

INDEX & CHARTS

Reference Table



INCH/METRIC DRILL-TAP-WIRE EQUIVALENTS TABLE

| Inches | Metric (mm) | Twist Drill | B&S Wire | U.S. Plate | Tap Drill | Clearance Hole | Inches | Metric (mm) | Twist Drill | B&S Wire | U.S. Plate | Tap Drill | Clearance Hole | Inches | Metric (mm) | Twist Drill | B&S Wire | U.S. Plate | Tap Drill | Clearance Hole | Inches | Metric (mm) | Twist Drill | B&S Wire | U.S. Plate | Tap Drill | Clearance Hole |
|----------|-------------|-------------|----------|------------|-----------|----------------|-----------|-------------|-------------|----------|------------|-----------|----------------|----------|-------------|-------------|----------|------------|-----------|----------------|----------|-------------|-------------|----------|------------|-----------|----------------|
| .0003936 | .0100 | | | | | | .03196 | .8118 | | | 20 | | | .0995 | 2.5273 | #39 | | | | | .209 | 5.3086 | #4 | | | | |
| .001 | .0254 | | | | | | .032 | .8128 | #67 | | | | | .1 | 2.5400 | | | | | | .2125984 | 5.4000 | 5.40mm | | | | |
| .002 | .0508 | | | | | | .033 | .8382 | #66 | | | | | .1003937 | 2.5500 | 2.55mm | | | | | .213 | 5.4102 | #3 | | | | |
| .003 | .0762 | | | | | | .0334646 | .8500 | .85mm | | | 1.0mm | | .1015 | 2.5781 | #38 | | | | | .2165354 | 5.5000 | 5.50mm | | | | |
| .003145 | .0799 | | 40 | | | | .034 | .8636 | | | | | | .1019 | 2.5883 | | 10 | | | | .21875 | 5.5562 | 7/32 | | 5 | | |
| .003531 | .0897 | | 39 | | | | .034375 | .8731 | | | 21 | | | .1023622 | 2.6000 | 2.60mm | | | | | .2204724 | 5.6000 | 5.60mm | | | | |
| .003965 | .1007 | | 38 | | | | .035 | .8890 | #65 | | | 00-90 | | .104 | 2.6416 | #37 | | | | | .221 | 5.6134 | #2 | | | | |
| .004 | .1016 | | | | | | .00354331 | .9000 | .90mm | | | | | .1043397 | 2.6500 | 2.65mm | | | | | .2244095 | 5.7000 | 5.70mm | | | | |
| .004453 | .1131 | | 37 | | | | .03589 | .9116 | | | 19 | | | .1062992 | 2.7000 | 2.70mm | | | | | .228 | 5.7912 | #1 | | | | |
| .005 | .1270 | | 36 | | | | .036 | .9144 | #64 | | | | | .1065 | 2.7051 | #36 | | | | | .2283465 | 5.8000 | 5.80mm | | | | |
| .005614 | .1426 | | 35 | | | | .037 | .9398 | #63 | | | | | .1082677 | 2.7500 | 2.75mm | | | | | .2294 | 5.8268 | | 3 | | | |
| .0059 | .1499 | #97 | | | | | .0374016 | .9500 | .95mm | | | | | .108375 | 2.7781 | 1/64 | | | 12 | | .2322834 | 5.9000 | 5.90mm | | | | |
| .006 | .1524 | | | | | | .0375 | .9525 | .0 | | 20 | | | .11 | 2.7940 | #35 | | | | 6-32 | .234 | 5.9436 | A | | | | |
| .00625 | .1587 | | | 38 | | | .038 | .9625 | #62 | | | | | .1102362 | 2.8000 | 2.80mm | | | | | .234375 | 5.9531 | 11/64 | | 4 | | |
| .0063 | .1600 | #96 | | | | | .039 | .9906 | #61 | | | | | .111 | 2.8194 | #34 | | | | | .2362204 | 6.0000 | 6.00mm | | | | |
| .006304 | .1601 | | 34 | | | | .0393701 | 1.0000 | 1.00mm | | | 1.2mm | | .112 | 2.8448 | | | | | | .238 | 6.0452 | B | | | | |
| .0066406 | .1687 | | | 37 | | | .04 | 1.0160 | #60 | | | | | .1122047 | 2.8500 | 2.85mm | | | | | .2401574 | 6.1000 | 6.10mm | | | | 6.0mm |
| .0067 | .1702 | #95 | | | | | .0403 | 1.0236 | | | 18 | | | .113 | 2.8702 | #33 | | | | | .242 | 6.1468 | C | | | | |
