M39 Tap Drill Chart

Metric coarse (ISO) · 4 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

35 mm = 1.3780 in = 35.00 mm

Drills for M39 (50–85% thread)

DRILL	INCH	MM	% THREAD	
36 mm	1.4173	36.00	58%	
35.5 mm	1.3976	35.50	67%	
35 mm	1.3780	35.00	77%	Recommended

Clearance hole (bolt passes through)

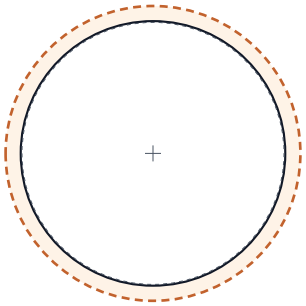
FIT	DRILL	INCH	MM
Close	40 mm	1.5748	40.00
Normal	42 mm	1.6535	42.00
Loose	45 mm	1.7717	45.00

Thread dimensions (basic)

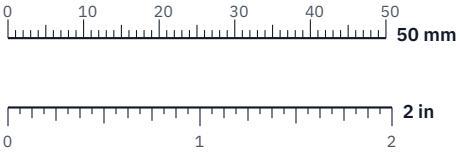
DIMENSION	INCH	MM
Major diameter (basic)	1.5354	39.00
Pitch diameter (basic)	1.4331	36.40
Minor diameter, internal (basic)	1.3650	34.67
Pitch	0.1575	4.00

Actual size

Print at 100% scale ("Actual size", not "Fit to page"). Check with the rulers below.



Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.



Scan for the interactive version:

whatsizeis.com/tap-drill/m39/

Values from the ASME B1.1, ISO 261/68-1 and ASME B1.20.1 thread formulas; drill sizes per ASME B94.11M; clearance holes per ISO 273. Method: whatsizeis.com/how-we-calculate/