

TAPPING SIZES

Metric Coarse

Size	Pitch	Tap drill
mm	mm	mm
1.0	0.25	0.75
1.1	0.25	0.85
1.2	0.25	0.95
1.4	0.30	1.10
1.6	0.35	1.25
1.8	0.35	1.45
2.0	0.40	1.60
2.2	0.45	1.75
2.5	0.45	2.05
3.0	0.50	2.50
3.5	0.60	2.90
4.0	0.70	3.30
4.5	0.75	3.70
5.0	0.80	4.20
6.0	1.00	5.00
7.0	1.00	6.00
8.0	1.25	6.80
9.0	1.25	7.80
10.0	1.50	8.50
11.0	1.50	9.50
12.0	1.75	10.20
14.0	2.00	12.00
16.0	2.00	14.00
18.0	2.50	15.50
20.0	2.50	17.50
22.0	2.50	19.50
24.0	3.00	21.00
27.0	3.00	24.00
30.0	3.50	26.50
33.0	3.50	29.50
36.0	4.00	32.00
39.0	4.00	35.00
42.0	4.50	37.50
45.0	4.50	40.50
48.0	5.00	43.00
52.0	5.00	47.00
56.0	5.50	50.50
60.0	5.50	54.50
64.0	6.00	58.00
68.0	6.00	62.00
72.0	6.00	66.00
76.00	6.00	70.00

Bugatti

Size	Pitch	Tap drill
mm	mm	mm
4.0	0.75	3.25
5.0	0.75	4.25
6.0	1.00	5.00
7.0	1.00	6.00
8.0	1.25	6.75
9.0	1.00	8.00
9.0	1.25	7.75
10.0	1.00	9.00
10.0	1.50	8.50
11.0	1.25	9.75
12.0	1.25	10.75
12.0	1.50	10.50
14.0	1.25	12.75
14.0	1.50	12.50
15.0	1.50	13.50
16.0	1.25	14.75
18.0	1.50	16.50
20.0	1.50	18.50
22.0	1.50	20.50
30.0	1.50	28.50

Wood screw

Gauge	Size	
"	mm	
2	0.0820	2.08
3	0.0940	2.39
4	0.1080	2.74
5	0.1220	3.10
6	0.1360	3.45
7	0.1500	3.81
8	0.1640	4.17
9	0.1780	4.52
10	0.1920	4.88
12	0.2200	5.59
14	0.2480	6.30
16	0.2760	7.01
18	0.3040	7.72
20	0.3320	8.43

SWG Thickness

Gauge	Size	
"	mm	
1swg	0.3000	7.62
2swg	0.2760	7.01
3swg	0.2520	6.40
4swg	0.2320	5.89
6swg	0.1920	4.88
8swg	0.1600	4.06
10swg	0.1280	3.25
12swg	0.1040	2.64
13swg	0.0920	2.34
14swg	0.0800	2.03
16swg	0.0640	1.63
18swg	0.0480	1.22
20swg	0.0380	0.97
22swg	0.0280	0.71
24swg	0.0220	0.56
26swg	0.0180	0.46
28swg	0.0148	0.38
29swg	0.0136	0.35
30swg	0.0124	0.32