| .007 | .1720 | | | | | | .041 | 1.0414 | #59 | | | | | .1141732 | 2.9000 | 2.90mm | | | | | .246 | 6.2484 | D | | | | |
| .0070312 | .1786 | | | 36 | | | .0413386 | 1.0500 | 1.05mm | | | | | .1144 | 2.9058 | | 9 | | | | .25 | 6.3500 | 1/4-E | | 3 | | 1/4-20 |
| .00708 | .1798 | | 33 | | | | .042 | 1.0668 | #58 | | | | | .116 | 2.9464 | #32 | | | | | .2559055 | 6.5000 | 6.50mm | | | | |
| .0071 | .1803 | #94 | | | | | .043 | 1.0922 | #57 | | | | | .1161417 | 2.9500 | 2.95mm | | | | | .257 | 6.5278 | F | | | 5/16-18 | 1/4-20 |
| .0075 | .1905 | #93 | | | | | .0433971 | 1.1000 | 1.10mm | | | 1.0mm | | .1181102 | 3.0000 | 3.00mm | | | | | .2756 | 6.5430 | | 2 | | | |
| .0078125 | .1948 | 1/128 | | 35 | | | .04375 | 1.1112 | | | 19 | | | .12 | 3.0480 | #31 | | | | | .261 | 6.6294 | G | | | | |
| .0078740 | .2000 | .20mm | | | | | .044 | 1.1176 | | | | | | .1279528 | 3.2500 | 3.25mm | | | | | .265625 | 6.7462 | 17/64 | | 2 | | |
| .0079 | .2007 | #92 | | | | | .0444444 | 1.1289 | | | | | | .1285 | 3.2639 | #30 | 8 | | | | .266 | 6.7564 | H | | | | |
| .00795 | .2019 | | 32 | | | | .04526 | 1.1496 | | | 17 | 1.4mm | | .1299213 | 3.3000 | 3.30mm | | | | | .272 | 6.9088 | I | | | | |
| .008 | .2032 | | | | | | .0452756 | 1.1500 | 1.15mm | | | | | .13 | 3.3020 | | | | | | .2755906 | 7.0000 | 7.00mm | | | | |
| .0083 | .2108 | #91 | | | | | .0465 | 1.1811 | #56 | | | | | .1318898 | 3.3500 | 3.35mm | | | | | .277 | 7.0358 | J | | | | |
| .0085937 | .2183 | | | 34 | | | .046875 | 1.1906 | 3/64 | | | 0-80 | | .1338583 | 3.4000 | 3.40mm | | | | | .281 | 7.1374 | K | | | | |
| .0097 | .2210 | #90 | | | | | .0472441 | 1.2000 | 1.20mm | | | | | .1358268 | 3.4500 | 3.45mm | | | | | .28125 | 7.1437 | 9/32 | | 1 | | |
| .008928 | .2261 | | 31 | | | | .0492126 | 1.2500 | 1.25mm | | | 1.6mm | | .136 | 3.4544 | #29 | | | 8-32 | | .2893 | 7.3482 | | | | | |
| .009 | .2286 | | | | | | .049261 | 1.2512 | | | | | | .1377726 | 3.4994 | | | | | | .29 | 7.3660 | L | | | | |
| .0091 | .2231 | #89 | | | | | .05 | 1.2700 | | | 18 | | | .1377953 | 3.5000 | 3.50mm | | | | | .295 | 7.4930 | M | | | | |
| .009375 | .2381 | | 33 | | | | .05082 | 1.2908 | | | 16 | | | .138 | 3.5052 | | | | | | .2952756 | 7.5000 | 7.50mm | | | | |
| .0095 | .2413 | #88 | | | | | .0511811 | 1.3000 | 1.30mm | | | 1.7mm | 1.2mm | .14 | 3.5560 | | | | | | .296875 | 7.5387 | 19/64 | | | | |
| .0098425 | .2500 | .25mm | | | | | .052 | 1.3208 | #55 | | | | 00-90 | .1405 | 3.5687 | #28 | | | | 6-32 | .302 | 7.6708 | N | | | | |
| .01 | .2540 | #87 | | | | | .0531469 | 1.35 | 1.35mm | | | | | .140625 | 5.5719 | 9/64 | | | 10 | | .3125 | 7.9375 | 5/16 | | 0 | 3/8-16 | |
| .01003 | .2548 | | 30 | | | | .055 | 1.3970 | #54 | | | | | .1417323 | 3.6000 | 3.60mm | | | | | .3149606 | 8.0000 | 8.00mm | | | | |
| .0101562 | .2580 | | | 32 | | | .0551181 | 1.4000 | 1.4mm | | | | | .144 | 3.6576 | #27 | | | | | .316 | 8.0264 | O | | | | 5/16-18 |
| .0105 | .2667 | #86 | | | | | .05625 | 1.4287 | | | 17 | | | .1443 | 3.6652 | | 7 | | | | .323 | 8.2042 | P | | | | |
| .0109375 | .2778 | | 31 | | | | .05707 | 1.4496 | | | 15 | | | .1456693 | 3.7000 | 3.70mm | | | | | .3249 | 8.2525 | | 0 | | | |
