



METRIC (S.S.O.) COARSE		
Nominal Dia. of Thread (mm)	Average Dia. (mm)	Tapping Drill Dia. (mm)
M2.0	0.80	1.60
M2.3	0.85	1.75
M2.5	0.85	2.05
M3.0	0.50	2.50
M3.5	0.60	2.90
M4.0	0.70	3.30
M4.5	0.75	3.70
M5.0	0.80	4.20
M6.0	1.00	5.00
M7.0	1.00	6.00
M8.0	1.25	6.80
M9.0	1.25	7.80
M10.0	1.50	8.50
M11.0	1.50	9.50
M12.0	1.75	10.20
M14.0	2.00	12.00
M16.0	2.00	14.00
M18.0	2.50	15.50
M20.0	2.50	17.50
M22.0	2.50	19.50
M24.0	3.00	21.00
M27.0	3.00	24.00
M30.0	3.50	26.50
M33.0	3.50	29.50
M36.0	4.00	32.00
M39.0	4.00	35.00
M42.0	4.50	37.50
M45.0	4.50	40.50
M48.0	5.00	43.00
M52.0	5.00	47.00
M56.0	5.50	50.50
M60.0	5.50	54.50

METRIC (S.S.O.) FINE		
Nominal Dia. of Thread (mm)	Average Dia. (mm)	Tapping Drill Dia. (mm)
M2.0	0.25	1.75
M2.3	0.25	1.95
M2.5	0.25	2.15
M3.0	0.25	2.65
M3.5	0.25	3.15
M4.0	0.50	3.50
M4.5	0.50	4.00
M5.0	0.50	4.50
M6.0	0.75	5.20
M7.0	0.75	6.20
M8.0	0.75	7.20
M9.0	1.00	7.00
M10.0	0.75	8.20
M11.0	1.00	9.00
M12.0	1.25	8.80
M14.0	1.50	10.00
M16.0	1.50	11.00
M18.0	1.50	12.50
M20.0	1.50	14.50
M22.0	1.50	17.00
M24.0	1.50	19.00
M27.0	1.50	18.00
M30.0	1.50	21.00
M33.0	1.50	20.50
M36.0	2.00	20.00
M39.0	1.00	23.00
M42.0	1.50	22.50
M45.0	2.00	22.00
M48.0	1.50	23.50
M52.0	2.00	23.00
M56.0	1.50	25.50
M60.0	1.50	26.50
M63.0	1.50	28.50
M66.0	1.50	30.50
M70.0	2.00	31.00

METRIC (S.S.O.) FINE (continued)		
Nominal Dia. of Thread (mm)	Average Dia. (mm)	Tapping Drill Dia. (mm)
M80.0	1.50	36.50
M85.0	3.00	36.00
M90.0	1.50	38.50
M95.0	3.00	37.00
M100.0	4.00	38.00
M105.0	4.00	41.00
M110.0	4.00	44.00
M115.0	4.00	45.00
M120.0	4.00	48.00
M125.0	4.00	49.00
M130.0	4.00	52.00
M135.0	4.00	56.00

  

FLUTELESS (mm and inch mm)		
ISO Metric Coarse		
M3	2.8	
M3.5	3.2	
M4	3.7	
M5	4.8	
M6	5.8	
M8	7.8	
M10	9.5	
M12	11.1	

  

UNC (DIN)		
No.	mm	inch
No.2	1.95	
No.4	2.65	
No.6	3.2	
No.8	3.8	
No.10	4.3	
1/4	6.3	
5/16	7.3	
3/8	9.5	
1/2	11.7	

  

S.A.		
	mm	inch
25A	4.4	
45A	3.3	
65A	2.6	
85A	2.0	

  

UNF (DIN)		
No.	mm	inch
No.4	3.8	
No.6	4.8	
No.8	5.8	
No.10	6.5	
1/4	9.5	
5/16	7.5	
3/8	9.5	
1/2	12.1	

  

BSF		
	mm	inch
1/4	6.8	
5/16	7.3	
3/8	9.5	

  

