

The threading specialists



METRIC (S.S.O.) COARSE		
Nominal Dia. of Thread (mm)	Actual Dia. of Thread (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)	Actual Dia. of Thread (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	1.25	10.80
M20.0	1.50	10.50
M22.0	1.00	13.00
M24.0	1.25	12.80
M27.0	1.50	12.50
M30.0	1.00	15.00
M33.0	1.50	14.50
M36.0	1.00	17.00
M39.0	1.50	16.50
M42.0	2.00	16.00
M45.0	1.00	19.00
M48.0	1.50	18.50
M52.0	2.00	18.00
M56.0	1.00	21.00
M60.0	1.50	20.50
M63.0	2.00	20.00
M66.0	1.00	23.00
M70.0	1.50	22.50
M75.0	1.50	25.50
M80.0	1.50	25.00
M85.0	2.00	23.00
M90.0	1.50	26.50
M95.0	1.50	26.00
M100.0	2.00	30.00
M105.0	2.00	29.00

METRIC (S.S.O.) FINE (continued)		
Nominal Dia. of Thread (mm)	Actual Dia. of Thread (mm)	Tapping Drill Dia. (mm)
M110.0	2.00	33.00
M120.0	2.00	37.00
M130.0	4.00	38.00
M140.0	4.00	41.00
M150.0	4.00	44.00
M160.0	4.00	48.00
M180.0	4.00	52.00
M200.0	4.00	56.00

FLUTELESS		
Nominal Dia. of Thread (mm)	Actual Dia. of Thread (mm)	Tapping Drill Dia. (mm)
M3	2.8	
M3.5	3.2	
M4	3.7	
M5	4.5	
M6	5.5	
M8	7.4	
M10	9.3	
M12	11.1	

UNC (S.S.C.)		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
No.2	1.315	
No.4	2.062	
No.6	3.2	
No.8	3.8	
No.10	4.5	
1/4	5.8	
5/16	7.3	
3/8	8.8	
1/2	11.7	

S.A.		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
25A	4.4	
45A	3.3	
65A	2.6	
85A	2.0	

UNF (S.S.C.)		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
No.4	3.8	
No.6	4.5	
No.8	5.8	
No.10	7.5	
1/4	8.8	
5/16	11.5	
3/8	14.5	
1/2	18.1	

BSF		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
1/4	5.8	
5/16	7.3	
3/8	8.8	

BSW		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
1/8	2.0	
3/16	4.2	
1/4	5.7	
5/16	7.2	
3/8	8.7	

Unified National Coarse (U.N.C.)		
Nominal Dia. of Thread (in)	Pitch (in)	Tapping Drill Dia. (in)
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
9/16"	12	12.20
5/8"	11	13.50
3/4"	10	16.50
7/8"	9	19.50
1"	8	22.25
1.1/8"	7	25.00
1.1/4"	7	28.00
1.3/8"	6	30.75
1.1/2"	5	34.00
1.3/4"	5	38.50
2"	4.5	43.00

Unified National Fine (U.N.F.)		
Nominal Dia. of Thread (in)	Pitch (in)	Tapping Drill Dia. (in)
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	6.30
3/8"	24	8.50
7/16"	20	9.90
1/2"	20	11.50
9/16"	18	12.90
5/8"	18	14.50
3/4"	16	17.50
7/8"	14	20.40
1"	12	23.25
1.1/8"	12	26.50
1.1/4"	12	29.50
1.3/8"	12	32.75
1.1/2"	12	36.00

BRITISH STANDARD WHITFORTH (B.S.W.)		
Nominal Dia. of Thread (in)	Pitch (in)	Tapping Drill Dia. (in)
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
9/16"	12	12.10
5/8"	11	13.50
11/16"	10	15.00
3/4"	10	16.25
7/8"	9	19.25
1"	8	22.00
1.1/8"	7	24.75
1.1/4"	7	28.00
1.1/2"	6	30.50
1.3/4"	5	33.00
2"	4.5	44.50

BRITISH STANDARD PIPE FASTENING (B.S.P.F.) G		
Nominal Dia. of Thread (in)	Pitch (in)	Tapping Drill Dia. (in)
1/8"	28	8.80
1/4"	19	11.80
3/8"	19	15.25
1/2"	14	18.00
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 (in)	Pitch (in)	Tapping Drill Dia. (in)
1/8"	28	8.40
1/4"	19	11.20
3/8"	19	14.75
1/2"	14	18.25
5/8"	14	23.75
1"	11	30.00
1.1/8"	11	36.50
1.1/2"	11	44.50
2"	11	56.00
2.1/2"	11	71.00

BRITISH ASSOCIATION (B.A.)		
Nominal Dia. of Thread (in)	Pitch (in)	Tapping Drill Dia. (in)
No. 0	1.500	5.10
No. 1	0.900	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 (in)	Pitch (in)	Tapping Drill Dia. (in)
1/16"	27	6.30
1/8"	27	8.70
1/4"	18	11.50
3/8"	18	14.50
1/2"	14	18.00
5/8"	14	23.25
1"	11	29.00
1.1/4"	11	36.00
1.1/2"	11	44.00
2"	11	56.00
2.1/2"	11	71.00

Tapping Drill Selector Chart



Machinists Guide For Taps

JS Bruner



Machinists Guide For Taps:

Rogers Machinists Guide William Rogers,1913 *Handbook of Small Tools* ,1908 **American Machinist** ,1917
Illustrated Catalogue of Railway, Steamship, Machinist, Factory, Mill and Electric Supplies Manning, Maxwell & Moore, Inc,1902 **Everybody's Handbook of Machinist's Kinks** ,1925 Monthly Journal of the International Association of Machinists ,1900 Vols 42 57 1930 45 include separately paged reports of secretary treasurer auditor roster of officials and other documents dealing with the activities of the association **Statements Made by the Association of Railway Executives** Association of Railway Executives (U.S.),1920 *Decisions Railway Board of Adjustment* United States Railroad Administration,1919 **Handbook of Small Tools** Erik Oberg,1914 **Machinists' Monthly Journal** ,1916
Greenfield's Pocket Guide for Machinists Greenfield Tap and Die Corporation,1930 American Machinist & Automated Manufacturing ,1924 **Defense Supply Management Handbook** United States. Office of the Assistant Secretary of Defense (Supply and Logistics),1953 **Hendricks' Commercial Register of the United States** ,1911
Manufacturers' Record ,1909 *Transactions of ASME.* ,1889 Catalog Sears, Roebuck and Company,1929
Transactions Australasian Institute of Mining and Metallurgy,1900 American Machinists' Handbook and Dictionary of Shop Terms Fred Herbert Colvin, Frank Arthur Stanley,1940 Transactions of the American Society of Mechanical Engineers American Society of Mechanical Engineers,1889 Vols 2 4 11 62 68 include the Society s Membership list v 55 80 include the Journal of applied mechanics also issued separately as contributions from the Society s Applied Mechanics Division

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web abstract the purpose of this study was to reconceptualize scales of the parenting styles and dimensions questionnaire psdq as a typology based on the parenting styles

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web a self assessment to determine your parenting style based on your feelings and beliefs about sadness fear and anger in yourself and your children the test asks questions

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web the paper analyzes the psychometric properties of the g1 version of the parenting styles and dimensions questionnaire a self report instrument designed to investigate how

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