1/4-28	NF-UNF	3	.213
14-20	NS	10	.194
5/16-18	NC-UNC	F	.257
5/16-24	NF-UNF	I	.272
3/8-16	NC-UNC	5/16	.313
3/8-24	NF-UNF	Q	.332
7/16-14	NC-UNC	U	.368
7/16-20	NF-UNF	25/64	.391
1/2-13	NC-UNC	27/64	.442
1/2-20	NF-UNF	29/64	.453
9/16-12	NC-UNC	31/64	.484
9/16-18	NF-UNF	33/64	.516
5/8-11	NC-UNC	17/32	.531
5/8-18	NF-UNF	37/64	.578
3/4-10	NC-UNC	21/32	.656
3/4-16	NF-UNF	11/16	.688
7/8-9	NC-UNC	49/64	.766
7/8-14	NF-UNF	13/16	.813
1-8	NC-UNC	7/8	.875
1-14	NS	15/16	.938
1 1/8-7	NC-UNC	63/64	.984
1 1/8-12	NF-UNF	1 3/64	1.047
1 1/4-7	NC-UNC	1 7/64	1.109
1 1/4-12	NF-UNF	1 11/64	1.172
1 3/8-6	NC-UNC	1 7/32	1.219
1 3/8-12	NF-UNF	1 19/64	1.297
1 1/2-6	NC-UNC	1 11/32	1.344
1 1/2-12	NF-UNF	1 27/64	1.422
1 3/4-5	NC-UNC	1 9/16	1.563
2 4 1/2	NC-UNC	1 25/32	1.781
2 1/4-4 1/2	NC-UNC	2 1/32	2.031
2 1/2-4	NC-UNC	2 1/4	2.250
2 3/4-4	NC-UNC	2 1/2	2.500
3-4	NC-UNC	2 3/4	2.750
3 1/4-4	NC-UNC	3	3.000
3 1/4-4	NC-UNC	3 1/4	3.250
3 3/4-4	NC-UNC	3 1/2	3.500
4-4	NC-UNC	3 3/4	3.750

METRIC THREADS			
French and International Standard (D.I.N.)			
TAP SIZE	STD.	DRILL	
		STD.	DC.
2.5-4.5	French	5/64	.0781
2.6-.45	D.I.N.	#45	.082
3-.50	D.I.N.	#40	.098
3-.60	French	#39	.0995
3-.75	Optional	#43	.089
3.5-.60	French & D.I.N.	#33	.113
4-.70	D.I.N.	1/8	.125
4-.75	French	1/8	.125
4.5-.75	French & D.I.N.	#26	.147
5-.75	Optional	#19	.166
5-.80	D.I.N.	11/64	.1719
5-.90	French	#20	.161
5-1.00	Optional	5/32	.156
5.5-.75	Optional	3/16	.1875
5.5-.90	French & D.I.N.	#14	.182
6-1.00	French & D.I.N.	13/64	.2031
6-1.25	Optional	3/16	.1875
7-1.00	French & D.I.N.	15/64	.234
7-1.25	Optional	#1	.228
8-1.00	French	J	.277
8-1.25	D.I.N.	17/64	.265
9-1.00	French	5/16	.3125
9-1.25	D.I.N.	5/16	.3125
10-1.00	Optional	23/64	.359
10-1.25	Optional	11/32	.3437
10-1.50	French & D.I.N.	11/32	.3437
11-1.50	D.I.N.	3/8	.375
12-1.25	Optional	7/16	.4375
12-1.50	French	13/32	.406
12-1.75	D.I.N.	27/64	.4219
13-1.50	Optional	29/64	.453
13-1.75	Optional	29/64	.453
13-2.00	Optional	7/16	.4375
14-1.25	Optional	33/64	.5156
14-1.75	Optional	1/2	.5
14-2.00	French & D.I.N.	15/32	.4687
15-1.75	Optional	17/32	.531
15-2.00	Optional	33/64	.5156
16-1.50	Optional	37/64	.5781
16-2.00	French & D.I.N.	35/64	.5468
17-2.00	Optional	19/32	.5937
18-1.50	Optional	21/32	.656

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	1 5/32
1 1/4	1 1/2
1 1/2	1 47/64
2	2 7/32
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	1 5/32
1 1/4	1 1/2
1 1/2	1 3/4
2	2 7/32
2 1/2	2 21/32

British Taps & Dies				
Thread	British Standard Whitworth		British Standard Fine	
	Threads / inch	Tap Drill	Threads / inch	Tap Drill
1/8	40	2,55mm		
3/16	24	3,70mm	32	5/32
7/32			28	4,65mm
1/4	20	5,10mm	26	5,30mm
9/32			26	
5/16	18	6,50mm	22	6,75mm
3/8	16	5/16	20	8,25mm
7/16	14	9,25mm	18	9,70mm
1/2	12	10,50mm	16	7/16
9/16	12	12,10mm	16	1/2
5/8	11	13,50mm	14	14,00mm
11/16	11		14	
3/4	10	41/64	12	16,75mm
7/8	9	19,25mm	11	25/32
1	8	22,00mm	10	22,75mm
1 1/8	7	24,75mm	9	25,50mm
1 1/4	7	1 3/32	9	28,75mm
1 3/8			8	31,50mm
1 1/2	6	33,50mm	8	1 23/64
1 3/4	5	39,00mm		
2	4,5	44,50mm		

British ASSOC STD Thread (B.A.)				
Thread	Threads / inch	Pitch mm	Major Diameter mm	
0	25,4	1	6	
1	28,2	0,9	5,3	
2	31,4	0,81	4,7	
3	34,8	0,73	4,1	
4	38,5	0,66	3,6	
5	43	0,59	3,2	
6	47,9	0,53	2,8	
7	52,9	0,48	2,5	
8	59,1	0,43	2,2	
9	65,1	0,39	1,9	
10	72,6	0,35	1,7	
11	82	0,31	1,5	
12	90,7	0,28	1,3	
13	102	0,25	1,2	
14	110	0,23	1	
15	121	0,21	0,9	
16	134	0,19	0,79	

Thread Size		Tap Drill Size	
mm	Inches	mm	Inches
1,5	0,059	1,1	0,0433
2	0,0787	1,5	0,059
2,3	0,0895	1,9	0,0748
2,5	0,0984	2	0,0787
2,6	0,1124	2,1	0,0827
3	0,1181	2,4	0,0945
3,5	0,1378	2,9	0,1142
4	0,1575	3,3	0,1299
4,5	0,1772	3,75	0,1476
5	0,1968	4,1	0,1614
5,5	0,2165	4,6	0,1811
6	0,2362	5	0,1968
7	0,2856	6	0,2362
8	0,315	6,8	0,2677
9	0,3543	7,8	0,3071
10	0,3937	8,6	0,3386
11	0,3937	9,6	0,378
12	0,4624	10,5	0,4134
14	0,5512	12	0,4724
16	0,6299	14	0,5118
18	0,7087	15,5	0,6102
20	0,7974	17,5	0,689
22	0,8771	19,5	0,7677
24	0,9449	21	0,8268
26	1,0236	23	0,9055
27	1,063	24	0,9449
28	1,1024	25	0,9842
30	1,1811	26,5	1,0433
32	1,2598	28,5	1,122
33	1,2992	29,5	1,1614
34	1,3386	30,5	1,2008
36	1,4173	32	1,2598
38	1,4961	34	1,3386
39	1,5354	35	1,3779
40	1,5748	36	1,4173
42	1,6535	37	1,4567

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