BSW		
	mm	inch
1/8	2.9	
3/16	4.2	
1/4	5.7	
5/16	7.2	
3/8	8.7	

Unified National Coarse (UN.C)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
No. 1	84	1.55
No. 2	56	1.85
No. 3	48	2.15
No. 4	40	2.35
No. 5	40	2.65
No. 6	32	2.85
No. 8	32	3.50
No. 10	24	3.90
No. 12	24	4.50
1/4"	20	5.10
5/16"	18	6.60
3/8"	16	8.00
7/16"	14	9.40
1/2"	13	10.80
5/8"	12	12.20
3/4"	11	13.50
7/8"	10	16.50
1"	9	19.50
1 1/8"	7	25.00
1 1/4"	7	28.00
1 3/8"	6	30.75
1 1/2"	6	34.00
1 3/4"	5	39.50
2"	4.5	45.00

  

Unified National Fine (UN.F)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
No. 0	80	1.35
No. 1	72	1.55
No. 2	64	1.80
No. 3	56	2.15
No. 4	48	2.40
No. 5	44	2.70
No. 6	40	2.95
No. 8	36	3.50
No. 10	32	4.10
No. 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
5/8"	18	12.90
3/4"	18	14.50
7/8"	16	17.50
1"	14	20.40
1 1/8"	12	23.25
1 1/4"	12	26.50
1 1/2"	12	29.50
1 3/4"	12	32.75
1 1/2"	12	36.00

BRITISH STANDARD WHITFORTH (B.S.W.)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
1/8"	25	2.55
3/16"	24	3.15
1/4"	20	5.50
5/16"	18	6.50
3/8"	16	7.90
7/16"	14	9.30
1/2"	13	10.50
5/8"	12	12.10
3/4"	11	13.50
7/8"	10	16.25
1"	9	19.25
1 1/8"	8	22.00
1 1/4"	7	24.75
1 1/2"	7	28.00
1 3/4"	6	30.50
2"	5	36.00
2 1/2"	4.5	44.50

  

BRITISH STANDARD PIPE FASTENING (B.S.P.F.) G		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
1/8"	28	8.00
1/4"	19	11.80
3/8"	19	15.25
1/2"	14	19.00
5/8"	14	21.00
3/4"	14	24.50
7/8"	14	28.25
1"	11	30.75
1 1/4"	11	39.50
1 1/2"	11	45.00
1 3/4"	11	51.00
2"	11	57.00

  

BRITISH STANDARD PIPE THREAD (B.S.P.T.)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
1/8"	28	8.40
1/4"	19	12.00
3/8"	19	14.75
1/2"	14	18.25
5/8"	14	22.75
3/4"	14	26.50
1"	11	30.00
1 1/8"	11	36.50
1 1/2"	11	44.50
1 3/4"	11	56.00
2 1/2"	11	71.00

  

BRITISH ASSOCIATION (B.A.)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
No. 0	1.50	5.10
No. 1	0.90	4.50
No. 2	0.81	4.00
No. 3	0.73	3.40
No. 4	0.66	3.00
No. 5	0.59	2.65
No. 6	0.53	2.30
No. 7	0.48	2.05
No. 8	0.43	1.80
No. 9	0.39	1.55
No. 10	0.35	1.40
No. 11	0.31	1.20
No. 12	0.28	1.05
No. 13	0.25	0.98
No. 14	0.23	0.85

NATIONAL STANDARD PIPE (N.S.P.T.)		
Nominal Dia. of Thread	Pitch (in 1")	Tapping Drill Dia. (mm)
1/8"	27	8.30
1/4"	18	11.50
3/8"	18	14.50
1/2"	14	18.00
5/8"	14	23.25
1"	11	26.00
1 1/4"	11	38.00
1 1/2"	11	44.00
2"	11	58.00
2 1/2"	8	87.00

# Tapping Drill Selector Chart



# Machinists Guide For Taps

**D Siedentop**



## **Machinists Guide For Taps:**

## Unveiling the Power of Verbal Artistry: An Emotional Sojourn through **Machinists Guide For Taps**

In some sort of inundated with displays and the cacophony of fast transmission, the profound energy and psychological resonance of verbal artistry frequently disappear in to obscurity, eclipsed by the constant onslaught of noise and distractions. However, located within the musical pages of **Machinists Guide For Taps**, a charming perform of fictional splendor that impulses with fresh feelings, lies an memorable trip waiting to be embarked upon. Published by way of a virtuoso wordsmith, this enchanting opus courses viewers on a mental odyssey, softly revealing the latent potential and profound impact embedded within the complex web of language. Within the heart-wrenching expanse with this evocative analysis, we can embark upon an introspective exploration of the book is key styles, dissect their charming publishing style, and immerse ourselves in the indelible impact it leaves upon the depths of readers souls.

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