

Tapping Drill Sizes - Metric / US

A.J.H. Computer Services

METRIC COARSE SIZES	
TAP SIZE	DRILL SIZE
1 x 0.25	0.75
1.1 x 0.25	0.85
1.2 x 0.25	0.95
1.4 x 0.3	1.1
1.6 x 0.35	1.25
1.7 x 0.35	1.3
1.8 x 0.35	1.45
2 x 0.4	1.6
2.2 x 0.45	1.75
2.5 x 0.45	2.05
3 x 0.5	2.5
3.5 x 0.6	2.9
4 x 0.7	3.3
4.5 x 0.75	3.7
5 x 0.8	4.2
6 x 1	5
7 x 1	6
8 x 1.25	6.8
9 x 1.25	7.8
10 x 1.5	8.5
11 x 1.5	9.5
12 x 1.75	10.2
14 x 2	12
16 x 2	14
18 x 2.5	15.5
20 x 2.5	17.5
22 x 2.5	19.5
24 x 3	21
27 x 3	24
30 x 3.5	26.5
33 x 3.5	29.5
36 x 4	32
39 x 4	35

METRIC FINE SIZES	
TAP SIZE	DRILL SIZE
4 x .35	3.6
4 x .5	3.5
5 x .5	4.5
6 x .5	5.5
6 x .75	5.25
7 x .75	6.25
8 x .5	7.5
8 x .75	7.25
8 x 1	7
9 x 1	8
10 x .75	9.25
10 x 1	9
10 x 1.25	8.8
11 x 1	10
12 x .75	11.25
12 x 1	11
12 x 1.5	10.5
14 x 1	13
14 x 1.25	12.8
14 x 1.5	12.5
16 x 1	15
16 x 1.5	14.5
18 x 1	17
18 x 2	16
20 x 1	19
20 x 1.5	18.5
20 x 2	18
22 x 1	21
22 x 1.5	20.5
22 x 2	20
24 x 1.5	22.5
24 x 2	22
26 x 1.5	24.5
27 x 1.5	25.5
27 x 2	25
28 x 1.5	26.5
30 x 1.5	28.5
30 x 2	28
33 x 2	31
36 x 3	33
39 x 3	36

NATIONAL COARSE (UNC)		Metric
TAP SIZE	DRILL SIZE	Equivalents
No. 1 x 64	No. 53	1.5
No. 2 x 56	No. 51	1.7
No. 3 x 48	5/64"	2
No. 4 x 40	No. 43	2.3
No. 5 x 40	No. 39	2.5
No. 6 x 32	No. 36	2.7
No. 8 x 32	No. 29	3.5
No. 10 x 24	No. 25	3.8
No. 12 x 24	No. 17	4.4
1/4 x 20	No. 7	5.1
5/16 x 18	F (Letter)	6.5
3/8 x 16	5/16"	7.9
7/16 x 14	U (Letter)	9.3
1/2 x 13	27/64"	10.7
9/16 x 12	31/64"	12.3
5/8 x 11	17/32"	13.5
3/4 x 10	21/32"	16.7
7/8 x 9	49/64"	19.4
1" x 8	7/8"	22.2
1-1/8 x 7	63/64"	25
1-1/4 x 7	1-7/64"	28.2
1-1/2 x 6	1-11/32"	34.1
1-3/4 x 5	1-35/64"	39.3
2" x 4-1/2	1-25/32"	45.2

NATIONAL FINE (UNF)		Metric
TAP SIZE	DRILL SIZE	Equivalents
No. 0 x 80	3/64"	1.2
No. 1 x 72	No. 53	1.5
No. 2 x 64	No. 50	1.8
No. 3 x 56	No. 46	2.1
No. 4 x 48	No. 42	2.4
No. 5 x 44	No. 37	2.6
No. 6 x 40	No. 33	2.9
No. 8 x 36	No. 29	3.5
No. 10 x 32	No. 21	4
No. 12 x 28	No. 15	4.6
1/4 x 28	No. 3	5.4
5/16 x 24	I (Letter)	6.9
3/8 x 24	Q (Letter)	8.4
7/16 x 20	W (Letter)	9.8
1/2 x 20	29/64"	11.5
9/16 x 18	33/64"	13.1
5/8 x 18	37/64"	14.7
3/4 x 16	11/16"	17.5
7/8 x 14	13/16"	20.6
1" x 14	15/16"	23.8
1-1/8 x 12	1-3/64"	26.6
1-1/4 x 12	1-11/64"	29.8
1-1/2 x 12	1-27/64"	36.1
1-3/4 x 12	1-43/64"	42.4
2" x 12	1-59/64"	48.8

