

Recommended Tapping Drill Sizes

Mf	Ø	BSF	Ø	UNC	Ø	UNF	Ø	8-UN	Ø	UNEF	Ø	PG	Ø
	mm		mm		mm		mm		mm		mm		mm
M 105 x 1.5	103.5	BSF 1/4"	5.2	No. 1-64	1.5	No. 0-80	1.3	UN 1.1/16-8	23.9	No. 12-32	4.75	PG 7	11.4
M 105 x 2.0	103	BSF 5/16"	6.6	No. 2-56	1.8	No. 1-72	1.6	UN 1.1/8-8	25.5	1/4-32	5.6	PG 9	14
M 105 x 3.0	102	BSF 3/8"	8.1	No. 3-48	2.1	No. 2-64	1.9	UN 1.3/16-8	27.1	5/16-32	7.2	PG 11	17.25
M 105 x 4.0	101	BSF 7/16"	9.5	No. 4-40	2.3	No. 3-56	2.1	UN 1.1/4-8	28.75	3/8-32	8.8	PG 13.5	19
M 110 x 1.5	108.5	BSF 1/2"	11	No. 5-40	2.6	No. 4-48	2.4	UN 1.5/16-8	30.3	7/16-28	10.25	PG 16	21.25
M 110 x 2.0	108	BSF 5/8"	14	No. 6-32	2.85	No. 5-44	2.7	UN 1.3/8-8	31.75	1/2-28	11.8	PG 21	26.75
M 110 x 3.0	107	BSF 3/4"	16.5	No. 8-32	3.5	No. 6-40	3	UN 1.1/2-8	35	9/16-24	13.3	PG 29	35.5
M 110 x 4.0	106	BSF 7/8"	19.5	No. 10-24	3.9	No. 8-36	3.5	UN 1.5/8-8	38	5/8-24	14.9	PG 36	45.5
		BSF 1"	22.5	No. 12-24	4.5	No. 10-32	4.1	UN 1.3/4-8	41.5	11/16-24	16.5	PG 42	52.5
				No. 14-20	5.2	No. 12-28	4.7	UN 1.7/8-8	44.5	3/4-20	17.75	PG 48	58
BSW	Ø	BSP	Ø										
	mm	G	mm									NPT	Ø
W 3/32"	1.8	G 1/8"	8.8	5/16-18	6.6	1/4-28	5.5	UN 2"-8	47.75	13/16-20	19.5		mm
W 1/8"	2.6	G 1/4"	11.8	3/8-16	8	5/16-24	6.9	UN 2.1/8-8	50.9	7/8-20	21		
W 5/32"	3.1	G 3/8"	15.25	7/16-14	9.4	3/8-24	8.5	UN 2.1/4-8	54	15/16-20	22.5		
W 3/16"	3.6	G 1/2"	19	1/2-13	10.8	7/16-20	9.9	UN 2.1/2-8	60.4	1"-20	24.25	1/16-27	6.3
W 7/32"	4.4	G 5/8"	21	9/16-12	12.2	1/2-20	11.5	UN 2.3/4-8	66.7	1.1/16-18	25.7	1/8-27	8.5
W 1/4"	5.1	G 3/4"	24.5	5/8-11	13.5	9/16-18	12.9	UN 3"-8	73.1	1.1/8-18	27.25	1/4-18	11.2
W 5/16"	6.5	G 7/8"	28.25	3/4-10	16.5	5/8-18	14.5	UN 3.1/4-8	79.4	1.3/16-18	28.75	3/8-18	14.5
W 3/8"	7.9	G 1"	30.75	7/8-9	19.5	3/4-16	17.5	UN 3.1/2-8	85.8	1.1/4-18	30.5	1/2-14	18
W 7/16"	9.3	G 1.1/8"	35.3	1"-8	22.25	7/8-14	20.25	UN 3.3/4-8	92.1	1.5/16-18	32	3/4-14	23
W 1/2"	10.5	G 1.1/4"	39.3	1.1/8-7	25	1"-12	23.25	UN 4"-8	98.5	1.3/8-18	33.5	1"-11.5	29
W 9/16"	12	G 1.3/8"	41.7	1.1/4-7	28.25	1.1/8-12	26.5			1.7/16-18	35.2	1.1/4-11.5	38