Metric Fine

Size	Pitch	Tap drill
mm	mm	mm
2	0.25	1.75
2.2	0.25	1.95
2.3	0.25	2.05
2.5	0.35	2.15
2.6	0.35	2.25
3	0.35	2.65
3.5	0.35	3.15
4	0.35	3.65
4	0.50	3.50
5	0.35	4.65
5	0.50	4.50
5	0.75	4.25
5.5	0.50	5.00
6	0.50	5.50
6	0.75	5.25
7	0.75	6.25
8	0.50	7.25
8	0.75	7.50
8	1.00	7.00
9	0.75	8.25
9	1.00	8.00
10	0.50	9.50
10	0.75	9.25
10	1.00	9.00
10	1.25	8.75
11	0.75	10.25
11	1.00	10.00
11	1.25	9.75
12	0.50	11.50
12	0.75	11.25
12	1.00	11.00
12	1.25	10.75
12	1.50	10.50
14	1.00	13.00
14	1.25	12.75
14	1.50	12.50
15	0.75	14.25
15	1.00	14.00
15	1.50	13.50
16	0.50	15.50
16	0.75	15.25
16	1.00	15.00
16	1.25	14.75
16	1.50	14.50
17	1.00	16.00
17	1.50	15.50
18	0.75	17.25
18	1.00	17.00
18	1.25	16.75
18	1.50	16.50
18	2.00	16.00
19	1.00	18.00
20	1.00	19.00
20	1.50	18.50
20	2.00	18.00
22	1.00	21.00
22	1.50	20.50
22	2.00	20.00
24	1.00	23.00
24	1.50	22.50
24	2.00	22.00
25	1.00	24.00
25	1.50	23.50
25	2.00	23.00
27	1.00	26.00
27	1.50	25.50
27	2.00	25.00
28	1.00	27.00
28	1.50	26.50
28	2.00	26.00
30	1.00	29.00
30	1.50	28.50
30	2.00	28.00
30	3.00	27.00
32	1.00	31.00
32	1.50	30.50
32	2.00	30.00
33	1.50	31.50
33	2.00	31.00
33	3.00	30.00
35	1.50	33.50
35	2.00	33.00
35	3.00	32.00
36	1.50	35.00
36	2.00	34.00
36	3.00	33.00
38	1.50	37.00
38	2.00	36.50
38	3.00	36.00
39	1.50	37.50
39	2.00	37.00
39	3.00	36.00
40	1.00	39.00
40	1.50	38.50
40	3.00	37.00
42	1.50	40.50
42	2.00	40.00
42	3.00	39.00
42	4.00	38.00
45	1.50	43.50
45	2.00	43.00
45	3.00	42.00
48	1.50	46.50
48	2.00	46.00
48	3.00	45.00
48	4.00	44.00

UNC

Size	Pitch	Tap drill
"	TPI	L/N/F mm
(1)	64	0.0551 54 1.40
(2)	56	0.0669 51 1.70
(3)	48	0.0787 47 2.00
(4)	40	0.0866 44 2.20
(5)	40	0.0984 40 2.50
(6)	32	0.1102 35 2.80
(8)	32	0.1339 29 3.40
(10)	24	0.1457 24 3.70
(12)	24	0.1732 16 4.40
1/4	20	0.2047 7 5.20
1/3	18	0.2559 F 6.50
3/8	16	0.3110 5/16 7.90
1/2	14	0.3661 U 9.30
9/16	13	0.4213 27/64 10.70
4/7	12	0.4764 31/64 12.10
5/8	11	0.5307 17/32 13.49
3/4	10	0.6496 21/32 16.50
7/8	9	0.7657 49/64 19.45
1	8	0.8760 7/8 22.25
1 1/8	7	0.9844 63/64 25.00
1 1/4	7	1.1094 1 - 7/64 28.18
1 3/8	6	1.2106 1 - 7/32 30.75
1 1/2	6	1.3281 1 - 21/64 33.80
1 3/4	5	1.5469 1 - 35/64 39.30
2	4.5	1.7812 1 - 25/32 45.30
2 1/4	4.5	2.0276 2 - 1/32 51.50
2 1/2	4	2.2441 2 - 1/4 57.00
2 3/4	4	2.5000 2 - 1/2 63.50
3	4	2.7560 2 - 3/4 70.00
3 1/4	4	3.0118 3 76.50
3 1/2	4	3.2677 3 - 1/4 83.00
3 3/4	4	3.5040 3 - 1/2 89.00
4	4	3.7598 3 - 3/4 95.50

BSC (cycle)