TAPER PIPE SIZES - NPT		Metric
TAP SIZE	DRILL SIZE	Equivalents
1/8 x 27	S (Letter)	8.8
1/4 x 18	29/64"	11.5
3/8 x 18	19/32"	15.1
1/2 x 14	47/64"	18.7
3/4 x 14	15/16"	23.8
1" x 11-1/2	1-3/16"	30.2
1-1/4 x 11-1/2	1-33/64"	38.5
1-1/2 x 11-1/2	1-3/4"	44.4
2" x 11-1/2	2-7/32"	56.4
2-1/2 x 8	2-21/32"	67.5
3" x 8	3-9/32"	83.3
3-1/2 x 8	3-25/32"	96
4" x 8	4-9/32"	108.7

STRAIGHT PIPE SIZES - NPS		Metric
TAP SIZE	DRILL SIZE	Equivalents
1/8 x 27	R (Letter)	8.6
1/4 x 18	7/16"	11.1
3/8 x 18	37/64"	14.7
1/2 x 14	23/32"	18.3
3/4 x 14	59/64"	23.4
1" x 11-1/2	1-5/32"	29.4
1-1/4 x 11-1/2	1-1/2"	38.1
1-1/2 x 11-1/2	1-47/64"	44.1
2" x 11-1/2	2-7/32"	56.4
2-1/2 x 8	2-5/8"	66.7
3" x 8	3-1/4"	82.5
3-1/2 x 8	3-3/4"	95.2
4" x 8	4-1/4"	107.9

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Tapping Drill Sizes British Imperial

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BSW		Metric	
TAP SIZE	TPI	Drill size	Equivalents
1/16	60	3/64	1.2
1/8	40	3/32	2.4
5/32	32	1/8	3.2
3/16	24	9/64	3.6
7/32	24	11/64	4.4
1/4	20	13/64	5.2
5/16	18	17/64	6.7
3/8	16	5/16	7.9
7/16	14	3/8	9.5
1/2	12	27/64	10.7
9/16	12	31/64	12.3
5/8	11	17/32	13.5
11/16	11	19/32	15.1
3/4	10	21/32	16.7
7/8	9	49/64	19.4
1	8	7/8	22.2
1 1/8	7	63/64	25.0
1 1/4	7	1 7/64	28.2
1 3/8	6	1 7/32	31.0
1 1/2	6	1 11/32	34.1
1 5/8	5	1 7/16	36.5
1 3/4	5	1 9/16	39.7
2	4.5	1 25/32	45.2

BSF		Metric	
TAP SIZE	TPI	Drill size	Equivalents
3/16	32	5/32	4.0
7/32	28	11/64	4.4
1/4	26	7/32	5.6
5/16	22	17/64	6.7
3/8	20	21/64	8.3
7/16	18	25/64	9.9
1/2	16	7/16	11.1
9/16	16	1/2	12.7
5/8	14	9/16	14.3
11/16	14	39/64	15.5
3/4	12	43/64	17.1
7/8	11	25/32	19.8
1	10	29/32	23.0
1 1/8	9	1 1/64	25.8
1 1/4	9	1 9/64	29.0
1 3/8	8	1 1/4	31.8
1 1/2	8	1 3/8	34.9
1 5/8	8	1 1/2	38.1
1 3/4	7	1 39/64	40.9
2	7	1 55/64	47.2

BSP		Metric	
TAP SIZE	TPI	Drill size	Equivalents
1/8	28	11/32	8.7
1/4	19	15/32	11.9
3/8	19	39/64	15.5
1/2	14	3/4	19.1
5/8	14	53/64	21.0
3/4	14	31/32	24.6
7/8	14	1 1/8	28.6
1	11	1 7/32	31.0
1 1/4	11	1 9/16	39.7
1 1/2	11	1 51/64	45.6
1 3/4	11	2 1/32	51.6
2	11	2 17/64	57.5

BA		Metric
Size	Drill size	Equivalents
0	No. 7	5.1
1	No. 16	4.5
2	5/32	4.0
3	No. 29	3.5
4	No. 32	3.0
5	No. 37	2.6
6	No. 43	2.3
7	No. 46	2.1
8	No. 50	1.8
9	No. 53	1.5
10	No. 54	1.4
11	3/64	1.2
12	No. 59	1.0

BSW British Standard Whitworth
 BSF British Standard Fine
 BSP British Standard Pipe
 BA British Association

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