

THREAD CHART

METRIC COARSE THREAD			METRIC FINE THREAD			U.N.F.			B.S.F.		
Nominal Dia. mm	Pitch mm	Tapping Drill Size* mm	Nominal Dia. mm	Pitch mm	Tapping Drill Size* mm	Nominal Diameter	Pitch T.P.I.	Tapping Drill Size mm	Nominal Diameter	Pitch T.P.I.	Tapping Drill Size mm
2.0	0.40	1.60	2.0	0.25	1.75				3/16"	32	4.00
2.2	0.45	1.75	2.2	0.25	1.95	No. 0 (0.060")	80	1.25	7/32"	28	4.60
2.5	0.45	2.05	2.5	0.35	2.15	No. 1 (0.073")	72	1.55	1/4"	28	5.30
3.0	0.50	2.50	3.0	0.35	2.65	No. 2 (0.086")	64	1.90	9/32"	28	6.10
3.5	0.60	2.90	3.5	0.35	3.15	No. 3 (0.099")	56	2.15	5/16"	22	6.80
4.0	0.70	3.30	4.0	0.50	3.60	No. 4 (0.112")	48	2.40	3/8"	20	8.30
4.5	0.75	3.70	4.5	0.50	4.00	No. 5 (0.125")	44	2.70	7/16"	18	9.70
5.0	0.80	4.20	5.0	0.50	4.50	No. 6 (0.138")	40	2.95	1/2"	16	11.50
6.0	1.00	5.00	6.0	0.75	5.20	No. 8 (0.164")	36	3.50	5/16"	16	12.70
7.0	1.00	6.00	7.0	0.75	6.20	No. 10 (0.190")	32	4.10	5/8"	14	14.00
8.0	1.25	6.80	8.0	1.00	7.00	No. 12 (0.216")	28	4.70	1 1/16"	14	15.50
9.0	1.25	7.80	10.0	0.75	9.20	1/4"	28	5.60	3/4"	12	16.75
10.0	1.50	8.50	10.0	1.00	9.00	5/16"	24	6.60	7/8"	11	19.75
11.0	1.50	9.50	10.0	1.25	8.00	3/8"	24	8.60	1"	10	22.75
12.0	1.75	10.20	12.0	1.00	11.00	7/16"	20	9.60	1 1/8"	9	25.50
14.0	2.00	12.00	12.0	1.25	10.00	1/2"	20	11.50	1 1/4"	8	28.50
16.0	2.00	14.00	12.0	1.50	10.50	9/16"	18	12.90	1 3/8"	8	31.50
18.0	2.50	15.50	14.0	1.25	12.00	5/8"	18	14.60	1 1/2"	8	34.50
20.0	2.50	17.50	14.0	1.50	12.50	3/4"	16	17.50	1 5/8"	8	38.00
22.0	2.50	19.50	16.0	1.00	15.00	7/8"	14	20.40	1 3/4"	7	40.50
24.0	3.00	21.00	16.0	1.50	14.50	1"	12	23.25	2"	7	47.00
27.0	3.00	24.00	18.0	1.50	16.50	1 1/8"	12	26.50	2 1/4"	6	53.00
30.0	3.50	26.50	20.0	1.00	18.00	1 1/4"	12	29.50	2 1/2"	6	59.00
33.0	3.50	29.50	20.0	1.50	18.50	1 3/8"	12	32.75	2 3/4"	6	65.00
36.0	4.00	32.00	20.0	2.00	18.00	1 1/2"	12	36.00	3"	5	71.00
39.0	4.00	35.00	22.0	1.90	20.00						
42.0	4.50	37.50	24.0	2.00	22.00						
45.0	4.50	40.50	26.0	1.80	23.50						
48.0	5.00	43.00	27.0	2.00	25.00						
52.0	5.00	47.00	30.0	2.00	28.00						
56.0	5.50	50.50	32.0	1.50	30.50						
60.0	5.50	54.50	33.0	2.00	31.00						
			36.0	3.00	33.00						
			39.0	3.00	36.00						

U.N.C.			B.S.W.			B.S.P.		
Nominal Diameter	Pitch T.P.I.	Tapping Drill Size mm	Nominal Diameter	Pitch T.P.I.	Tapping Drill Size mm	Nominal Diameter	Pitch T.P.I.	Tapping Drill Size mm
No. 1 (0.073")	64	1.55	1/8"	40	2.65	1/8"	28	8.80
No. 2 (0.086")	56	1.85	3/16"	24	3.70	1/4"	19	11.80
No. 3 (0.099")	48	2.10	1/4"	20	5.10	3/8"	19	15.25
No. 4 (0.112")	40	2.35	5/16"	18	6.50	1/2"	14	19.00
No. 5 (0.125")	40	2.65	3/8"	16	7.90	5/8"	14	21.00
No. 6 (0.138")	32	2.85	7/16"	14	9.30	3/4"	14	24.50
No. 8 (0.164")	32	3.50	1/2"	12	10.50	7/8"	14	28.25
No. 10 (0.190")	24	3.90	9/16"	12	12.10	1"	11	30.75
No. 12 (0.216")	24	4.50	5/8"	11	13.50	1 1/4"	11	39.50
1/4"	20	5.10	11/16"	11	15.00	1 1/2"	11	45.00
5/16"	18	6.60	3/4"	10	16.25	1 3/4"	11	51.00
3/8"	16	8.00	7/8"	9	19.25	2"	11	57.00
7/16"	14	9.40	1"	8	22.00			
1/2"	13	10.80	1 1/8"	7	24.75			
9/16"	12	12.20	1 1/4"	7	28.00			
5/8"	11	13.50	1 1/2"	6	33.50			
3/4"	10	16.50	1 3/4"	5	39.00			
7/8"	9	19.50	2"	4 1/2	44.50			
1"	8	22.25	2 1/4"	4	51.00			
1 1/8"	7	25.00	2 1/2"	4	57.00			
1 1/4"	7	28.00	2 3/4"	3 1/2	62.00			
1 3/8"	6	30.75	3"	3 1/2	69.00			
1 1/2"	6	34.00						
1 3/4"	5	39.50						
2"	4 1/2	45.00						

B.A.		
Size	Pitch mm	Tapping Drill Size mm
No. 0	1.00	5.10
No. 1	0.90	4.50
No. 2	0.81	4.00
No. 3	0.73	3.40
No. 4	0.66	3.00
No. 5	0.59	2.65
No. 6	0.53	2.30
No. 7	0.48	2.05
No. 8	0.43	1.80
No. 9	0.39	1.55
No. 10	0.35	1.40
No. 11	0.31	1.20
No. 12	0.28	1.05
No. 13	0.25	0.98
No. 14	0.23	0.80