



TAPPING DRILL SIZES



Metric Coarse			Metric Fine						Imperial Sizes		B.S.W.		B.S.F.		U.N.C.		U.N.F.		U.N.E.F.		G (BSP)		Rc (BSPT)		N.P.S.		N.P.T.		Brass		British Association									
Nominal Diam. & Pitch			Drill Diam.		Nominal Diam. & Pitch		Drill Diam.		Nominal Diam. & Pitch		Drill Diam.		Diam (INCH)		Metric Equiv.		TPI		Drill Diam.		TPI		Drill Diam.		TPI		Drill Diam.		TPI		Drill Diam.		No.		Major Diam.		TPI		Drill Diam.	
M 1	0.25	0.75	M 2.5	0.35	2.15	M 24	1	23	1/16	1.587	60	1.15																				16	0.0311	133.3	0.6					
M 1.1	0.25	0.85	M 3	0.35	2.65	M 24	1.5	22.5	3/32	2.381	48	1.8																				15	0.0354	120.5	0.7					
M 1.2	0.25	0.95	M 3.5	0.35	3.15	M 24	2	22	1/8	3.175	40	2.6																				14	0.0394	109.9	0.75					
M 1.4	0.3	1.1	M 4	0.5	3.5	M 25	1	24	5/32	3.968	32	3.1																				13	0.0472	102	0.95					
M 1.6	0.35	1.25	M 4.5	0.5	4	M 25	1.5	23.5	3/16	4.762	24	3.6	32	4																		12	0.0512	90.9	1					
M 1.8	0.35	1.45	M 5	0.5	4.5	M 25	2	23	7/32	5.556	24	4.4	28	4.7																		11	0.0591	81.9	1.2					
M 2	0.4	1.6	M 5.5	0.5	5	M 27	1	26	1/4	6.350	20	5.1	26	5.4	20	5.1	28	5.5	32	5.5	19	11.8	19	11.5	18	11.5	18	11	26	5.4	10	0.0669	72.6	1.3						
M 2.2	0.45	1.75	M 6	0.75	5.25	M 27	1.5	25.5	9/32	7.143	20	5.8	26	6.2																		9	0.0748	65.1	1.5					
M 2.5	0.45	2.05	M 7	0.75	6.25	M 27	2	25	5/16	7.937	18	6.5	22	6.8	18	6.6	24	6.9	32	7.1											26	6.9	8	0.0866	59.1	1.8				
M 3	0.5	2.5	M 8	0.75	7.25	M 28	1	27	3/8	9.525	16	7.9	20	8.3	16	8	24	8.5	32	8.6	19	15.25	19	15	18	15	18	14.5	26	8.4	7	0.0984	52.9	2						
M 3.5	0.6	2.9	M 8	1	7	M 28	1.5	26.5	7/16	11.112	14	9.3	18	9.8	14	9.4	20	9.9	28	10.1										26	10	6	0.1102	47.9	2.3					
M 4	0.7	3.3	M 9	0.75	8.25	M 28	2	26	1/2	12.700	12	10.5	16	11.2	13	10.8	20	11.5	28	11.7	14	19	14	18.5	14	18.5	14	18	26	11.5	5	0.1260	43	2.7						
M 4.5	0.75	3.7	M 9	1	8	M 30	1	29	9/16	14.288	12	12	16	12.7	12	12.2	18	12.9	24	13										26	13	4	0.1417	38.5	3					
M 5	0.8	4.2	M 10	0.75	9.25	M 30	1.5	28.5	5/8	15.875	11	13.5	14	14	11	13.5	18	14.5	24	14.75	14	21								26	14.7	3	0.1614	34.8	3.5					
M 6	1	5	M 10	1	9	M 30	2	28	11/16	17.462	11	15	14	15.75					24	16.25												2	0.1850	31.4	4					
M 7	1	6	M 10	1.25	8.75	M 30	3	27	3/4	19.050	10	16.5	12	17	10	16.5	16	17.5	20	17.5	14	24.5	14	24	14	24	14	23	26	17.8	1	0.2087	28.2	4.5						
M 8	1.25	6.75	M 11	0.75	10.25	M 32	1.5	30.5	13/16	20.638	10	18	12	18.5					20	19.25												0	0.2362	25.4	5.1					
M 9	1.25	7.75	M 11	1	10	M 32	2	30	7/8	22.225	9	19.25	11	20	9	19.5	14	20.4	20	20.75	14	28.25							26	21	NC – NATIONAL COARSE									
M 10	1.5	8.5	M 12	1	11	M 33	1.5	31.5	15/16	23.812	9	20.75	11	21.75					20	22.25											No.	Major Diam.	TPI	Drill Diam.						
