



Strong Threads Made Easy

Coil Threaded Inserts for Metal

Drill/Tap Chart

Important Note: Coil inserts require the use of an STI tap

Thread Size	Drill	Tap	Install Tool
Standard Wall - Inch - Coarse			
2-56	3/32	2-56 STI	M1002
3-48	#36	3-48 STI	M1002
4-40	#31	4-40 STI	M1004
5-40	#29	5-40 STI	M1004
6-32	#25	6-32 STI	M1005
8-32	11/64	8-32 STI	M1006
10-24	13/64	10-24 STI	M1007
12-24	15/64	12-24 STI	M1008
1/4-20	17/64	1/4-20 STI	M1009
5/16-18	21/64	5/16-18 STI	M1010
3/8-16	25/64	3/8-16 STI	M1012
7/16-14	29/64	7/16-14 STI	M1014
1/2-13	33/64	1/2-13 STI	M1015
9/16-12	37/64	9/16-12 STI	M1015
5/8-11	21/32	5/8-11 STI	M1018
3/4-10	25/32	3/4-10 STI	M1020
7/8-9	29/32	7/8-9 STI	M1022
1-8	1-1/32	1-8 STI	M1023
1-1/8-7	1-5/32	1-1/8-7 STI	M1024
1-1/4-7	1-9/32	1-1/4-7 STI	M1025
1-3/8-6	1-13/32	1-3/8-6 STI	M1026
1-1/2-6	1-17/32	1-1/2-6 STI	M1027
Standard Wall - Inch - Fine			
4-48	#31	4-48 STI	M1004
6-40	#25	6-40 STI	M1005
8-36	11/64	8-36 STI	M1006
10-32	13/64	10-32 STI	M1008
1/4-28	17/64	1/4-28 STI	M1009
5/16-24	21/64	5/16-24 STI	M1011
3/8-24	25/64	3/8-24 STI	M1013
7/16-20	29/64	7/16-20 STI	M1014
1/2-20	33/64	1/2-20 STI	M1015
9/16-18	37/64	9/16-18 STI	M1017
5/8-18	41/64	5/8-18 STI	M1018
3/4-16	49/64	3/4-16 STI	M1021
7/8-14	57/64	7/8-14 STI	M1022
1-12	1-1/64	1-12 STI	M1023
1-14	1-1/64	1-14 STI	M1023
1-1/8-12	1-5/32	1-1/8-12 STI	M1028
1-1/4-12	1-9/32	1-1/4-12 STI	M1029
1-3/8-12	1-13/32	1-3/8-12 STI	M1030
1-1/2-12	1-17/32	1-1/2-12 STI	M1031

Thread Size	Drill	Tap	Install Tool
Standard Wall - Metric - Coarse			
M2-0.4	2.1	M2-0.4 STI	M1002
M2.5-.45	2.6	M2.5-.45 STI	M1002
M3-0.5	3.1	M3-0.5 STI	M1004
M3.5-0.6	3.6	M3.5-0.6 STI	M1005
M4-0.7	4.1	M4-0.7 STI	M1006
M5-0.8	5.2	M5-0.8 STI	M1008
M6-1.0	6.2	M6-1.0 STI	M1009
M7-1.0	7.2	M7-1.0 STI	M1010
M8-1.25	8.3	M8-1.25 STI	M1011
M10-1.5	10.3	M10-1.5 STI	M1013
M11-1.5	11.3	M11-1.5 STI	M1014
M12-1.75	12.4	M12-1.75 STI	M1015
M14-2.0	14.5	M14-2.0 STI	M1015
M16-2.0	16.5	M16-2.0 STI	M1018
M18-2.5	18.5	M18-2.5 STI	M1020
M20-2.5	20.5	M20-2.5 STI	M1021
M22-2.5	22.5	M22-2.5 STI	M1022
M24-3.0	24.75	M24-3 STI	M1023
M27-3.0	27.5	M27-3 STI	M1032
M30-3.5	30.5	M30-3.5 STI	M1033
M33-3.5	33.5	M33-3.5 STI	M1034
M36-4.0	36.5	M36-4 STI	M1035
M39-4.0	39.5	M39-4 STI	M1036
Standard Wall - Metric - Fine			
M8-1.0	8.3	M8-1.0 STI	M1011
M10-1.25	10.3	M10-1.25 STI	M1013
M12-1.5	12.4	M12-1.5 STI	M1015
M14-1.5	14.3	M14-1.5 STI	M1016
M16-1.5	16.25	M16-1.5 STI	M1018
M18-2.0	18.5	M18-2.0 STI	M1020
M20-2.0	20.5	M20-2.0 STI	M1020
M22-2.0	22.5	M22-2.0 STI	M1022
M24-2.0	24.25	M24-2 STI	M1023
Standard Wall - Metric - Spark Plug			
M10-1.0	10.3	M10-1.0 STI	M1014
M14-1.25	14.3	M14-1.25 STI	M1017
M18-1.5	18.25	M18-1.5 STI	M1020
M12-1.25	12.4	M12-1.25 STI	M1015