

TAPPING DRILL SIZES

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
ISO MC		
1.6	0.35	1.25
1.8	0.35	1.45
2	0.4	1.6
2.2	0.45	1.75
2.5	0.45	2.05
3	0.5	2.5
3.5	0.6	2.9
4	0.7	3.3
4.5	0.75	3.8
5	0.8	4.2
6	1	5
7	1	6
8	1.25	6.8
9	1.25	7.8
10	1.5	8.5
11	1.5	9.5
12	1.75	10.3
14	2	12
16	2	14
18	2.5	15.5
20	2.5	17.5
22	2.5	19.5
24	3	21
27	3	24
30	3.5	26.5
33	3.5	29.5
36	4	32
39	4	35
42	4.5	37.5
45	4.5	40.5
48	5	43
52	5	47

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
ISO UNC		
nr 2	56	1.8
nr 3	48	2
nr 4	40	2.35
nr 5	40	2.65
nr 6	32	2.85
nr 8	32	3.5
nr 10	24	3.9
nr 12	24	4.5
¼	20	5.1
⅜	18	6.6
½	16	8
⅞	14	9.4
1	13	10.8
1 1/16	12	12.2
1 1/8	11	13.5
1 1/4	10	16.5
1 1/2	9	19.5
1 3/4	8	22.25
2	7	25
2 1/4	7	28
2 1/2	6	30.5
2 3/4	6	34
3	5	39.5
4	4.5	45

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
ISO MF		
3	0.35	2.65
3.5	0.35	3.2
4	0.5	3.5
5	0.5	4.5
5.5	0.5	5
6	0.75	5.3
7	0.75	6.3
8	0.75	7.3
8	1	7
9	1	8
10	0.75	9.3
10	1	9
10	1.25	8.8
11	1	10
12	1	11
12	1.25	10.8
12	1.5	10.5
14	1	13
14	1.25	12.8
14	1.5	12.5
15	1	14
15	1.5	13.5
16	1	15
16	1.5	14.5
18	1	17
18	1.5	16.5
18	2	16
20	1	19
20	1.5	18.5
20	2	18
22	1	21
22	1.5	20.5
22	2	20
24	1	23
24	1.5	22.5
24	2	22
25	1	24
25	1.5	23.5
25	2	23
26	1.5	24.5
27	1.5	25.5
27	2	25
28	1.5	26.5
28	2	26
30	1.5	28.5
30	2	28
32	1.5	30.5
32	2	30
33	2	31
35	1.5	33.5
36	1.5	34.5
36	2	34
36	3	33
38	1.5	36.5
39	3	36
40	1.5	38.5
40	2	38
40	3	37
42	1.5	40.5
42	2	40
42	3	39
45	1.5	43.5
45	2	43
45	3	42
48	1.5	46.5
48	2	46
48	3	45
50	1.5	48.2
50	2	48
50	3	47

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
ISO UNF		
nr 2	64	1.8
nr 3	56	2.1
nr 4	48	2.4
nr 4	44	2.7
nr 6	40	2.95
nr 8	36	3.5
nr 10	32	4.1
nr 12	28	4.7
¼	28	5.5
5/16	24	6.9
¾	24	8.5
7/16	20	9.9
½	20	11.5
9/16	18	12.9
¾	18	14.5
¾	16	17.5
¾	14	20.5
1	12	23.25
1 1/8	12	26.5
1 ¼	12	29.5
1 ½	12	33
1 1/2	12	36

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
BSW		
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	9.2
1/2	12	10.5
9/16	12	12
5/8	11	13.5
3/4	10	16.5
7/8	9	19.25
1	8	22
1 1/8	7	24.75
1 ¼	7	28
1 ½	6	30.5
1 1/2	6	33.5
1 3/4	5	35.5
1 3/4	5	39
1 7/8	4 1/2	41.5
2	4 1/2	44.5

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
NPT		
1/16	27	6.3
1/8	27	8.5
1/4	18	11
3/8	18	14.5
1/2	14	18
3/4	14	23
1	14	29
1 ¼	11 1/2	38
1 1/2	11 1/2	44
2	11 1/2	56
2 1/2	8	67
3	8	83

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
BSP (G)		
1/8	28	8.8
1/4	19	11.8
3/8	19	15.25
1/2	14	19
5/8	14	21
3/4	14	24.5
7/8	14	28
1	11	30.5
1 ¼	11	39.5
1 1/2	11	45
1 3/4	11	51
2	11	57
2 ¼	11	63
2 1/2	11	72.5
2 3/4	11	79
3	11	85.5

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
BSPT		
1/8	28	8.4
1/4	19	11.2
3/8	19	14.75
1/2	14	18.25
5/8	14	20.25
3/4	14	23.75
7/8	14	27.5
1	11	30
1 1/8	11	34.5
1 ¼	11	38.5
1 ½	11	41
1 1/2	11	44.5
1 3/4	11	50
2	11	56
2 ¼	11	62
2 1/2	11	71.5
2 3/4	11	78
3	11	84

TAP SIZE	PITCH / TPI	DRILL DIA
	MM	MM
BSF		
3/16	32	5/32
7/32	28	4.65
1/4	26	5.30
5/16	22	6.75
3/8	20	8.25
7/16	18	9.70
1/2	16	7/16
9/16	16	1/2
5/8	14	14
3/4	12	16.75
7/8	11	25/32
1	10	22.75
1 1/8	9	25.5
1 ¼	9	28.75
1 ½	8	31.5
1 1/2	8	1 23/64