

Thread Pitch Chart: Imperial & Metric

Diam. (inch)	UNC	UNF	8-UN
#0		80	
#1	64	72	
#2	56	64	
#3	48	56	
#4	40	48	
#5	40	44	
#6	32	40	
#8	32	36	
#10	24	32	
#12	24	28	
1/4	20	28	
5/16	18	24	
3/8	16	24	
7/16	14	20	
1/2	13	20	
9/16	12	18	
5/8	11	18	
3/4	10	16	
7/8	9	14	
1	UNS - 14 TPI (common)		
	8	12	8
1 1/8	7	12	8
1 1/4	7	12	8
1 3/8	6	12	8
1 1/2	6	12	8
1 3/4	5		8
2	4.5		8
2 1/4	4.5		8
2 1/2	4		8
2 3/4	4		8
3	4		8
3 1/4	4		8
3 1/2	4		8
3 3/4	4		8
4	4		8

Diam. (mm)	Coarse	Fine	Fine (2/3/4)
1	0.25		
1.2	0.25		
1.4	0.3		
1.6	0.35		
1.8	0.35		
2	0.4		
2.5	0.45		
3	0.5		
3.5	0.6		
4	0.7		
5	0.8	0.9	0.75 / 0.5
6	1	0.75	0.5
7	1	0.75	0.5
8	1.25	1	0.75 / 0.5
10	1.5	1.25	1 / 0.75
12	1.75	1.5	1.25 / 1
14	2	1.5	1.25 / 1
16	2	1.5	1
18	2.5	2	1.5 / 1
20	2.5	2	1.5 / 1
22	2.5	2	1.5 / 1
24	3	2	1.5 / 1
27	3	2	1.5 / 1
30	3.5	3	2 / 1.5 / 1
33	3.5	3	2 / 1.5
36	4	3	2 / 1.5
39	4	3	2 / 1.5
42	4.5	4	3 / 2 / 1.5
45	4.5	3	
48	5	3	
52	5	4	
56	5.5	4	
60	5.5	4	
64	6	4	

Tap & Drill Chart: Imperial & Metric

Tap (inch)	Fractional Drill Bit	Number Drill Bit	Letter Drill Bit
0-80	3/64	-	-
1-64	-	53	-
2-56	-	50	-
3-48	-	47	-
4-40	3/32	43	-
5-40	-	38	-
6-32	7/64	36	-
8-32	-	29	-
10-24	5/32	25	-
10-32	5/32	21	-
12-24	11/64	16	-
1/4-20	13/64	7	-
1/4-28	7/32	3	-
5/16-18	17/64	-	F
5/16-24	-	-	I
3/8-16	5/16	-	-
3/8-24	21/64	-	Q
7/16-14	23/64	-	U
7/16-20	25/64	-	-
1/2-13	27/64	-	-
1/2-20	29/64	-	-
9/16-12	31/64	-	-
9/16-18	33/64	-	-
5/8-11	17/32	-	-
5/8-18	37/64	-	-
3/4-10	21/32	-	-
3/4-16	11/16	-	-

Drill sizes are for 75% depth of thread.

Tap (mm)	Metric Drill	Imperial Drill
3 mm x 0.5	2.5 mm	-
4 mm x 0.7	3.4 mm	-
5 mm x 0.8	4.3 mm	-
6 mm x 1.0	5.2 mm	-
7 mm x 1.0	6.1 mm	15/64
8 mm x 1.25	6.9 mm	17/64
8 mm x 1.0	7.1 mm	-
10 mm x 1.5	8.7 mm	-
10 mm x 1.25	8.8 mm	11/32
10 mm x 1.0	9.1 mm	-
12 mm x 1.75	10.5 mm	-
12 mm x 1.5	10.7 mm	27/64
14 mm x 2.0	12.2 mm	-
14 mm x 1.5	12.7 mm	1/2
16 mm x 2.0	14.2 mm	35/64
16 mm x 1.5	14.7 mm	-

Drill sizes are for 75% depth of thread.

