M42 Tap Drill Chart

Metric coarse (ISO) · 4.5 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

37.5 mm = 1.4764 in = 37.50 mm

Drills for M42 (50–85% thread)

DRILL	INCH	MM	% THREAD	
39 mm	1.5354	39.00	51%	
38.5 mm	1.5157	38.50	60%	
38 mm	1.4961	38.00	68%	
37.5 mm	1.4764	37.50	77%	Recommended

Clearance hole (bolt passes through)

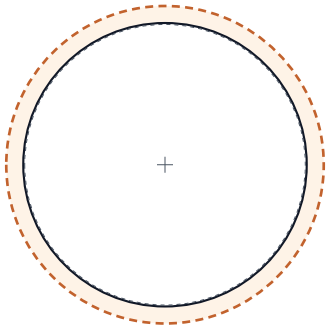
FIT	DRILL	INCH	MM
Close	43 mm	1.6929	43.00
Normal	45 mm	1.7717	45.00
Loose	48 mm	1.8898	48.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.6535	42.00
Pitch diameter (basic)	1.5385	39.08
Minor diameter, internal (basic)	1.4618	37.13
Pitch	0.1772	4.50

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/m42/

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/