

# TAPPING DRILL SIZES

Drill Size					Drill Size				
mm	inch	inch	Let/No.	Thread	mm	inch	inch	Let/No.	Thread
0.2	0.0079				2.78	0.1094	7/64		
0.22	0.0087				2.8	0.1102		35	6 BAO
0.25	0.0098				2.85	0.1122		34	No6 UNC
0.28	0.0110				2.9	0.1142		33	Met C 3.5 mm
0.3	0.0118				2.95	0.1161		32	4 BA, No6 UNF
0.32	0.0126				3	0.1181		31	
0.35	0.0138		80		3.1	0.1220			
0.38	0.0150		79		3.18	0.1250	1/8		
0.39	0.0156	1/64			3.2	0.1260		30	Met S P 2.3 mm, 5 BAO
0.4	0.0157		78		3.2	0.1260		30	5/32 BSC, 5/32 Whit, 0.154 CEI
0.42	0.0165				3.3	0.1299			Met C 4 mm
0.45	0.0177		77		3.4	0.1339		29	3 BA
0.48	0.0189				3.5	0.1378			Met F 4 mm, No8 UNC
0.5	0.0197		76		3.55	0.1398			No8 UNF
0.52	0.0205		75		3.57	0.1406	9/64	28	
0.55	0.0217				3.6	0.1417		27	0.175 CEI, 4 BAO
0.58	0.0228		74		3.7	0.1457		26	3/16 Whit
0.6	0.0236		73	16 BA	3.8	0.1496		25	Met C 4.5 mm
0.62	0.0244		72		3.9	0.1535		24	No10 UNC
0.65	0.0256		71		3.97	0.1562	5/32	23	3/16 BSF 3/16 CEI, 3/16 BSC
0.68	0.0268				4	0.1575		22	2 BA
0.7	0.0276		70	15 BA	4.1	0.1614		21	Met S P 5 mm, No 10 UNF, 3 BAO
0.72	0.0283				4.2	0.1654		20	Met C 5 mm
0.75	0.0295		69	Met C 1 mm	4.3	0.1693		19	
0.78	0.0307				4.37	0.1719	11/64	18	
0.79	0.0312	1/32	68		4.4	0.1732		17	
0.8	0.0315			14 BA	4.5	0.1772		16	1 BA, 7/32 Whit., Met F 5 mm
0.82	0.0323		67		4.55	0.1791			No12 UNC
0.85	0.0335		66	Met C 1.1 mm	4.6	0.1811		15	7/32 BSF, Met S P 5.5 mm
0.88	0.0346				4.65	0.1831			No 12 UNF
0.9	0.0354		65		4.7	0.1850		14	2 BAO
0.92	0.0362		64		4.76	0.1875	3/16	13	
0.95	0.0374		63	Met C 1.2 mm	4.8	0.1890		12	
0.98	0.0386		62	13 BA	4.9	0.1929		11	
1	0.0394		61	12 BA, 17swg CEI, 14BAO	5	0.1969		10	Met C 6 mm
1.05	0.0413		60	12 BA	5.1	0.2008		9	0 BA, 1/4 Whit
1.1	0.0433		59	Met C 1.4 mm	5.16	0.2031	13/64	8	
1.15	0.0453		58		5.2	0.2047		7	1/4 UNC, Met F 6 mm
1.19	0.0469	3/64	57	16swg CEI	5.3	0.2087		6	1/4 BSF, 1 BAO
1.2	0.0472		56	11 BA, 1/16 Whit, 13 BAO	5.4	0.2126		5	
1.25	0.0492			Met C 1.6 mm, No 0 UNF	5.5	0.2165		4	1/4 UNF
1.3	0.0512		55	12 BAO	5.56	0.2188	7/32	3	1/4 BSC, 1/4 CEI
1.35	0.0531			Met S P 1.7 mm	5.6	0.2205		2	
1.4	0.0551		54	15swg CEI, 10BA	5.7	0.2244			
1.45	0.0571			Met C 1.8 mm	5.8	0.2283		1	0.266 CEI
1.5	0.0591		53	9 BA, 11 BAO	5.9	0.2323		A	
1.55	0.0610			Met S P 2 mm, No1 UNC	5.95	0.2344	15/64		
1.58	0.0625	1/16			6	0.2362		B	Met C 7 mm, 9/32 BSF, 0 BAO
1.6	0.0630		52	Met C 2 mm, No1 UNF, 14swg CEI	6.1	0.2402		C	
1.65	0.0650				6.2	0.2441		D	9/32 BSC, 0.281 CEI, Met F 7 mm
1.7	0.0669		51	10 BAO	6.3	0.2480		E	
1.75	0.0689			Met C 2.2 mm	6.35	0.2500	1/4		
1.8	0.0709		50	8 BA	6.4	0.2520			1/16 BSTP
1.85	0.0728		49	3/32 Whit, No2 UNC, 13swg CEI	6.5	0.2559		F	5/16 Whit
1.9	0.0748		48	Met S P 2.3 mm, No2 UNF, 9 BAO	6.6	0.2598		G	5/16 UNC, 1/16 BSP
1.95	0.0768				6.7	0.2638		H	
1.98	0.0781	5/64			6.75	0.2655	17/64		5/16 BSF
2	0.0787		47	7 BA	6.8	0.2677			Met C 8 mm
2.05	0.0807		46	Met C 2.5 mm, 12swg CEI	6.9	0.2717		I	5/16 UNF
2.1	0.0827		45	No3 UNC	7	0.2756		J	5/16 BSC, Met F 8 mm, 5/16 CEI
2.15	0.0846			Met S P 2.6 mm, No3 UNF	7.1	0.2795		K	
2.2	0.0866		44	8 BAO	7.14	0.2812	9/32		
2.25	0.0886		43		7.2	0.2835			Met S P 8 mm
2.3	0.0906			6 BA	7.3	0.2874		L	
2.35	0.0925			No4 UNC	7.4	0.2913		M	
2.38	0.0938	3/32	42		7.5	0.2953			
2.4	0.0945			Met S P 3 mm, No4 UNF	7.54	0.2969	19/64		
2.45	0.0965		41		7.6	0.2992		N	
2.5	0.0984		40	Met C 3 mm, 7 BAO	7.7	0.3031			
2.55	0.1004		39	1/8 Whit 1/8 BSC, 1/8 CEI	7.8	0.3071			Met C 9 mm
2.6	0.1024		38	5 BA	7.9	0.3110			
2.65	0.1043		37	Met F 3 mm, No5 UNC	7.94	0.3125	5/16		3/8 Whit
2.7	0.1063		36	No5 UNF	8	0.3150		0	3/8 UNC, Met S P 9 mm
2.75	0.1083				8.1	0.3189			

