



RECOMMENDED TAPPING DRILL SIZES

M [metrisch]				MF [metrisch]				UNF				G				NPT			
ø	P [mm]	ø [mm]	ø [mm]	ø	P [mm]	ø [mm]	ø [mm]	UNF	TPI	ø [mm]	ø [mm]	ø	TPI	ø [mm]	ø [mm]	NPT	TPI	ø [mm]	ø [mm]
1.0	0.25	0.75	0.90	27.0	1.50	25.50		5/8	18	14.50	15.30	1/8	28	8.80	9.30	1/16	27	6.30	
1.6	0.35	1.25	1.40	27.0	2.00	25.00		3/4	16	17.50	18.30	1/4	19	11.80	12.50	1/8	27	8.50	
1.8	0.35	1.45	1.65	28.0	1.50	26.50		7/8	14	20.40		3/8	14	15.25	16.00	1/4	18	11.00	
2.0	0.40	1.60	1.80	28.0	2.00	26.00		1	12	23.25		1/2	14	19.00	20.00	3/8	18	14.50	
2.2	0.45	1.75	2.00	30.0	1.50	28.50		1 1/8	12	26.50		5/8	14	21.00	22.00	1/2	14	18.00	
2.5	0.45	2.05	2.30	30.0	2.00	28.00		1 1/4	12	29.50		3/4	14	24.50	25.50	3/4	14	23.00	
3.0	0.50	2.50	2.80	32.0	1.50	30.50		1 3/8	12	32.75		7/8	14	28.25	29.30	1	11.5	29.00	
3.5	0.60	2.90	3.20	32.0	2.00	30.00		1 1/2	12	36.00		1	11	30.75	32.00	1 1/4	11.5	38.00	
4.0	0.70	3.30	3.70	33.0	2.00	31.00						1 1/4	11	39.50		1 1/2	11.5	44.00	
4.5	0.75	3.80	4.15	35.0	1.50	33.50						1 1/2	11	45.00		2	11.5	56.00	
5.0	0.80	4.20	4.60	36.0	1.50	34.50						1 3/4	11	51.00		2 1/2	8	67.00	
6.0	1.00	5.00	5.50	36.0	2.00	34.00						2	11	57.00		3	8	83.00	
7.0	1.00	6.00	6.50	36.0	3.00	33.00						2 1/4	11	63.00					
8.0	1.25	6.80	7.40	38.0	1.50	36.5						2 1/2	11	72.50					
9.0	1.25	7.80	8.40	39.0	2.00	36.00						2 3/4	11	79.00					
10.0	1.50	8.50	9.30	40.0	1.50	38.50						3	11	85.50					
11.0	1.50	9.50	10.30	40.0	2.00	38.00													
12.0	1.75	10.30	11.20	40.0	3.00	37.00													
14.0	2.00	12.00	13.00	42.0	1.50	40.50													
16.0	2.00	14.00	15.00	42.0	2.00	40.00													
18.0	2.50	15.50	16.80	42.0	3.00	39.00													
20.0	2.50	17.50	18.90	45.0	1.50	43.50													
22.0	2.50	19.50	20.80	45.0	2.00	43.00													
24.0	3.00	21.00	22.70	45.0	3.00	42.00													
27.0	3.00	24.00		48.0	1.50	46.50													
30.0	3.50	26.50		48.0	2.00	46.00													
33.0	3.50	29.50		48.0	3.00	45.00													
36.0	4.00	32.00		50.0	1.50	48.50													
39.0	4.00	35.00		50.0	2.00	48.00													
42.0	4.50	37.50		50.0	3.00	47.00													
45.0	4.50	40.50																	
48.0	5.00	43.00																	
52.0	5.00	47.00																	
56.0	5.50	50.50																	
64.0	6.00	58.00																	

UNC				BSW			
UNC	TPI	ø [mm]	ø [mm]	BSW	TPI	ø [mm]	ø [mm]
No.2	56	1.85	2.00	3/32	48	1.85	2.10
No.3	48	2.10	2.30	7/8	40	2.55	2.90
No.4	40	2.35	2.60	5/32	32	3.20	3.60
No.5	40	2.65	2.90	3/16	24	3.70	4.30
No.6	32	2.85	3.20	7/32	24	4.50	
No.8	32	3.50	3.80	1/4	20	5.10	5.80
No.10	24	3.90	4.40	5/16	18	6.50	7.30
No.12	24	4.50	5.00	3/8	16	7.90	8.80
1/4	20	5.10	5.80	7/16	14	9.40	10.30
5/16	18	6.60	7.30	1/2	13	10.80	11.90
3/8	16	8.00	8.80	5/8	12	12.20	
7/16	14	9.40	10.30	9/16	12	12.20	
1/2	13	10.80	11.90	5/8	11	13.50	14.80
5/8	11	13.50	14.80	3/4	10	16.50	17.70
3/4	10	16.50	17.70	7/8	9	19.25	
7/8	9	19.25		1	8	22.25	24.00
1	8	22.25	24.00	1 1/8	7	24.75	
1 1/8	7	25.00		1 1/4	7	28.00	
1 1/4	7	28.00		1 3/8	6	30.75	
1 3/8	6	30.75		1 1/2	6	33.50	
1 1/2	6	33.50		1 5/8	5	35.50	
1 5/8	5	35.50		1 3/4	4	39.00	
1 3/4	4	39.00		1 7/8	4	41.50	
1 7/8	4	41.50		2	4.5	45.00	
2	4.5	45.00					

