

TAPPING CHART

United National Thread



UNF Unified National Fine (60°)

Tap Size	T.P.I	Drill Size (mm)
#0	80	1.25
#1	72	1.55
#2	64	1.90
#3	56	2.15
#4	48	2.40
#5	44	2.70
#6	40	2.95
#8	36	3.50
#10	32	4.10
#12	28	4.70
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	12.90
5/8"	18	14.50
3/4"	16	17.50
7/8"	14	20.40
1"	12	23.25
1 1/8"	12	26.50
1 1/4"	12	29.50
1 3/8"	12	32.75
1 1/2"	12	36.00

UNC Unified National Coarse (60°)

Tap Size	T.P.I	Drill Size (mm)
#1	64	1.50
#2	56	1.80
#3	48	2.10
#4	40	2.35
#5	40	2.65
#6	32	2.85
#8	32	3.50
#10	24	4.00
#12	24	4.65
1/4"	20	5.35
5/16"	18	6.80
3/8"	16	8.25
7/16"	14	9.65
1/2"	13	11.15
9/16"	12	12.60
5/8"	11	14.05
3/4"	10	17.00
7/8"	9	20.00
1"	8	22.85
1 1/8"	7	25.65
1 1/4"	7	28.85
1 3/8"	6	31.55
1 1/2"	6	34.70
1 3/4"	5	40.40
2"	4 1/2	46.30

TAPPING CHART

ISO Metric Thread



MF ISO Metric Fine (60°)		
Tap Size	Pitch (mm)	Drill Size (mm)
M4	0.5	3.50
M5	0.5	4.50
M6	0.75	5.30
M8	1.0	7.00
M10*	1.0	9.00
M10	1.25	8.80
M12*	1.25	10.80
M12	1.5	10.50
M14	1.25	12.80
M14	1.5	12.50
M16*	1.5	14.50
M18*	1.5	16.50
M20*	1.5	18.50
M22	1.5	20.50
M24	1.5	22.50
M25*	1.5	23.50
M32	1.5	30.50
M36	1.5	34.00
M40	1.5	38.50
M50	1.5	48.50
* Metric Conduit		
* Spark Plug		

M ISO Metric Coarse (60°)		
Tap Size	Pitch (mm)	Drill Size (mm)
M1.6	0.35	1.25
M2	0.4	1.60
M2.5	0.45	2.05
M3	0.5	2.50
M3.5	0.6	2.90
M4	0.7	3.30
M4.5	0.75	3.80
M5	0.8	4.20
M6	1.0	5.00
M8	1.25	6.80
M10	1.50	8.50
M12	1.75	10.20
M14	2.0	12.00
M16	2.0	14.00
M18	2.5	15.50
M20	2.5	17.50
M24	3.0	21.00
M27	3.0	24.00
M30	3.5	26.50
M33	3.5	29.50
M36	4.0	32.00
M42	4.5	37.50
M45	4.5	40.50
M48	5.0	43.00
M52	5.0	47.00
M56	5.5	50.50