

# THREADING & TAPPING TABLES.

## BSW Whitworth\*

55° thread form

Size Inch	Threads Per Inch	Tapping Drill Sizes			
		Preferred		Alternative	
		mm	inch	mm	inch
1/16*	60	1.2	3/64	1.05	-
3/32*	48	1.9	-	1.75	-
1/8	40	2.55	-	2.5	3/32
5/32*	32	3.2	1/8	2.95	-
3/16	24	3.7	-	3.6	9/64
7/32*	24	4.5	-	4.3	11/64
1/4	20	5.1	-	5.0	3/16
5/16	18	6.5	-	6.4	1/4
3/8	16	7.9	5/16	7.8	19/64
7/16	14	9.5	-	9.2	23/64
1/2	12	10.5	-	-	13/32
9/16	12	-	-	12.0	15/32
5/8	11	13.5	17/32	-	33/64
3/4	10	16.5	41/64	16.0	5/8
7/8	9	-	3/4	19.0	47/64
1	8	22.0	55/64	-	27/32
1-1/8	7	-	31/32	24.5	61/64
1-1/4	7	28.0	1-3/32	27.5	1-5/64
1-1/2	6	33.5	1-5/16	33.0	1-19/64
1-3/4	5	39.0	1-17/32	38.5	1-33/64
2	4 1/2	44.5	1-49/64	44.0	1-3/4

## Metric ISO Coarse

60° thread form

Size Inch	Pitch mm	Tapping Drill Sizes			
		Preferred		Alternative	
		mm	inch	mm	inch
2.0	0.40	1.65	-	1.6	1/16
2.5	0.45	2.1	-	2.05	-
3.0	0.50	2.55	-	2.5	-
3.5	0.60	2.95	-	2.9	-
4.0	0.70	3.4	-	3.3	-
4.5	0.75	3.8	-	3.7	-
5.0	0.80	4.3	11/64	4.2	-
6.0	1.00	5.1	13/64	5.0	-
7.0	1.00	6.1	-	6.0	15/64
8.0	1.25	6.9	-	6.8	17/64
9.0	1.25	7.9	5/16	7.8	-
10.0	1.50	8.6	11/32	8.5	-
11.0	1.50	-	-	9.5	3/8
12.0	1.75	-	13/32	10.2	-
14.0	2.00	12.2	31/64	12.0	15/32
16.0	2.00	14.25	9/16	14.0	35/64
18.0	2.50	15.75	-	15.5	39/64
20.0	2.50	-	45/64	17.5	11/16
22.0	2.50	-	25/32	19.5	49/64
24.0	3.00	-	-	21.0	53/64
27.0	3.00	-	61/64	24.0	15/16
30.0	3.50	-	-	26.5	1-3/64
33.0	3.50	-	1-11/64	29.5	1-5/32
36.0	4.00	-	1-17/64	32.0	1-1/4

## UNC

60° thread form

Size Inch	Threads Per Inch	Tapping Drill Sizes -			
		Preferred		Alternative	
		mm	inch	mm	inch
No. 2	56	1.85	-	1.8	-
No. 3	48	2.1	-	2.05	5/64
No. 4	40	2.35	3/32	2.3	-
No. 5	40	2.65	-	2.6	-
No. 6	32	2.85	-	2.8	7/64
No. 8	32	3.5	-	3.4	-
No. 10	24	3.9	5/32	3.8	-
No. 12	24	4.5	-	4.4	11/64
1/8*	40	2.65	-	2.6	-
5/32*	32	3.3	-	3.1	1/8
3/16*	24	3.8	-	3.7	-
7/32*	24	4.6	-	4.5	-
1/4	20	5.2	13/64	5.1	-
5/16	18	6.6	17/64	6.5	1/4
3/8	16	8.1	-	8.0	5/16
7/16	14	9.5	3/8	-	23/64
1/2	13	11.0	-	10.8	27/64
9/16	12	12.2	31/64	-	-
5/8	11	13.8	35/64	13.5	17/32
11/16*	11	15.25	-	15.0	19/32
3/4	10	-	21/32	16.5	41/64
13/16*	10	-	23/32	18.0	-
7/8	9	19.5	49/64	-	-
1	8	-	7/8	22.5	-
1-1/8	7	-	-	25.0	63/64
1-1/4	7	-	1-7/64	28.0	-
1-3/8	6	31.0	1-7/32	-	1-13/64
1-1/2	6	-	1-11/32	34.0	1-21/64

## Metric ISO Fine

60° thread form

Size Inch	Pitch mm	Tapping Drill Sizes			
		Preferred		Alternative	
		mm	inch	mm	inch
8.0	1.00	7.1	9/32	7.0	-
10.0	1.25	8.9	-	8.8	11/32
12.0	1.25	-	27/64	10.5	-
14.0	1.50	-	1/2	12.5	-
16.0	1.50	14.75	37/64	14.5	-
18.0	1.50	-	21/32	16.5	-
20.0	1.50	-	47/64	18.5	-
22.0	1.50	-	13/16	20.5	-
24.0	2.00	-	7/8	22.0	-

## BSF

55° thread form

Size Inch	Threads Per Inch	Tapping Drill Sizes			
		Preferred		Alternative	
		mm	inch	mm	inch
3/16	32	4.0	5/32	3.9	-
1/4	26	5.3	-	5.2	13/64
5/16	22	6.8	17/64	6.7	-
3/8	20	8.3	21/64	8.2	5/16
7/16	18	-	-	9.5	3/8
1/2	16	-	7/16	11.0	27/64
9/16	16	-	1/2	12.5	31/64
5/8	14	14.0	35/64	13.8	17/32
3/4	12	-	-	16.5	21/32
7/8	11	-	25/32	19.5	49/64
1	10	-	57/64	22.5	7/8
1-1/4	9	28.5	1-1/8	-	1-7/64
1-1/2	8	34.5	1-23/64	-	1-11/32
1-3/4	7	40.5	1-19/32	40.0	1-37/64

## UNF

60° thread form

Size Inch	Threads Per Inch	Tapping Drill Sizes			
		Preferred		Alternative	
		mm	inch	mm	inch
No. 5	44	2.7	-	2.65	-
No. 6	40	2.95	-	2.9	-
No. 8	36	3.6	9/64	3.5	-
No. 10	32	4.1	-	4.0	5/32
No. 12	28	4.7	-	4.6	-
1/8*	40	2.65	-	2.6	-
5/32*	32	3.3	-	3.1	1/8
3/16*	32	4.1	-	3.9	5/32
7/32*	32	4.9	-	4.8	3/16
1/4	28	5.5	7/32	5.4	-
5/16	24	6.9	-	6.8	-
3/8	24	8.5	-	8.4	-
7/16	20	10.0	25/64	9.8	-
1/2	20	11.5	29/64	-	-
9/16	18	-	33/64	12.8	-
5/8	18	14.5	37/64	-	-
11/16*	16	16.0	5/8	15.75	-
3/4	16	17.5	11/16	-	-
13/16*	16	-	3/4	19.0	-
7/8	14	-	13/16	20.5	-
1	12	23.5	59/64	-	-
1*	14	-	15/16	23.5	-
1-1/8	12	26.5	1-3/64	-	-
1-1/4	12	-	1-11/64	29.5	-
1-3/8	12	33.0	1-19/64	-	-
1-1/2	12	36.0	1-27/64	-	-