W 5/8"	13.5	G 1.1/2"	45.7	1.3/8-6	30.75	1.1/4-12	29.5			1.1/2-18	36.8	1.1/2-11.5	44
W 3/4"	16.5	G 1.3/4"	51.1	1.1/2-5	34	1.3/8-12	32.5			1.9/16-18	38.4	2"-11.5	56
W 7/8"	19.25	G 2"	57	1.3/4-5	39.5	1.1/2-12	36			1.5/8-18	40	2.1/2-8	67
W 1"	22	G 2.1/4"	63.1	2"-4.5	45					1.11/16-18	41.5	3"-8	83
W 1 1/8"	24.75	G 2.1/2"	72.6	2.1/4-4	51.5	12-UN	Ø	UN	Ø	1.3/4-18	43		
W 1 1/4"	27.75	G 2.3/4"	78.9	2 1/2-4	57.25	UN 1.5/8-12	39.2	UN 5/16-28	7	2"-18	49.4	W	Ø
W 1 3/8"	30.2	G 3"	85.3	2.3/4-4	63.5	UN 1.3/4-12	42.4	UN 3/8-20	8.			DIN 477	mm
W 1 1/2"	33.5			3"-4	70	UN 1.7/8-12	45.6	UN 3/8-28	8.6	UNEF		W 19.8	15.1
W 1 3/4"	38.5	BA	Ø	3.1/2-4	82.6	UN 2"-12	48.75	UN 7/16-32	10.3		mm	W 28.8	23.5
W 2"	44.5	BA 0	5.1			UN 2.1/8-12	51.9	UN 1/2-32	11.9	UNS 1/4-24	5.4	W 31.3	26.0
		BA 1	4.5			UN 2.1/4-12	55.1	UN 9/16-20	10.9	UNS 1/4-36	5.7		
		BA 2	4			UN 2.1/2-12	61.5	UN 9/16-28	11.3	UNS 1/4-40	5.75		
		BA 3	3.4			UN 2.3/4-12	67.8	UN 9/16-32	11.4	UNS 3/8-27	8.35		
		BA 4	3			UN 3"-12	74.2	UN 5/8-20	14.6	UNS 7/16-24	10.1		
		BA 5	2.65			UN 3.1/4-12	80.5	UN 5/8-28	15	UNS 1/2-24	11.75		
		BA 6	2.3			UN 3.1/2-12	86.9	UN 11/16-20	16.2	UNS 5/8-27	14.7		
						UN 3.3/4-12	93.2	UN 11/16-16	15.9	UNS 3/4-24	18		
						UN 4"-12	99.6	UN 1"-32	24.6	UNS 7/8-18	21		
										UNS 1"-14	23.75		

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M	Ø		Mf	Ø		Mf	Ø		Mf	Ø		Mf	Ø		Mf	Ø	
	mm			mm			mm			mm			mm			mm	
M 1	0.25	0.75	M 2.5 x 0.35	2.15	M 16 x 0.5	15.5	M 27 x 2.0	25	M 44 x 2	42	M 62 x 4.0	58	M 82 x 2.0	80			
M 1.1	0.25	0.85	M 2.6 x 0.35	2.25	M 16 x 1.0	15	M 28 x 1.0	27	M 42 x 3.0	39	M 63 x 1.5	61.5	M 82 x 3.0	79			
M 1.2	0.25	0.95	M 3 x 0.35	2.65	M 16 x 0.75	14.75	M 28 x 1.5	26.5	M 45 x 1	44	M 64 x 1.5	62.5	M 82 x 4.0	78			
M 1.4	0.3	1.1	M 3.5 x 0.35	3.15	M 16 x 1.25	14.75	M 28 x 2.0	24	M 45 x 1.5	43.5	M 64 x 2.0	62	M 84 x 1.5	82.5			
M 1.6	0.35	1.25	M 4 x 0.35	3.65	M 16 x 1.5	14.5	M 29 x 1.5	27.5	M 45 x 2.0	43	M 64 x 3.0	61	M 84 x 2.0	82			
