



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
76.0	6.00	70.00

Wood screw		
Gauge	Size	
	mm	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	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

AWG (American) Thickness		
Gauge	Size	
	mm	mm
1awg	0.2893	7.35
2awg	0.2576	6.54
3awg	0.2294	5.83
4awg	0.2043	5.19
5awg	0.1819	4.62
6awg	0.1620	4.12
7awg	0.1443	3.67
8awg	0.1285	3.26
9awg	0.1144	2.91
10awg	0.1019	2.59
11awg	0.0907	2.31
12awg	0.0808	2.05
13awg	0.0720	1.83
14awg	0.0641	1.63
15awg	0.0571	1.45
16awg	0.0508	1.29
17awg	0.0453	1.15
18awg	0.0403	1.02
19awg	0.0359	0.91
20awg	0.032	0.81

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	7.50
8	0.75	7.25
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	0.75	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

BSC (cycle)				
Size	Pitch	Tap drill		
"	TPI	"	L/N/F	mm
17 swg	56	0.0390	61	1
17 swg	62	0.0420	57	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	30	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
1.29 lh	24	1.2500	1 - 1/4	31.7
1 3/8	24	1.3281	1 - 21/64	33.7
1 3/8 lh	24	1.3281	1 - 21/64	33.7
1.45	26	1.4218	1 - 27/64	35.8
1.45 lh	26	1.4218	1 - 27/64	35.8
1 9/16 lh	24	1.5312	1 - 17/32	38.6
1 5/8	24	1.5937	1 - 19/32	38.4

Bugatti			
Size	Pitch	Tap drill	
mm	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	

BSW				
Size	Pitch	Tap drill		
"	TPI	"	L/N/F	mm
1/16	60	0.0465	56	1.10
3/32	48	0.07	50	1.80
1/8	40	0.0984	40	2.50
5/32	32	0.12	31	3.10
3/16	24	0.1457	27	3.70
7/32	24	0.173	17	4.40
1/4	20	0.2008	8	5.10
5/16	18	0.2559	E	6.50
3/8	16	0.3125	5/16	8.00
7/16	14	0.3622	23/64	9.20
1/2	12	0.4134	Z	10.50
9/16	12	0.4764	31/64	12.10
5/8	11	0.5315	17/32	13.50
11/16	11	0.5938	19/32	15.00
3/4	10	0.6406	41/64	16.30
13/16	10	0.7126	23/32	18.10
7/8	9	0.75	3/4	19.30
15/16	9	0.8281	53/64	21.00
1	8	0.8661	55/64	22.00
1 1/8	7	0.9744	31/32	24.80
1 1/4	7	1.0938	1 - 3/32	27.50
1 3/8	6	1.1875	1 - 3/8	30.00
1 1/2	6	1.3189	1 - 5/16	33.50
1 5/8	5	1.375	1 - 3/8	35.00
1 3/4	5	1.5354	1 - 17/32	39.00
1 7/8	4.5	1.625	1 - 5/8	41.00
2	4.5	1.752	1 - 3/4	44.50
2 1/4	4	1.9685		50.00
2 1/2	4	2.2047		56.00
2 3/4	3.5	2.4213		61.50
3	3.5	2.6772		68.00
3 1/4	3.25	2.9035		73.75
3 1/2	3.25	3.1496		80.00
3 3/4	3	3.3661		85.50

BSP (pipe)				
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	0.2854		7.25
3/8	32	0.3484		8.85
7/16	28	0.4075		10.35
1/2	28	0.4646		11.80
9/16	24	0.5276		13.40
5/8	24	0.5906		15.00
11/16	24	0.6535		16.60
3/4	20	0.7087		18.00
13/16	20	0.7717		19.60
7/8	20	0.8327		21.15
15/16	20	0.8937		22.70
1	20	0.9567		24.30
1 1/16	18	1.0157		25.80
1 1/8	18	1.0768		27.35
1 1/4	18	1.2028		