

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

Bugatti		
Size	Pitch	Tap drill
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

Wood screw		
Gauge	Size	
	"	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
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

BA						
No.	Size		Pitch		Tap drill	
	"	mm	TPI	mm	"	L/N/F
0	0.2362	6.00	25.4	1.00	0.2008	9
1	0.2087	5.30	28.2	0.90	0.1772	16
2	0.1850	4.70	31.4	0.81	0.1575	22
3	0.1614	4.10	34.8	0.73	0.1339	29
4	0.1417	3.60	38.5	0.66	0.1181	31
5	0.1260	3.20	43.0	0.59	0.1043	37
6	0.1102	2.80	47.9	0.53	0.0906	42
7	0.0984	2.50	52.9	0.48	0.0807	46
8	0.0866	2.20	59.1	0.43	0.0709	50
9	0.0748	1.90	65.1	0.39	0.0610	54
10	0.0669	1.70	72.6	0.35	0.0551	54
11	0.0590	1.50	82.0	0.31	0.0472	56
12	0.0511	1.30	90.7	0.28	0.0413	60
13	0.0472	1.20	102.0	0.25	0.0386	62
14	0.0394	1.00	110.0	0.23	0.0315	62
15	0.0354	0.90	121.0	0.21	0.0276	70
16	0.0311	0.79	134.0	0.19	0.0236	73

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	0.50	11.50
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
36	1.00	35.00
36	1.50	34.40
36	2.00	34.00
36	3.00	33.00
38	1.00	37.00
38	1.50	36.50
38	2.00	36.00
39	1.50	37.50
39	2.00	37.00
39	3.00	36.00
40	1.00	39.00
40	1.50	38.50
40	3.00	37.00
42	1.50	40.50
42	2.00	40.00
42	3.00	39.00
42	4.00	38.00
45	1.50	43.50
45	2.00	43.00
45	3.00	42.00
48	1.50	46.50
48	2.00	46.00
48	3.00	45.00
48	4.00	44.00

UNC				
Size	Pitch	Tap drill		
"	TPI	"	L/N/F	mm
(1)	64	0.0551	54	1.40
(2)	56	0.0669	51	1.70
(3)	48	0.0787	47	2.00
(4)	40	0.0866	44	2.20
(5)	40	0.0984	40	2.50
(6)	32	0.1102	35	2.80
(8)	32	0.1339	29	3.40
(10)	24	0.1457	24	3.70
(12)	24	0.1732	16	4.40
1/4	20	0.2047	7	5.20
1/3	18	0.2559	F	6.50
3/8	16	0.3110	5/16	7.90
4/9	14	0.3661	U	9.30
1/2	13	0.4213	27/64	10.70
4/7	12	0.4764	31/64	12.10
5/8	11	0.5307	17/32	13.49
3/4	10	0.6496	21/32	16.50
7/8	9	0.7657	49/64	19.45
1	8	0.8760	7/8	22.25
1 1/8	7	0.9844	63/64	25.00
1 1/4	7	1.1094	1 - 7/64	28.18
1 3/8	6	1.2106	1 - 7/32	30.75
1 1/2	6	1.3281	1 - 21/64	33.80
1 3/4	5	1.5469	1 - 35/64	39.30
2	4.5	1.7812	1 - 25/32	45.30
2 1/4	4.5	2.0276	2 - 1/32	51.50
2 1/2	4	2.2441	2 - 1/4	57.00
2 3/4	4	2.5000	2 - 1/2	63.50
3	4	2.7560	2 - 3/4	70.00
3 1/4	4	3.0118	3	76.50
3 1/2	4	3.2677	3 - 1/4	83.00
3 3/4	4	3.5040	3 - 1/2	89.00
4	4	3.7598	3 - 3/4	95.50

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	20	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