M (1.7)	0.35	1.3	M 4 x 0.5	3.5	M 18 x 0.5	17.5	M 30 x 1.0	29	M 45 x 3.0	42	M 64 x 4.0	60	M 84 x 3.0	81			
M 1.8	0.35	1.45	M 4.5 x 0.5	4	M 17 x 1.0	16	M 30 x 1.5	28.5	M 46 x 1.5	44.5	M 65 x 1.5	63.5	M 84 x 4.0	80			
M 2	0.4	1.6	M 5 x 0.5	4.5	M 18 x 1.0	17	M 30 x 2.0	28	M 48 x 1.5	46.5	M 65 x 2.0	63	M 85 x 1.5	83.5			
M 2.2	0.45	1.75	M 5 x 0.75	4.25	M 18 x 1.25	16.75	M 30 x 2.5	27.5	M 48 x 1	47	M 65 x 3.0	62	M 85 x 2.0	83			
M (2.3)	0.4	1.9	M 5.5 x 0.5	5	M 18 x 1.5	16.5	M 30 x 3.0	27	M 48 x 2.0	46	M 65 x 4.0	61	M 85 x 3.0	82			
M 2.5	0.45	2.05	M 6 x 0.5	5.5	M 18 x 0.75	17.25	M 32 x 2	30	M 48 x 3.0	45	M 68 x 1.5	66.5	M 85 x 4.0	81			
M (2.6)	0.45	2.1	M 6 x 0.75	5.2	M 18 x 2.0	16	M 32 x 1.5	29.5	M 50 x 1.5	48.5	M 68 x 2.0	66	M 86 x 1.5	84.5			
M 3	0.5	2.5	M 7 x 0.5	6.5	M 19 x 1.0	18	M 32 x 3.0	29	M 50 x 2.0	48	M 68 x 3.0	65	M 86 x 2.0	84			
M 3.5	0.6	2.9	M 7 x 0.75	6.2	M 19 x 1.5	17.5	M 33 x 1.5	31.5	M 50 x 3.0	47	M 68 x 4.0	64	M 86 x 3.0	83			
M 4	0.7	3.3	M 8 x 0.5	7.5	M 20 x 0.5	19.5	M 32 x 1	31	M 52 x 1.5	50.5	M 70 x 1.5	68.5	M 86 x 4.0	82			
M 4.5	0.75	3.7	M 8 x 0.75	7.2	M 20 x 1.0	19	M 33 x 2.0	31	M 52 x 2.0	50	M 70 x 2.0	68	M 88 x 1.5	86.5			
M 5	0.8	4.2	M 8 x 1.0	7	M 20 x 0.75	19.25	M 33 x 3.0	30	M 52 x 3.0	49	M 70 x 3.0	67	M 88 x 2.0	86			
M 6	1	5	M 9 x 0.5	8.5	M 20 x 1.25	18.75	M 34 x 1	33	M 54 x 1.0	53	M 70 x 4.0	66	M 88 x 3.0	85			
M 7	1	6	M 9 x 0.75	8.2	M 20 x 1.5	18.5	M 34 x 1.5	32.5	M 54 x 1.5	52.5	M 72 x 1.5	70.5	M 88 x 4.0	84			
M 8	1.25	6.8	M 9 x 1.0	8	M 20 x 2.0	18	M 34 x 2.0	32	M 54 x 2.0	52	M 72 x 2.0	70	M 90 x 1.5	88.5			
M 9	1.25	7.8	M 10 x 0.5	9.5	M 21 x 1.0	20	M 35 x 2	34	M 54 x 3.0	51	M 72 x 3.0	69	M 90 x 2.0	88			
M 10	1.5	8.5	M 10 x 0.75	9.2	M 21 x 1.5	19.5	M 35 x 1.5	33.5	M 54 x 4.0	50	M 72 x 4.0	68	M 90 x 3.0	87			
M 11	1.5	9.5	M 10 x 1.0	9	M 22 x 0.5	21.5	M 35 x 2	33	M 55 x 1.5	53.5	M 74 x 1.5	72.5	M 90 x 4.0	86			
M 12	1.75	10.2	M 10 x 1.25	8.8	M 22 x 1.0	21	M 36 x 1.5	34.5	M 55 x 2.0	53	M 74 x 2.0	72	M 92 x 1.5	90.5			