### Abbreviations

Met = ISO metric thread    F= Fine, C= Coarse (SP = special pitch    p = pitch in mm)  
 BSF = British Standard fine,    Whit = Whitworth,    UNC = Unified Coarse,    UNF = Unified Fine,  
 BSTP = British Standard Taper Pipe,    BSP = British Standard Pipe,    BSC = British Standard Cycle,    CEI = Cycle Engineers Institute  
 BA = British Association (tap drill size)    BAO = BA overall diameter,    swg = Standard Wire Gauge

# TAPPING DRILL SIZES

Drill Size					Drill Size				
mm	inch	inch	Let/No.	Thread	mm	inch	inch	Let/No.	Thread
8.2	0.3228		P	3/8 BSF	14.3	0.5625	9/16		
8.3	0.3268				14.5	0.5709			5/8 UNF, Met F 16 mm
8.33	0.3281	21/64			14.68	0.5780	37/64		
8.4	0.3307		Q	1/8 BSTP	14.75	0.5807			3/8 BSTP
8.5	0.3346			Met C 10 mm, 3/8 UNF	15	0.5906			11/16 Whit, Met S P 16 mm, 5/8 BSC
8.6	0.3386		R	3/8 BSC, 3/8 CEI	15.08	0.5937	19/32		
8.7	0.3425				15.25	0.6004			3/8 BSP
8.73	0.3438	11/32		1/8 BSP	15.48	0.6094	39/64		
8.8	0.3465		S	Met F 10 mm	15.5	0.6102			Met C 18 mm, 11/16 BSF
8.9	0.3504				15.75	0.6201			
9	0.3543			Met S P 10 mm	15.88	0.6252	5/8		
9.1	0.3583		T		16	0.6299			
9.13	0.3594	23/64			16.25	0.6398			
9.2	0.3622			Met S P 10 mm	16.27	0.6406	41/64		3/4 Whit
9.3	0.3661		U	7/16 Whit	16.5	0.6496			3/4 UNC, Met F 18 mm
9.4	0.3701			7/16 UNC	16.67	0.6563	21/32		
9.5	0.3740		V	Met C 11 mm	16.75	0.6594			3/4 BSF
9.53	0.3750	3/8			17	0.6693			
9.6	0.3780				17.07	0.6720	43/64		
9.7	0.3819			7/16 BSF	17.25	0.6791			
9.8	0.3858		W		17.46	0.6874	11/16		3/4 UNF
9.9	0.3898			7/16 UNF	17.5	0.6890			Met C 20 mm
9.92	0.3906	25/64			17.75	0.6988			
10	0.3937				17.86	0.7031	45/64		
10.1	0.3976		X	7/16 BSC	18	0.7087			13/16 Whit, Met S P 20 mm (2 p)
10.2	0.4016			Met C 12 mm	18.25	0.7185			1/2 BSTP
10.3	0.4055		Y		18.26	0.7189	23/32		
10.32	0.4062	13/32			18.5	0.7283			Met F 20 mm
10.4	0.4094				18.65	0.7343	47/64		
10.5	0.4134		Z	1/2 Whit, Met S P 12 mm (1.5 p)	18.75	0.7382			
10.6	0.4173				19	0.7480			Met S P 20 mm (1 p)
10.7	0.4213				19.05	0.7500	3/4		1/2 BSP
10.72	0.4219	27/64			19.25	0.7579			7/8 Whit
10.8	0.4252			1/2 UNC, Met F 12 mm	19.45	0.7656	49/64		7/8 UNC
10.9	0.4291				19.5	0.7677			Met C 22 mm