BSF				BA			
BSF	TPI	ø [mm]	ø [mm]	BA	TPI	ø [mm]	ø [mm]
3/16	32	4		10	0.35	1.30	
7/32	28	4.5		8	0.43	1.80	
1/4	26	5.3		6	0.53	2.30	
9/32	26	6		5	0.59	2.65	
5/16	22	6.8		4	0.66	3.00	
3/8	20	8.3		3	0.73	3.40	
7/16	18	9.7		2	0.81	4.00	
1/2	16	11		1	0.90	4.50	
5/8	16	12.7		0	1.00	5.10	
3/4	14	14					
1 1/16	14	15.5					
3/4	12	17					
1 1/8	9	25.5					
1 1/4	9	28.5					
1 3/8	8	31.5					
1 1/2	8	34.5					
1 5/8	8	37.5					

EGM				Rc				BA			
M	P [mm]	ø [mm]	ø [mm]	Rc	TPI	ø [mm]	ø [mm]	BA	TPI	ø [mm]	ø [mm]
2.5	0.45	2.60		1/8	28	8.40		10	0.35	1.30	
3	0.50	3.20		1/4	19	11.20		8	0.43	1.80	
3.5	0.60	3.70		3/8	19	14.75		6	0.53	2.30	
4	0.70	4.20		1/2	14	18.25		5	0.59	2.65	
5	0.80	5.20		5/8	14	20.25		4	0.66	3.00	
6	1.00	6.30		3/4	14	23.75		3	0.73	3.40	
8	1.25	8.40		7/8	14	27.50		2	0.81	4.00	
10	1.50	10.50		1	11	30.00		1	0.90	4.50	
12	1.75	12.50		1 1/8	9	25.5		0	1.00	5.10	
14	2.00	14.50		1 1/4	9	28.5					
16	2.00	16.50		1 3/8	8	31.5					
18	2.50	18.75		1 1/2	8	34.5					
20	2.50	20.75		1 5/8	8	37.5					
22	2.50	22.75									
24	3.00	24.75									

EG				Rc				BA			
M	P [mm]	ø [mm]	ø [mm]	Rc	TPI	ø [mm]	ø [mm]	BA	TPI	ø [mm]	ø [mm]
2.5	0.45	2.60		1/8	28	8.40		10	0.35	1.30	
3	0.50	3.20		1/4	19	11.20		8	0.43	1.80	
3.5	0.60	3.70		3/8	19	14.75		6	0.53	2.30	
4	0.70	4.20		1/2	14	18.25		5	0.59	2.65	
5	0.80	5.20		5/8	14	20.25		4	0.66	3.00	
6	1.00	6.30		3/4	14	23.75		3	0.73	3.40	
8	1.25	8.40		7/8	14	27.50		2	0.81	4.00	
10	1.50	10.50		1	11	30.00		1	0.90	4.50	
12	1.75	12.50		1 1/8	9	25.5		0	1.00	5.10	
14	2.00	14.50		1 1/4	9	28.5					
16	2.00	16.50		1 3/8	8	31.5					
18	2.50	18.75		1 1/2	8	34.5					
20	2.50	20.75		1 5/8	8	37.5					
22	2.50	22.75									
24	3.00	24.75									

NPTF				NPSF				NPSM				PG			
NPTF	TPI	ø [mm]	ø [mm]	NPSF	TPI	ø [mm]	ø [mm]	npsM	TPI	ø [mm]	ø [mm]	PG	TPI	ø [mm]	ø [mm]
1/16	27	6.30		1/8	27	8.70		1/8	27	9.10		7	20	11.40	
1/8	27	8.50		1/4	18	11.30		1/4	18	12.00		9	18	13.90	
1/4	18	11.00		3/8	18	14.75		1/2	14	15.50		11	18	17.50	
3/8	18	14.50		1/2	14	18.25		3/4	14	19.00		13.5	18	19.00	
1/2	14	18.00		3/4	14	23.50		1	11.5	30.50		16	18	21.25	
3/4	14	23.00		1	11.5	29.50		1 1/4	11.5	39.50		21	16	27.00	
1	11.5	29.00						1 1/2	11.5	45.50		29	16	35.50	
1 1/4	11.5	38.00						1 3/8	8	31.5		36	16	45.50	
1 1/2	11.5	44.00						1 1/2	8	34.5		42	16	52.50	
2	8	67.00													