

METRIC & IMPERIAL THREAD TAP CHART

Metric Coarse

Tap mm	Pitch	Drill Size
2	0.40	1.60
2.5	0.45	2.05
3	0.50	2.50
3.5	0.60	2.90
4	0.70	3.30
5	0.80	4.20
6	1.00	5.00
7	1.00	6.00
8	1.25	6.75
9	1.25	7.75
10	1.50	8.50
11	1.50	9.50
12	1.75	10.25
14	2.00	12.00
16	2.00	14.00
18	2.50	15.50
20	2.50	17.50
22	2.50	19.50
24	3.00	21.00
27	3.00	24.00
30	3.50	26.50
33	3.50	29.50
36	4.00	32.00
42	4.50	37.50

UNC (Unified Coarse)

Tap	TPI	Drill Size
No. 2	56	1.75
No. 3	48	2.00
No. 4	40	2.25
No. 5	40	2.60
No. 6	32	2.70
No. 8	32	3.40
No. 10	24	3.80
No. 12	24	4.50
1/4	20	5.10
5/16	18	6.50
3/8	16	8.00
7/16	14	9.30
1/2	13	10.75
9/16	12	12.00
5/8	11	13.50
3/4	10	16.50
7/8	9	18.50
1"	8	22.50
1-1/8	7	25.00
1-1/4	7	28.00
1-3/8	6	31.00
1-1/2	6	34.00

UNF (Unified Fine)

Tap	TPI	Drill Size
No. 2	64	1.80
No. 3	56	2.10
No. 4	48	2.35
No. 5	44	2.60
No. 6	40	2.90
No. 8	36	3.50
No. 10	32	4.50
No. 12	28	4.60
1/4	28	5.50
5/16	24	6.90
3/8	24	8.50
7/16	20	9.90
1/2	20	11.50
9/16	18	13.00
5/8	18	14.50
3/4	16	17.50
7/8	14	20.50
1"	12	23.50
1"	14	23.50
1-1/8	12	26.50
1-1/4	12	29.50
1-3/8	12	33.00
1-1/2	12	36.00

Metric Fine

Tap mm	Pitch	Drill
6	0.75	5.25
8	1.00	7.00
10	1.00	9.00
10	1.25	8.75
12	1.25	10.75
12	1.50	10.50
14	1.25	12.75
14	1.50	12.50
16	1.50	14.50
18	1.50	16.50
20	1.50	18.50
20	2.00	18.00
22	1.50	20.50
22	2.00	20.00
24	1.50	22.50
24	2.00	22.00

BSW (British Whitworth)

Tap	TPI	Drill Size
1/8	40	2.50
5/32	32	3.20
3/16	24	3.70
1/4	20	5.10
5/16	18	6.50
3/8	16	7.90
7/16	14	9.20
1/2	12	10.40
5/8	11	13.40
3/4	10	16.25

BSF (British Fine)

Tap	TPI	Drill Size
3/16	32	4.00
1/4	26	5.30
5/16	22	6.80
3/8	20	8.30
7/16	18	9.70
1/2	16	11.10
5/8	14	14.00
3/4	12	16.75

BSP (British Pipe)

Tap	TPI	Drill Size
1/16	28	6.60
1/8	28	8.75
1/4	19	11.80
3/8	19	15.25
1/2	14	19.05
3/4	14	24.50
1"	11	30.75

NPT (National Pipe)

Tap	TPI	Drill Size
1/16	27	6.20
1/8	27	8.50
1/4	18	11.10
3/8	18	14.75
1/2	14	17.85
3/4	14	23.00
1"	11.5	29.00

BA (British Association)

Tap	TPI	Drill Size
7 BA	52.9	2.05
6 BA	47.9	2.30
5 BA	43	2.65
4 BA	38.5	3.00
3 BA	34.8	3.40
2 BA	31.4	4.00
1 BA	28.2	4.50
0 BA	25.4	5.10

*TPI = Measurement of threads per Inch for Imperial Fasteners *

*Pitch = Measurement of thread from peak to peak Metric Fasteners *

** Please note that this is a guide only. Please double check drill sizes on packet that Tap comes in **