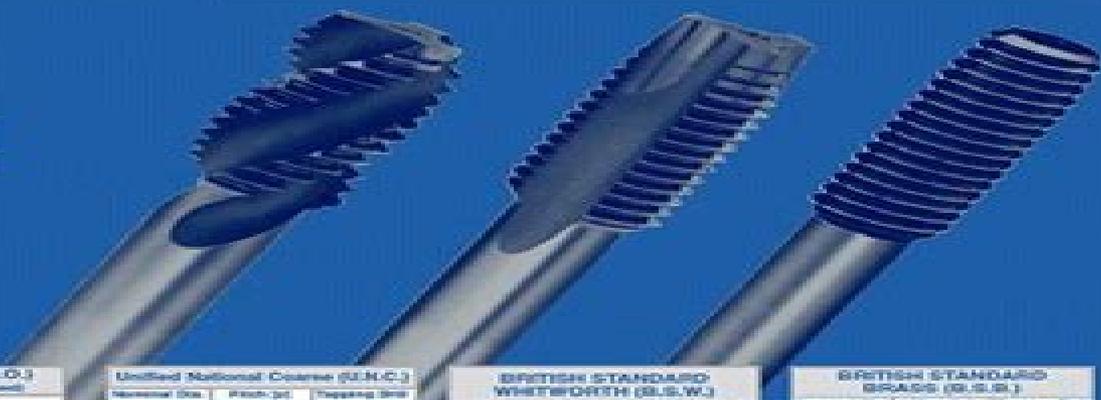


The threading specialists



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	1.25	10.00
M16.0	1.50	10.00
M18.0	1.50	11.00
M20.0	1.50	12.50
M22.0	1.50	13.00
M24.0	1.25	12.50
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	25.50
M85.0	2.00	23.00
M90.0	2.00	26.50
M95.0	1.50	28.50
M100.0	1.50	30.50
M105.0	2.00	31.00

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
M115.0	2.00	36.00
M120.0	2.00	36.00
M125.0	2.00	39.00
M130.0	2.00	42.00
M135.0	2.00	45.00
M140.0	2.00	48.00
M145.0	2.00	51.00
M150.0	2.00	54.00

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	9.5	
M12	11.1	

UNC (S.S.)		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
No.2	1.95	
No.4	2.05	
No.6	3.2	
No.8	3.8	
No.10	4.3	
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.)		
No.	Nominal Dia. of Thread (in)	Tapping Drill Dia. (in)
No.4	3.8	
No.6	3.2	
No.8	3.8	
No.10	4.3	
1/4	5.8	
5/16	7.3	
3/8	8.8	
1/2	12.1	

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	2.9	
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	39.50
2"	4.5	45.00

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"	13	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	39.00
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	8.00
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	12.20
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

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"	11.5	29.00
1.1/4"	11.5	38.00
1.1/2"	11.5	44.00
2"	11.5	58.00
2.1/2"	8	67.00

# Tapping Drill Selector Chart



# Machinists Guide For Taps

**Hongru Du**



## **Machinists Guide For Taps:**

The Top Books of the Year Machinists Guide For Taps The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous engrossing novels enthraling the hearts of readers worldwide. Lets delve into the realm of top-selling books, exploring the engaging narratives that have enthralled audiences this year. The Must-Read : Colleen Hoovers "It Ends with Us" This poignant tale of love, loss, and resilience has gripped readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can triumph. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This intriguing historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids captivating storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Machinists Guide For Taps : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These top-selling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of captivating stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and thrilling novel that will keep you guessing until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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