

# TAPPING DRILL SIZES

## IMPERIAL THREADS

Tap Size	B.S Whit	U.N.F	U.N.C	B.S.F	B.S.P	B.A	
	Drill Size	Drill Size	Drill Size	Drill Size	Drill Size	Tap Size	Drill Size
1/16	1.1mm					0	5.1mm
3/32	1.8mm						
1/8	2.5mm				11/32	1	4.5mm
5/32	2.9mm		1/8				
3/16	3.7mm			5/32		2	5/32
7/32	4.2mm		4.4mm				
1/4	13/64	7/32	13/64	5.3mm	15/32	3	3.4mm
5/16	1/4	1	6.5mm	17/64		4	3.0mm
3/8	5/16	21/64	5/16	21/64	19/32	5	2.6mm
7/16	23/64	25/64	9.3mm	3/8		6	2.3mm
1/2	13/32	29/64	27/64	7/16	3/4	7	2.0mm
9/16	15/32	33/64	31/64	1/2		8	1.8mm
5/8	17/32	37/64	17/32	35/64	53/64	9	1.5mm
11/16	19/32		19/32	39/64			
3/4	21/32	11/16	21/32	43/64	31/32	10	1.4mm
13/16	23/32		23/32	47/64		11	3/64
7/8	3/4	13/16	49/64	25/32	1-1/8	12	1.0mm
1'	55/64	15/16	7/8	57/64	1-7/32		
1-1/8	63/64	1-3/64	63/64	1-1/64			
1-1/4	1-3/32	1-11/64	1-7/64	1-9/64	1-9/16		
1-3/8	1-13/64	1-19/64	1-13/64	1-1/4			
1-1/2	1-11/32	1-27/64	1-11/32	1-23/64	1-51/64		
1-5/8	1-7/16			1-1/2			
1-3/4	1-17/32		1-9/16	1-19/32	2-1/32		
2"	1-49/64		1-25/32	1-27/32	2-17/64		

## METRIC THREADS

Tap size	Pitch	Tapping Drill
M 2.0	0.4	1.6mm
M 2.5	0.45	2.05mm
M 3.0	0.5	2.50mm
M 3.5	0.6	2.90mm
M 4.0	0.7	3.30mm
M 4.5	0.75	3.70mm
M 5.0	0.8	4.20mm
M 6	1.0	5.00mm
M 7	1.0	6.00mm
M 8	1.0	7.00mm
M 8	1.25	6.80mm
M 9	1.25	7.80mm
M 10	1.0	9.00mm
M 10	1.25	8.80mm
M10	1.5	8.50mm
M 11	1.5	9.50mm
M 12	1.25	10.80mm
M 12	1.75	10.20mm
M 14	1.25	12.80mm
M 14	1.5	12.50mm
M 14	2.0	12.00mm
M 16	1.5	14.5mm
M 16	2.0	14.0mm
M 18	1.5	16.5mm
M 18	2.5	15.5mm
M 20	1.5	18.5mm
M 20	2.5	17.5mm
M 22	1.5	20.5mm
M 22	2.5	19.5mm
M 24	2.0	22.0mm
M 24	3.0	21.0mm
M 27	3.0	24.0mm
M 30	3.5	26.5mm
M 33	3.5	29.5mm
M 36	4.0	32.0mm