M 11	1.5	9.5	M 12	1.25	10.75	M 33	2	31	1"	25.400	8	22	10	23	8	22.25	12	23.25	20	23.75	11	30.75	11	30.25	11.5	30	11.5	29	26	24.2	1	0.073	64	1.55						
M 12	1.75	10.2	M 12	1.5	10.5	M 33	3	30	1.1/8	28.575	7	24.75	9	26	7	25	12	26.5	18	26.75	11	35.5									2	0.086	56	1.85						
M 14	2	12	M 14	1	13	M 35	1.5	33.5	1.1/4	31.750	7	27.75	9	29	7	28	12	29.5	18	30	11	39.5	11	39	11.5	39	11.5	38			3	0.099	48	2.10						
M 16	2	14	M 14	1.25	12.75	M 36	1.5	34.5	1.3/8	34.925	6	30.5	8	32	6	30.75	12	32.75	18	33	11	42									4	0.112	40	2.35						
M 18	2.5	15.5	M 14	1.5	12.5	M 36	2	34	1.1/2	38.100	6	33.5	8	35	6	34	12	36	18	36	11	45	11	45	11.5	45	11.5	44			5	0.125	40	2.65						
M 20	2.5	17.5	M 15	1	14	M 36	3	33	1.5/8	41.275	5	35.5	8	37.5							11	49.6									6	0.138	32	2.85						
M 22	2.5	19.5	M 15	1.5	13.5	M 38	1.5	36.5	1.3/4	44.450	5	39	7	40	5	39.5					11	51									8	0.164	32	3.50						
M 24	3	21	M 16	1	15	M 39	1.5	37.5	1.7/8	47.625	4.5	41.5	7	43																	10	0.190	24	3.90						
M 27	3	24	M 16	1.5	14.5	M 39	2	37	2"	50.800	4.5	44.5	7	46.5	4.5	45					11	57	11	56.5	11.5	57	11.5	56			12	0.216	24	4.50						
M 30	3.5	26.5	M 17	1	16	M 39	3	36	2.1/4	57.150	4	50	6	52	4.5	51.5					11	63.3									NF – NATIONAL FINE									
M 33	3.5	29.5	M 17	1.5	15.5	M 40	1.5	38.5	2.1/2	63.500	4	56.5	6	58.5	4	57.25					11	72.8	11	71.4	8	68	8	67			No.	Major Diam.	TPI	Drill Diam.						
M 36	4	32	M 18	1	17	M 40	2	38	2.3/4	69.850	3.5	62	6	64.5	4	63.5					11	79.1									0	0.060	80	1.25						
M 39	4	35	M 18	1.5	16.5	M 40	3	37	3"	76.200	3.5	68.5	5	69.75	4	70					11	85.5			8	84	8	83			1	0.073	72	1.55						
M 42	4.5	37.5	M 18	2	16	M 42	1.5	40.5																							2	0.086	64	1.90						
M 45	4.5	40.5	M 20	1	19	M 42	2	40	NOTES: a. Please note all tapping drill sizes are in millimetres. b. Tapping drill sizes of other thread forms are displayed in FEW Technical Catalogue. c. Pipe thread nominal diameters do not represent actual size of tap. d. When tapping with taper pipe taps use a taper reamer if available. e. 1/4 Inch brass is identical to 1/4 inch BSF. f. Blank sizes for external threads can be found in the FEW Technical Catalogue																										3	0.099	56	2.15		
M 48	5	43	M 20	1.5	18.5	M 42	3	39																											4	0.112	48	2.40		
M 52	5	47	M 20	2	18	M 42	4	38																											5	0.125	44	2.70		
M 56	5.5	50.5	M 22	1	21	M 45	1.5	43.5																											6	0.138	40	2.95		
			M 22	1.5	20.5	M 45	2	43																											8	0.164	36	3.50		
			M 22	2	20	M 45	3	42																											10	0.190	32	4.10		
						M 45	4	41																											12	0.216	28	4.70		