11	0.4331			Met S P 12 mm (1p)	19.75	0.7776			
11.1	0.4370				19.84	0.7812	25/32		7/8 BSF
11.11	0.4375	7/16		1/2 BSF	20	0.7874			
11.2	0.4409			1/4 BSTP	20.24	0.7969	51/64		
11.3	0.4449				20.25	0.7972			
11.4	0.4488			1/2 UNF	20.5	0.8071			Met F 22 mm
11.5	0.4528				20.64	0.8125	13/16		7/8 UNF
11.51	0.4531	29/64			20.75	0.8169			15/16 Whit
11.6	0.4567				21	0.8268			Met C 24 mm
11.7	0.4606				21.03	0.8281	53/64		5/8 BSP
11.8	0.4646			1/4 BSP	21.25	0.8366			
11.9	0.4685				21.43	0.8438	27/32		
11.91	0.4688	15/32			21.5	0.8465			
12	0.4724			Met C 14 mm	21.75	0.8563			
12.1	0.4764			9/16 Whit	21.83	0.8594	55/64		
12.2	0.4803			9/16 UNC	22	0.8661			1 inch Whit, Met F 24 mm
12.3	0.4843				22.23	0.8750	7/8		
12.3	0.4844	31/64			22.25	0.8760			1 inch UNC
12.4	0.4882				22.5	0.8858			Met S P 24 mm (1.5 p)
12.5	0.4921			Met S P 14 mm	22.62	0.8906	57/64		
12.6	0.4961				22.75	0.8957			1 inch BSF
12.7	0.5000	1/2		9/16 BS F	23	0.9055			Met S P 24 mm (1 p)
12.8	0.5039			Met F 14 mm	23.02	0.9062	29/32		
12.9	0.5079			9/16 UNF	23.25	0.9154			1 inch UNF
13	0.5118				23.42	0.9219	59/64		
13.1	0.5156	33/64		9/16 BSC, 9/16 CEI	23.5	0.9252			Met S P 25 mm (1.5 p)
13.1	0.5157				23.75	0.9350			3/4 BSTP
13.2	0.5197				23.81	0.9375	15/16		
13.3	0.5236				24	0.9449			Met C 27 mm
13.4	0.5276				24.21	0.9531	61/64		
13.49	0.5313	17/32		5/8 UNC	24.25	0.9547			
13.5	0.5315			5/8 Whit	24.5	0.9646			3/4 BSP
13.6	0.5354				24.61	0.9688	31/32		1 inch BSC, 1 inch CEI
13.7	0.5394				24.75	0.9744			
13.8	0.5433				25	0.9843			Met F 27 mm
13.89	0.5469	35/64			25	0.9844	63/64		
13.9	0.5472				25.4	1.0000	1		
14	0.5512			Met C 16 mm, 5/8 BSF					
14.25	0.5610								

Copyright: Ray West 2003 email: tapchartv1@raywest.com

### Abbreviations

Met = ISO metric thread F= Fine, C= Coarse (SP = special pitch p = pitch in mm)  
 BSF = British Standard fine, Whit = Whitworth, UNC = Unified Coarse, UNF = Unified Fine,  
 BSTP = British Standard Taper Pipe, BSP = British Standard Pipe, BSC = British Standard Cycle, CEI = Cycle Engineers Institute  
 BA = British Association (tap drill size) BAO = BA overall diameter, swg = Standard Wire Gauge