

Tapping drill sizes for internal thread formers

prototyp



M

Metric ISO thread

Thread size mm	Tapping drill size mm
M 1	0.88±0.01
M 1.2	1.08±0.01
M 1.4	1.25±0.01
M 1.6	1.45±0.02
M 1.7	1.55±0.02
M 1.8	1.65±0.02
M 2	1.8±0.02
M 2.2	2±0.02
M 2.3	2.1±0.02
M 2.5	2.3±0.02
M 2.6	2.4±0.02
M 3	2.8±0.03
M 3.5	3.25±0.03
M 4	3.7±0.03
M 5	4.65±0.03
M 6	5.55±0.05
M 8	7.4±0.05
M 10	9.3±0.05
M 12	11.2±0.05
M 14	13.1±0.05
M 16	15.1±0.05
M 18	16.9±0.05
M 20	18.9±0.05
M 22	20.9±0.05
M 24	22.65±0.05

MF

Metric ISO fine thread

Thread size mm	Tapping drill size mm
M 4 x 0.5	3.75±0.03
M 5 x 0.5	4.75±0.03
M 6 x 0.5	5.75±0.03
M 8 x 0.5	7.75±0.03
M 6 x 0.75	5.65±0.03
M 8 x 0.75	7.65±0.03
M 10 x 0.75	9.65±0.03
M 8 x 1	7.55±0.05
M 10 x 1	9.55±0.05
M 12 x 1	11.55±0.05
M 14 x 1	13.55±0.05
M 16 x 1	15.55±0.05
M 18 x 1	17.55±0.05
M 12 x 1.5	11.3±0.05
M 14 x 1.5	13.3±0.05
M 16 x 1.5	15.3±0.05
M 18 x 1.5	17.3±0.05
M 20 x 1.5	19.3±0.05
M 22 x 1.5	21.3±0.05
M 24 x 1.5	23.3±0.05
M 20 x 2	19.1±0.05
M 22 x 2	21.1±0.05
M 24 x 2	23.1±0.05

UNC

Unified Coarse thread

Thread size inch-P	Tapping drill size mm
No. 2-56	1.95±0.02
No. 3-48	2.25±0.03
No. 4-40	2.55±0.03
No. 5-40	2.9±0.03
No. 6-32	3.15±0.03
No. 8-32	3.8±0.03
No. 10-24	4.3±0.05
No. 12-24	5±0.05
1/4 - 20	5.75±0.05
5/16 - 18	7.3±0.05
3/8 - 16	8.8±0.05
7/16 - 14	10.3±0.05
1/2 - 13	11.8±0.05
9/16 - 12	13.3±0.05
5/8 - 11	14.8±0.05
3/4 - 10	17.9±0.05
7/8 - 9	20.95±0.05
1 - 8	24±0.05

UNF

Unified Fine thread

Thread size inch-P	Tapping drill size mm
No. 2-64	2±0.02
No. 3-56	2.3±0.02
No. 4-48	2.6±0.03
No. 5-44	2.9±0.03
No. 6-40	3.2±0.03
No. 8-36	3.85±0.03
No. 10-32	4.45±0.03
No. 12-28	5.1±0.05
1/4 - 28	5.95±0.05
5/16 - 24	7.45±0.05
3/8 - 24	9±0.05
7/16 - 20	10.5±0.05
1/2 - 20	12.1±0.05
9/16 - 18	13.65±0.05
5/8 - 18	15.25±0.05
3/4 - 16	18.3±0.05
7/8 - 14	21.4±0.05
1 - 12	24.45±0.05

UNEF

Unified Extra Fine thread

Thread size inch-P	Tapping drill size mm
1/4 - 32	6±0.05
5/16 - 32	7.6±0.05
3/8 - 32	9.1±0.05
7/16 - 28	10.7±0.05
1/2 - 28	12.3±0.05
9/16 - 24	13.8±0.05
5/8 - 24	15.4±0.05
3/4 - 20	18.5±0.05
7/8 - 20	21.6±0.05
1 - 20	24.8±0.05

G

British Standard pipe thread
DIN ISO 228

Thread size inch-P	Tapping drill size mm
G 1/8	9.2±0.05
G 1/4	12.4±0.05
G 3/8	15.9±0.05
G 1/2	19.9±0.05
G 5/8	21.9±0.05
G 3/4	25.4±0.05

BSW

British Standard Whitworth thread

Thread size inch-P	Tapping drill size mm
3/32-48	2.10±0.02
1/8-40	2.90±0.03
5/32-32	3.50±0.03
3/16-24	4.15±0.03
1/4-20	5.65±0.05
5/16-18	7.15±0.05
3/8-16	8.65±0.05
7/16-14	10.1±0.05
1/2-12	11.5±0.05
9/16-12	13.1±0.05
5/8-11	14.55±0.05
11/16-11	16.15±0.05
3/4-10	17.6±0.05
7/8-9	20.65±0.05
1-8	23.6±0.05