M 14	2	12	M 11 x 1.0	10	M 22 x 0.75	21.25	M 36 x 1	35	M 55 x 3.0	52	M 74 x 3.0	71	M 92 x 2.0	90			
M 16	2	14	M 11 x 1.25	9.8	M 22 x 1.25	20.75	M 36 x 2.0	34	M 55 x 4.0	51	M 74 x 4.0	70	M 92 x 3.0	89			
M 18	2.5	15.5	M 12 x 0.75	11.2	M 22 x 1.5	20.5	M 37 x 1.5	35.5	M 56 x 1.0	55	M 75 x 1.5	73.5	M 92 x 4.0	88			
M 20	2.5	17.5	M 12 x 1.0	11	M 22 x 2.0	20	M 36 x 3.0	33	M 56 x 1.5	54.5	M 75 x 2.0	73	M 95 x 1.5	93.5			
M 22	2.5	19.5	M 12 x 0.5	11.5	M 23 x 1.0	22	M 38 x 1	37	M 56 x 2.0	54	M 75 x 3.0	72	M 95 x 2.0	93			
M 24	3	21	M 12 x 1.25	10.8	M 23 x 1.5	21.5	M 38 x 1.5	36.5	M 56 x 3.0	53	M 75 x 4.0	71	M 95 x 3.0	92			
M 27	3	24	M 13 x 0.5	12.5	M 24 x 1.0	23	M 38 x 2.0	36	M 56 x 4.0	52	M 76 x 1.5	74.5	M 95 x 4.0	91			
M 30	3.5	26.5	M 12 x 1.5	10.5	M 24 x 0.5	23.5	M 39 x 1.5	37.5	M 58 x 1.0	57	M 76 x 2.0	74	M 96 x 1.5	94.5			
M 33	3.5	29.5	M 13 x 0.75	12.25	M 24 x 1.25	22.75	M 38 x 3	35	M 58 x 1.5	56.5	M 76 x 3.0	73	M 96 x 2.0	94			
M 36	4	32	M 13 x 1.0	12	M 24 x 0.75	23.25	M 39 x 2.0	37	M 58 x 2.0	56	M 76 x 4.0	72	M 96 x 3.0	93			
M 39	4	35	M 13 x 1.5	11.5	M 24 x 1.5	22.5	M 39 x 3.0	36	M 58 x 3.0	55	M 78 x 1.5	76.5	M 96 x 4.0	92			
M 42	4.5	37.5	M 14 x 0.75	13.25	M 24 x 2.0	22	M 40 x 1	39	M 58 x 4.0	54	M 78 x 2.0	76	M 98 x 1.5	96.5			
M 45	4.5	40.5	M 14 x 1.0	13	M 25 x 1.0	24	M 40 x 1.5	38.5	M 60 x 1.5	58.5	M 78 x 3.0	75	M 98 x 2.0	96			
M 48	5	43	M 14 x 1.25	12.8	M 25 x 1.5	23.5	M 40 x 2.0	38	M 60 x 2.0	58	M 78 x 4.0	74	M 98 x 3.0	95			
M 52	5	47	M 14 x 0.5	13.5	M 26 x 1.0	25	M 40 x 3.0	37	M 60 x 3.0	57	M 80 x 1.5	78.5	M 98 x 4.0	94			
			M 14 x 1.5	12.5	M 26 x 1.5	24.5	M 42 x 1	41	M 60 x 4.0	56	M 80 x 2.0	78	M 100 x 1.5	98.5			
M 3	0.6	2.4	M 15 x 0.75	14.25	M 26 x 2.0	24	M 42 x 1.5	40.5	M 62 x 1.5	60.5	M 80 x 3.0	77	M 100 x 2.0	98			
M 3.5	0.75	2.75	M 15 x 1.0	14	M 27 x 1.0	26	M 44 x 1.5	42.5	M 62 x 2.0	60	M 80 x 4.0	76	M 100 x 3.0	97			
M 4	0.75	3.25	M 15 x 1.5	13.5	M 27 x 1.5	25.5	M 42 x 2.0	40	M 62 x 3.0	59	M 82 x 1.5	80.5	M 100 x 4.0	96			
M 5	0.9	4.1															