Size	Pitch	Tap drill
"	TPI	L/N/F mm
17 swg	56	0.0390 57 1
17 swg	62	0.0420 61 1.1
16 swg	56	0.0390 61 1
16 swg	62	0.0469 3/64 1.2
15 swg	56	0.0550 54 1.4
15 swg	62	0.0625 1/16 1.6
14 swg	56	0.0630 1/16 1.6
14 swg	62	0.0630 52 1.6
13 swg	56	0.0748 48 1.9
12 swg	44	0.0810 46 2.1
11 swg	44	0.0960 41 2.5
1/8	40	0.0995 39 2.5
10 swg	44	0.1063 36 2.7
9 swg	40	0.1160 32 3
5/32	32	0.1285 30 3.2
8 swg	40	0.1360 29 3.5
7 swg	32	0.1440 27 3.7
3/16	32	0.1562 5/32 4
7/32	26	0.1800 15 4.6
1/4	26	0.2130 3 5.4
17/64	26	0.2280 1 5.8
9/32	26	0.2420 C 6.2
5/16	26	0.2750 J 7
3/8	26	0.3390 R 8.6
7/16	26	0.3970 X 10.1
7/16	20	0.3860 W 9.8
1/2	26	0.4688 15/32 11.7
1/2	20	0.4528 29/64 11.5
9/16	26	0.5313 17/32 13.3
9/16	20	0.5118 33/64 13
5/8	26	0.5905 19/32 15
5/8	20	0.5780 37/64 14.6
11/16	26	0.6496 21/32 16.5
11/16	20	0.6406 41/64 16.2
3/4	26	0.7120 23/32 18.1
3/4	20	0.7031 45/64 17.7
7/8	24	0.8370 27/32 21.1
31/32	20	0.9370 15/16 23.8
1 inch	24	0.9688 31/32 24.3
1 inch	26	0.9688 31/32 24.4
1 1/8	26	1.0937 1 - 3/32 27.6
1 1/8	24	1.2500 1 - 1/4 31.7
1 3/8	24	1.3281 1 - 21/64 33.7
1 3/8	26	1.4218 1 - 27/64 35.8
1 1/2	26	1.4218 1 - 27/64 35.8
1 9/16	24	1.5312 1 - 17/32 38.6
1 5/8	24	1.5937 1 - 19/32 38.4

BA

Size	Pitch	Tap drill
No.	mm	mm
0	6.00	1.00 5.10
1	5.30	0.90 4.50
2	4.70	0.81 4.00
3	4.10	0.73 3.50
4	3.60	0.66 3.00
5	3.20	0.59 2.70
6	2.80	0.53 2.35
7	2.50	0.48 2.10
8	2.20	0.43 1.80
9	1.90	0.39 1.50
10	1.70	0.35 1.40
11	1.50	0.31 1.20
12	1.30	0.28 1.05
13	1.20	0.25 0.95
14	1.00	0.23 0.80
15	0.90	0.21 0.70
16	0.79	0.19 0.60

UNF

Size	Pitch	Tap drill
"	TPI	L/N/F mm
(0)	80	0.0492 51 1.25
(1)	72	0.0630 52 1.60
(2)	64	0.0748 48 1.90
(3)	56	0.0846 44 2.15
(4)	48	0.0945 37/32 2.40
(5)	44	0.1063 36 2.70
(6)	40	0.1160 32 2.95
(8)	36	0.1398 28 3.55
(10)	32	0.1590 21 4.10
(12)	28	0.1831 13 4.65
1/4	28	0.2165 7/32 5.50
5/16	24	0.2717 I 6.90
3/8	24	0.3346 Q 8.50
7/16	20	0.3898 25/64 9.90
1/2	20	0.4488 29/64 11.40
9/16	18	0.5079 33/64 12.90
5/8	18	0.5709 37/64 14.50
3/4	16	0.6874 11/16 17.46
7/8	14	0.8071 13/16 20.50
1	12	0.9154 59/64 23.25
11/8	12	1.0433 26.50
1 1/4	12	1.1614 29.50
1 3/8	12	1.2900 32.80
1 1/2	12	1.4173 36.00
1 3/4	12	1.6732 42.50
2	12	1.9212 48.80
2 1/4	12	2.1732 55.20
2 1/2	12	2.4212 61.50
2 3/4	12	2.6732 67.90
3	12	2.9212 74.20

UNEF (extra fine)

Size	Pitch	Tap drill
"	TPI	L/N/F mm
12	32	0.1890 4.80
1/4	32	0.2244 5.70
5/16	32	