

Threading Tapping Drill Size Chart

M ISO METRIC COARSE (60°)		
Tap Size	Pitch mm	Tapping Drill mm
M1.6	0.35	1.25
M2	0.4	1.6
M2.5	0.45	2.05
M3	0.5	2.5
M3.5	0.6	2.9
M4	0.7	3.3
M4.5	0.75	3.7
M5	0.8	4.2
M6	1.0	5.0
M8	1.25	6.8
M10	1.5	8.5
M12	1.75	10.2
M14	2.0	12.0
M16	2.0	14.0
M18	2.5	15.5
M20	2.5	17.5
M22	2.5	19.5
M24	3.0	21.0
M27	3.0	24.0
M30	3.5	26.5
M33	3.5	29.5
M36	4.0	32.0
M42	4.5	37.5
M45	4.5	40.5
M48	5.0	43.0
M52	5.0	47.0
M56	5.5	50.5

MF ISO METRIC FINE (60°)		
Tap Size	Pitch mm	Tapping Drill mm
M4	0.5	3.5
M5	0.5	4.5
M6	0.75	5.3
M8	1.0	7.0
M10**	1.0	9.0
M10	1.25	8.8
M12**	1.25	10.8
M12	1.5	10.5
M14**	1.25	12.8
M14	1.5	12.5
M16*	1.5	14.5
M18**	1.5	16.5
M20*	1.5	18.5
M22	1.5	20.5
M24	2.0	22.0
M25*	1.5	23.5
M32*	1.5	30.5
M40*	1.5	38.5
M50*	1.5	48.5

*Metric Conduit **Spark Plug

8UN (8 TPI) UNIFIED NATIONAL FORM (60°)		
Tap Size	TPI	Tapping Drill mm
1-1/8	8	25.5
1-1/4	8	28.5
1-3/8	8	31.75
1-1/2	8	35.0
1-5/8	8	38.0
1-3/4	8	41.5
1-7/8	8	44.5
2	8	47.5

UNC UNIFIED NATIONAL COARSE (60°)		
Tap Size	TPI	Tapping Drill mm
#2 (.086)	56	1.85
#3 (.099)	48	2.1
#4 (.112)	40	2.3
#5 (.125)	40	2.6
#6 (.138)	32	2.8
#8 (.164)	32	3.4
#10 (.190)	24	3.8
#12 (.216)	24	4.5
1/4	20	5.1
5/16	18	6.6
3/8	16	8.0
7/16	14	9.4
1/2	13	10.8
9/16	12	12.2
5/8	11	13.5
3/4	10	16.5
7/8	9	19.5
1	8	22.2
1-1/8	7	25.0
1-1/4	7	28.0
1-3/8	6	31.0
1-1/2	6	34.0
1-3/4	5	39.5
2	4.5	45.0

UNF UNIFIED NATIONAL FINE (60°)		
Tap Size	TPI	Tapping Drill mm
#3 (.099)	56	2.1
#4 (.112)	48	2.35
#5 (.125)	44	2.65
#6 (.138)	40	2.9
#8 (.164)	36	3.5
#10 (.190)	32	4.1
#12 (.216)	28	4.6
3/16*	32	4.0
1/4	28	5.5
5/16	24	6.9
3/8	24	8.5
7/16	20	9.8
1/2	20	11.5
9/16	18	12.8
5/8	18	14.5
3/4	16	17.5
7/8	14	20.5
1	12	23.5
1*	14	24.0
1-1/8	12	26.5
1-1/4	12	29.5
1-3/8	12	33.01
1-1/2	12	36.0

*UNS

UNEF UNIFIED NATIONAL FORM (60°)		
Tap Size	TPI	Tapping Drill mm
1/4	32	5.6
5/16	32	7.2
3/8	32	8.8
1/2	28	11.8
5/8	24	14.75
3/4	20	18
1	20	24.2

BSW BRITISH STANDARD WHITWORTH (55°)		
Tap Size	TPI	Tapping Drill mm
1/16*	60	1.2
3/32*	48	1.85
1/8	40	2.55
5/32*	32	3.2
3/16	24	3.7
7/32*	24	4.5
1/4	20	5.1
5/16	18	6.5
3/8	16	7.9
7/16	14	9.3
1/2	12	10.5
9/16	12	12.1
5/8	11	13.5
3/4	10	16.25
7/8	9	19.25
1	8	22.0
1-1/8	7	24.75
1-1/4	7	28.0
1-1/2	6	33.5
1-3/4	5	39.0
2	4-1/2	44.5

*WHIT. Form

BSF BRITISH STANDARD FINE (55°)		
Tap Size	TPI	Tapping Drill mm
3/16	32	4.0
7/32	28	4.6
1/4	26	5.3
5/16	22	6.8
3/8	20	8.3
7/16	18	9.8
1/2	16	11.0
9/16	16	12.7
5/8	14	14.0
11/16	14	15.5
3/4	12	16.75
7/8	11	19.75
1	10	22.75
1-1/8	9	25.5
1-1/4	9	28.5
1-1/2	8	34.5
1-3/4	7	41.0

BSB BRITISH STANDARD BRASS (55°)		
Tap Size	TPI	Tapping Drill mm
1/4	26	5.2
5/16	26	6.8
3/8	26	8.4
7/16	26	10.0
1/2	26	11.6
9/16	26	13.2
5/8	26	14.8
3/4	26	18.0
7/8	26	20.8
1	26	24.3

*Taper pipe threads of improved quality are obtained when the tapping hole is pre-formed using Sutton Taper Pipe Reamers.