

METRIC COARSE / METRIC FINE

60° Included Angle (*Fluteless)



Size	Metric Coarse		Metric Coarse		Size	Metric Coarse		Metric Coarse		Size	Metric Coarse		Metric Coarse	
	Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm
1	0.25	0.75 (*0.9)	-	-	16	-	-	1.5	14.5 (*15.3)	39	4	35 (*37)	1.5	37.5
1.1	0.25	0.85	-	-	17	-	-	1.5	15.5	39	-	-	2	37
1.2	0.25	0.95 (*1.1)	-	-	18	2.5	15.5 (*17)	-	17	39	-	-	3	36
1.4	0.3	1.1 (*1.3)	-	-	18	-	-	1.25	16.8	40	-	-	1.5	38.5
1.6	0.35	1.25 (*1.5)	-	-	18	-	-	1.5	16.5 (*17.3)	40	-	-	2	38
1.8	0.35	1.45	-	-	18	-	-	2	16	40	-	-	3	37
2	0.4	1.6 (*1.8)	0.25	1.75	19	-	-	1	19	42	4.5	37.5 (*40)	1.5	40.5
2.2	0.45	1.75	0.25	1.95	20	2.5	17.5 (*18)	1.5	18.5 (*19.3)	42	-	-	2	40
2.5	0.45	2.05 (*2.3)	0.35	2.15	20	-	-	2	18	42	-	-	3	39
3	0.5	2.5 (*2.8)	0.35	2.65	22	2.5	19.5 (*21)	1.5	20.5 (*21.3)	42	-	-	4	38
3.5	0.6	2.9 (*3.2)	0.35	3.15	22	-	-	2	20	45	4.5	40.5 (*43)	1.5	43.5
4	0.7	3.3 (*3.7)	0.5	3.5	24	3	21 (*22.5)	1.5	22.5 (*23.3)	45	-	-	2	43
4.5	0.75	3.7 (*4.2)	0.5	4	24	-	-	2	22	45	-	-	3	42
5	0.8	4.2 (*4.7)	0.5	4.5	25	-	-	1	24	45	-	-	4	41
5.5	-	-	0.75	4.3	25	-	-	1.5	23.5	48	5	43	1.5	46.5
6	1	5 (*5.6)	0.75	5.25	27	3	24 (*25.5)	1.5	25.5	48	-	-	2	46
7	1	6	0.75	6.25	27	-	-	2	25	48	-	-	3	45
8	1.25	6.8 (*7.4)	0.75	7.3	28	-	-	1.5	26.5	48	-	-	4	44
9	1.25	7.8	0.75	8.3	28	-	-	2	26	50	-	-	1.5	48.5
10	1.5	8.5 (*9.3)	0.75	9.3	30	3.5	26.5 (*28.5)	1	29	50	-	-	2	48
11	1.5	9.5	1	10	30	-	-	1.5	28.5	50	-	-	3	47
12	1.75	10.2 (*11.2)	1	11	30	-	-	2	28	52	5	47	1.5	50.5
12	-	-	1.25	10.8 (*11.45)	32	3.5	28.5	1.5	30.5	52	-	-	2	50
12	-	-	1.5	10.5 (*11.3)	32	-	-	2	30	52	-	-	3	49
14	2	12 (*13.1)	-	-	33	3.5	29.5 (*31.5)	1.5	31.5	52	-	-	4	48
14	-	-	1.25	12.75 (*13.4)	33	-	-	2	31	56	5.5	50.5	-	-
14	-	-	1.5	12.5 (*13.3)	35	-	-	1.5	33.5	60	5.5	54.5	-	-
15	-	-	1	14	36	4	32 (*34)	1.5	34.5	64	6	58	-	-
15	-	-	1.5	13.5	36	-	-	2	34	68	6	62	-	-
16	2	14 (*15.1)	1	15	38	-	-	1.5	36.5					

