



Thread Tapping Chart

M METRIC COARSE 60°

Thread	Pitch	Drill Size
M1.6	0.35mm	1.25mm
M2	0.40mm	1.60mm
M2.5	0.45mm	2.05mm
M3	0.50mm	2.50mm
M3.5	0.60mm	2.90mm
M4	0.70mm	3.30mm
M4.5	0.75mm	3.70mm
M5	0.80mm	4.20mm
M6	1.00mm	5.00mm
M8	1.25mm	6.80mm
M10	1.50mm	8.50mm
M12	1.75mm	10.20mm
M14	2.00mm	12.00mm
M16	2.00mm	14.00mm
M18	2.50mm	15.50mm
M20	2.50mm	17.50mm
M22	2.50mm	19.50mm
M24	3.00mm	21.00mm
M27	3.00mm	24.00mm
M30	3.50mm	26.50mm
M33	3.50mm	29.50mm
M36	4.00mm	32.00mm
M42	4.50mm	37.50mm
M45	4.50mm	40.50mm
M48	5.00mm	43.00mm
M52	5.00mm	47.00mm
M56	5.00mm	50.50mm

MF METRIC FINE 60°

Thread	Pitch	Drill Size
M4	0.50mm	3.50mm
M5	0.50mm	4.50mm
M6	0.75mm	5.30mm
M8	1.00mm	7.00mm
M10**	1.00mm	9.00mm
M10	1.25mm	8.80mm
M12**	1.25mm	10.80mm
M12	1.50mm	10.50mm
M14**	1.25mm	12.80mm
M14	1.50mm	12.50mm
M16*	1.50mm	14.50mm
M18**	1.50mm	16.50mm
M20*	1.50mm	18.50mm
M22	1.50mm	20.50mm
M24	2.00mm	22.00mm
M25*	1.50mm	23.50mm
M32*	1.50mm	30.50mm
M40*	1.50mm	38.50mm
M50*	1.50mm	48.50mm

*Metric Conduit **Spark Plug

UNC UNIFIED NATIONAL COARSE 60°

Thread	TPI	Drill Size
#2	56	1.85mm
#3	48	2.10mm
#4	40	2.30mm
#5	40	2.60mm
#6	32	2.80mm
#8	32	3.40mm
#10	24	3.80mm
#12	24	4.50mm
1/4	20	5.10mm
5/16	18	6.60mm
3/8	16	8.00mm
7/16	14	9.40mm
1/2	13	10.80mm
9/16	12	12.20mm
5/8	11	13.50mm
3/4	10	16.55mm
7/8	9	19.55mm
1	8	22.20mm
1-1/8	7	25.00mm
1-1/4	7	28.00mm
1-3/8	6	31.00mm
1-1/2	6	34.00mm
1-3/4	5	39.50mm
2	4.5	45.00mm

UNF UNIFIED NATIONAL FINE 60°

Thread	TPI	Drill Size
#3	56	2.10mm
#4	48	2.35mm
#5	44	2.65mm
#6	40	2.90mm
#8	36	3.50mm
#10	32	4.10mm
#12	28	4.60mm
3/16*	32	4.00mm
1/4	28	5.50mm
5/16	24	6.90mm
3/8	24	8.50mm
7/16	20	9.80mm
1/2	20	11.50mm
9/16	18	12.80mm
5/8	18	14.50mm
3/4	16	17.50mm
7/8	14	20.50mm
1	12	23.50mm
1*	14	24.00mm
1-1/8	12	26.50mm
1-1/4	12	29.50mm
1-3/8	12	33.01mm
1-1/2	12	36.00mm

*UNS

BSW BRITISH STANDARD WHITWORTH 55°

Thread	TPI	Drill Size
1/16*	60	1.20mm
3/32*	48	1.85mm
1/8	40	2.55mm
5/32*	32	3.20mm
3/16	24	3.70mm
7/32*	24	4.50mm
1/4	20	5.10mm
5/16	18	6.50mm
3/8	16	7.90mm
7/16	14	9.30mm
1/2	12	10.50mm
9/16	12	12.10mm
5/8	11	13.50mm
3/4	10	16.25mm
7/8	9	19.25mm
1	8	22.00mm
1-1/8	7	24.75mm
1-1/4	7	28.00mm
1-1/2	6	33.50mm
1-3/4	5	39.00mm
2	4-1/2	44.50mm

*WHIT. Form