

# Technical Information

## Recommended tapping drill sizes



# V-COIL

THREAD INSERT SYSTEM

D	P	Ø
M/MF		mm
M 2 x 0.40		2.10
M 2.5 x 0.45		2.60
M 3 x 0.5		3.20
M 3.5 x 0.6		3.70
M 4 x 0.7		4.20
M 5 x 0.8		5.20
M 6 x 1.0		6.30
M 7 x 1.0		7.30
M 8 x 1.0		8.30
M 8 x 1.25		8.30
M 9 x 1.25		9.30
M 9 x 1.5		9.50
M 10 x 1.0		10.30
M 10 x 1.25		10.30
M 10 x 1.5		10.40
M 11 x 1.25		11.40
M 11 x 1.5		11.40
M 12 x 1.0		12.30
M 12 x 1.25		12.30
M 12 x 1.5		12.40
M 12 x 1.75		12.40
M 14 x 1.0		14.30
M 14 x 1.25		14.40
M 14 x 1.5		14.40
M 14 x 2.0		14.50
M 16 x 1.5		16.40
M 16 x 2.0		16.50
M 18 x 1.5		18.50
M 18 x 2.0		18.50
M 18 x 2.5		18.60
M 20 x 1.5		20.50
M 20 x 2.0		20.50
M 20 x 2.5		20.60
M 22 x 1.5		22.50
M 22 x 2.0		22.50
M 22 x 2.5		22.60
M 24 x 1.5		24.50
M 24 x 2.0		24.50
M 24 x 3.0		24.75
M 26 x 1.5		26.50
M 27 x 1.5		27.50
M 27 x 2.0		27.50
M 27 x 3.0		27.75
M 28 x 1.5		28.50
M 30 x 1.5		30.50
M 30 x 2.0		30.50
M 30 x 3.5		31.00
M 33 x 2.0		33.50
M 33 x 3.5		34.00
M 36 x 1.5		36.50
M 36 x 2.0		36.50

D	P	Ø
M/MF		mm
M 36 x 3.0		37.00
M 36 x 4.0		37.00
M 39 x 3.0		39.90
M 39 x 4.0		40.20
M 40 x 3.0		40.90
M 42 x 3.0		42.90
M 42 x 4.5		43.40
M 45 x 3.0		45.90
M 45 x 4.5		46.40
M 48 x 3.0		48.90
M 48 x 4.0		49.20
M 48 x 5.0		49.50
M 50 x 3.0		50.90
M 52 x 3.0		52.90
M 52 x 5.0		53.50
UNC		mm
No. 2 x 56		2.40
No. 4 x 40		3.00
No. 5 x 40		3.40
No. 6 x 32		3.70
No. 8 x 32		4.40
No. 10 x 24		5.10
No. 12 x 24		5.70
1/4 x 20		6.70
5/16 x 18		8.30
3/8 x 16		9.90
7/16 x 14		11.60
1/2 x 13		13.00
9/16 x 12		14.80
5/8 x 11		16.50
3/4 x 10		19.75
7/8 x 9		23.00
1" x 8		26.25
1.1/8 x 7		29.50
1.1/4 x 7		33.00
1.3/8 x 6		36.00
1.1/2 x 6		39.50

D	P	Ø
UNF		mm
No. 4 x 48		3.00
No. 6 x 40		3.70
No. 8 x 36		4.40
No. 10 x 32		5.10
1/4 x 28		6.60
5/16 x 24		8.20
3/8 x 24		9.80
7/16 x 20		11.50
1/2 x 20		13.00
9/16 x 18		14.80
5/8 x 18		16.25
3/4 x 16		19.50
7/8 x 14		22.75
1" x 12		26.00
1" x 14		26.00
1.1/8 x 12		29.00
1.1/4 x 12		32.50
1.3/8 x 12		35.50
1.1/2 x 12		38.50
UNx8		mm
1.1/8 x 8		28.75
1.1/4 x 8		31.75
1.3/8 x 8		35.00
1.1/2 x 8		38.00
1.5/8 x 8		41.50
1.3/4 x 8		44.50
1.7/8 x 8		47.75
2" x 8		50.90
BSW		mm
1/8 x 40		3.40
3/16 x 24		5.10
1/4 x 20		6.70
5/16 x 18		8.30
3/8 x 16		9.90
7/16 x 14		11.60
1/2 x 12		13.00
9/16 x 12		14.80
5/8 x 11		16.70
11/16 x 11		17.80
3/4 x 10		20.00
7/8 x 9		23.00
1" x 8		26.50

D	P	Ø
BSF		mm
3/16 x 32		5.00
1/4 x 26		6.60
5/16 x 22		8.30
3/8 x 20		9.90
7/16 x 18		11.60
1/2 x 16		13.00
9/16 x 16		14.80
5/8 x 14		16.40
11/16 x 14		17.70
3/4 x 12		19.50
7/8 x 11		22.70
1" x 10		26.50
G(BSP)		mm
1/8 x 28		10.00
1/4 x 19		13.60
3/8 x 19		17.10
1/2 x 14		21.50
5/8 x 14		23.40
3/4 x 14		27.00
7/8 x 14		30.60
1" x 11		33.70
BA		mm
0 x 25,40		6.20
2 x 31,35		4.90
4 x 38,48		3.80
6 x 47,92		2.90
BS. Brass		mm
1/4 x 26		6.50
5/16 x 26		8.10
3/8 x 26		9.70
7/16 x 26		11.30
1/2 x 26		12.90