BRITISH STANDARD WHITWORTH / PIPE / BRASS

55° Included Angle

Size	BSW		BSW		BSP		BSPT		BSB	
	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm
1/16	60	1.2	-	-	-	-	-	-	-	-
3/32	48	1.9	-	-	-	-	-	-	-	-
1/8	40	2.55	-	-	28	8.8	28	8.6	-	-
5/32	32	3.2	-	-	-	-	-	-	-	-
3/16	24	3.7	32	4	-	-	-	-	-	-
7/32	24	4.5	28	4.7	-	-	-	-	-	-
1/4	20	5.1	26	5.4	19	11.8	19	11.5	26	5.4
9/32	20	-	26	6.2	-	-	-	-	-	-
5/16	18	6.5	22	6.8	-	-	-	26	7	-
3/8	16	8	20	8.3	19	15.5	19	15	26	8.5
7/16	14	9.3	18	9.8	-	-	14	18.5	26	10.1
1/2	12	10.5	16	11	14	19	14	18.5	26	11.7
9/16	12	12.2	16	12.7	-	-	-	26	-	-
5/8	11	13.5	14	14	14	21	-	26	15	-
11/16	11	15.2	14	15.5	-	-	-	-	-	-
3/4	10	16.5	12	16.5	14	24.5	14	24	26	18
7/8	9	19.5	11	19.5	14	28.5	-	-	-	-
1"	8	22	10	22.5	11	31	11	30.25	26	24.5
1.1/8	7	25	9	25.5	-	-	11	39	-	-
1.1/4	7	28	9	29	11	40	11	39	-	-
1.3/8	6	-	8	31.8	-	-	-	-	-	-
1.1/2	6	34	8	34.5	11	45.5	11	45	-	-
1.5/8	6	-	8	38	-	-	-	-	-	-
1.3/4	5	39	7	41	11	51.5	-	-	-	-
2"	4	45	7	47	11	57	11	56.5	-	-
2.1/4	4	51	6	53	11	63.3	-	-	-	-
2.1/2	4	57	6	59	11	72.8	-	-	-	-
2.3/4	3.5	63	6	66	-	-	-	-	-	-
3"	3.5	69	5	71	11	85.5	-	-	-	-
3.1/4	3.25	75	5	77	-	-	-	-	-	-
3.1/2	3.25	81	4.5	83	-	-	-	-	-	-
3.3/4	3	87	4.5	90	-	-	-	-	-	-
4"	3	93	4.5	96	-	-	-	-	-	-

UNIFIED NATIONAL / NATIONAL PIPE

60° Included Angle

Size	Nom. Dia.	UNC		UNF		NPS		NPT	
		TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm
No.1	1.85	64	1.55	72	1.55	-	-	-	-
No.2	2.18	56	1.85	64	1.9	-	-	-	-
No.3	2.51	48	1.86	56	2.1	-	-	-	-
No.4	2.84	40	2.25	48	2.35	-	-	-	-
No.5	3.18	40	2.6	46	2.65	-	-	-	-
No.6	3.51	32	2.75	40	2.9	-	-	-	-
No.8	4.17	32	3.4	36	3.5	-	-	-	-
No.10	4.83	24	3.8	32	4.1	-	-	-	-
No.12	5.49	24	4.4	28	4.6	-	-	-	-
1/8	-	-	-	-	-	27	9.1	27	8.4
1/4	-	20	5.1	28	5.5	18	12	18	11
5/16	-	18	6.6	24	6.9	-	-	-	-
3/8	-	16	8	24	8.5	18	15.5	18	14.25
7/16	-	14	9.4	20	9.8	-	-	-	-
1/2	-	13	10.8	20	11.5	14	19	14	17.5
9/16	-	12	12.2	18	12.8	-	-	-	-
5/8	-	11	13.5	18	14.5	-	-	-	-
3/4	-	10	16.5	16	17.5	14	24.5	14	23
7/8	-	9	19.5	14	20.5	-	-	-	-
1"	-	8	22	12	23.5	11.5	30.5	11.5	29
1.1/8	-	7	25	12	26.5	-	-	-	-
1.1/4	-	7	28	12	29.5	11.5	39.4	11.5	37.5
1.3/8	-	6	31	12	32.5	-	-	-	-
1.1/2	-	6	34	12	36	11.5	45.5	11.5	43.5
1.3/4	-	5	39	-	-	-	-	-	-
2"	-	4.5	45	-	-	11.5	57.5	11.5	55.5

BRITISH ASSOCIATION

47½° Included Angle

Size	Nom. Dia.	TPI	Drill Size in mm	Size	Nom. Dia.	TPI	Drill Size in mm
No.12	1.3	90.1	1.05	No.5	3.2	43.1	2.65
No.10	1.7	72.6	1.4	No.4	3.6	38.3	3
No.9	1.9	65.1	1.55	No.3	4.1	34.8	3.4
No.8	2.2	59.1	1.8	No.2	4.7	31.3	3.9
No.7	2.5	52.9	2.05	No.1	5.3	28.2	4.5
No.6	2.8	47.9	2.3	No.0	6	25.4	5.1