| .0111 | .2819 | #85 | | | | | .0570866 | 1.4500 | 1.45mm | | | 1.8mm | | .147 | 3.7338 | #26 | | | | | .328125 | 8.3347 | 21/64 | | | | |
| .01126 | .2860 | | 29 | | | | .0590551 | 1.5000 | 1.50mm | | | 1.4mm | | .1495 | 3.7973 | #25 | | | | | .332 | 8.4328 | Q | | | | |
| .011481 | .2916 | | | | | | .0595 | 1.5113 | #53 | | | 1-72 | | .1496063 | 3.8000 | 3.80mm | | | | | .339 | 8.6106 | R | | | | |
| .0115 | .2921 | #84 | | | | | .06 | 1.5240 | | | | | | .15 | 3.8100 | | | | | | .34375 | 8.7312 | 11/32 | | 2/0 | | |
| .011811 | .3000 | .30mm | | | | | .0610236 | 1.5500 | 1.55mm | | | | | .152 | 3.8608 | #24 | | | | | .348 | 8.8392 | S | | | | |
| .012 | .3048 | #83 | | | | | .0625 | 1.5875 | 1/16 | | 16 | | | .1535433 | 3.9000 | 3.90mm | | | | | .3543307 | 9.0000 | 9.00mm | | | | |
| .0125 | .3175 | #82 | | 30 | | | .0629921 | 1.6000 | 1.60mm | | | 2.00 | | .154 | 3.9116 | #23 | | | | | .358 | 9.0932 | T | | | | |
| .01264 | .3210 | | 28 | | | | .063 | 1.6002 | | | | | | .15625 | 3.9687 | 5/32 | | | 9 | | .359375 | 9.1281 | 23/64 | | | | |
| .013 | .3302 | #81 | | | | | .0635 | 1.6129 | #52 | | | | | .157 | 3.9878 | #22 | | | | | .3648 | 9.2659 | | 2/0 | | | |
| .0135 | .0000 | #80 | | | | | .06408 | 1.6276 | | | 14 | | | .1574803 | 4.0000 | 4.00mm | | | | | .368 | 9.3472 | U | | | | |
| .0137795 | .3500 | .35mm | | | | | .0649606 | 1.6500 | 1.65mm | | | | | .159 | 4.0386 | #21 | | | | | .375 | 9.5250 | 3/8 | | 3/0 | | |
| .0140625 | .3572 | | | 29 | | | .0669291 | 1.7000 | 1.70mm | | | 1.6mm | | .16 | 4.0640 | | | | | | .377 | 9.5758 | V | | | | |
| .01419 | .3604 | | 27 | | | | .067 | 1.71018 | #51 | | | | | .161 | 4.0894 | #20 | | | 10-32 | | .386 | 9.8044 | W | | | | 3/8-16 |
| .0145 | .3683 | #79 | | | | | .068976 | 1.7000 | 1.75mm | | | 2.2mm | | .1614173 | 4.1000 | 4.10mm | | | | | .390625 | 9.9219 | 25/64 | | | | |
| .015 | .3810 | | | | | | .07 | 1.7780 | #50 | | | 2-56 | | .162 | 4.1148 | | 6 | | | | .393701 | 10.0000 | 10.00mm | | | | |
| .015625 | .3969 | 1/64 | | 28 | 0000-160 | | .0703125 | 1.7859 | | | 15 | | | .164 | 4.1656 | | | | | | .397 | 10.0838 | X | | | | |
| .0157480 | .4000 | .40mm | | | | | .0708661 | 1.8000 | 1.80mm | | | | | .1653543 | 4.2000 | 4.20mm | | | | | .404 | 10.2616 | Y | | | | |
| .01594 | .4049 | | 26 | | | | .07196 | 1.8278 | | | 13 | | | .166 | 4.2164 | #19 | | | | | .40625 | 10.3187 | 13/32 | | 4/0 | | |
| .016 | .4064 | #78 | | | | | .072 | 1.8288 | | | | | | .1692913 | 4.3000 | 4.30mm | | | | | .4096 | 10.4038 | | 3/0 | | | |
| .0171875 | .4366 | | | 27 | | | .0728346 | 1.8500 | 1.85mm | | | 1.8mm | | .1695 | 4.3053 | #18 | | | | 8-32 | .413 | 10.4902 | Z | | | | |
| .0177165 | .4500 | .45mm | | | | | .073 | 1.8542 | #49 | | | | | .17 | 4.3280 | | | | | | .4218745 | 10.7156 | 27/64 | | | 1/2-13 | |
| .0179 | .4547 | | 25 | | | | .0748031 | 1.9000 | 1.90mm | | | | | .171875 | 4.3656 | 11/64 | | | 8 | | .433071 | 11.0000 | 11.00mm | | | | |
| .018 | .4572 | #77 | | | | | .075 | 1.9050 | | | | | | .173 | 4.3942 | #17 | | | | | .4375 | 11.1125 | 7/16 | | 5/0 | | |
| .01875 | .4762 | | | 26 | | | .076 | 1.9304 | #48 | | | 1-72</ | | | | | | | | | | | | | | | |