



135° SPLIT POINT
CUTS FASTER AND
REDUCES WANDERING

FULLY GROUND M2 HSS
INCREASES DRILL LIFE

TITANIUM NITRIDE COATING
REDUCES HEAT AND
INCREASES LUBRICITY FOR
EXTENDED LIFE

MADE IN EUROPE

PRECISION MANUFACTURED
TO I.S.O. & D.I.N. STANDARDS

TAPPING CHART

M | MF | UNC | UNF | UNEF | 8UN | BSW | Rc (BSPT) | BSF | BA | BSB | Rp (BSPL) | NPT-NPTF | NPSF | Pg

M ISO METRIC COARSE (60°)		
TAP SIZE	PITCH MM	TAPPING DRILL
M1.6	0.35	1.25
M2	0.4	1.6
M2.5	0.45	2.05
M3	0.5	2.5
M3.5	0.6	2.9
M4	0.7	3.3
M4.5	0.75	3.7
M5	0.8	4.2
M6	1.0	5.0
M8	1.25	6.8
M10	1.5	8.5
M12	1.75	10.2
M14	2.0	12.0
M16	2.0	14.0
M18	2.5	15.5
M20	2.5	17.5
M22	2.5	19.5
M24	3.0	21.0
M27	3.0	24.0
M30	3.5	26.5
M33	3.5	29.5
M36	4.0	32.0
M42	4.5	37.5
M45	4.5	40.5
M48	5.0	43.0
M52	5.0	47.0
M56	5.5	50.5

BSW BRITISH STANDARD WHITWORTH (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL
1/16"	60	1.2
3/32"	48	1.85
1/8"	40	2.55
5/32"	32	3.2
3/16"	24	3.7
7/32"	24	4.5
1/4"	20	5.1
5/16"	18	6.5
3/8"	16	7.9
7/16"	14	9.3
1/2"	12	10.5
9/16"	12	12.1
5/8"	11	13.5
3/4"	10	16.25
7/8"	9	19.25
1"	8	22.0
1 - 1/8"	7	24.75
1 - 1/4"	7	28.0
1 - 1/2"	6	33.5
1 - 3/4"	5	39.0
2"	4 - 1/2	44.5

Pg STEEL CONDUIT (80°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
Pg7	20	11.3
Pg9	18	13.9
Pg11	18	17.3
Pg13.5	18	19.1
Pg16	18	21.2
Pg21	15	26.8

MF ISO METRIC FINE (60°)		
TAP SIZE	PITCH MM	TAPPING DRILL
M4	0.5	3.5
M5	0.5	4.5
M6	0.75	5.3
M8	1.0	7.0
M10*	1.0	9.0
M10	1.25	8.8
M12*	1.25	10.8
M12	1.5	10.5
M14*	1.25	12.8
M14	1.5	12.5
M16*	1.5	14.5
M18*	1.5	16.5
M20*	1.5	18.5
M22	1.5	20.5
M24	2.0	22.0
M25*	1.5	23.5
M32*	1.5	30.5
M40*	1.5	38.5
M50*	1.5	48.5

* Metric Conduit
* Spark Plug

Rc (BSPT) ISO Rc TAPER SERIES 1:16 (55°)			
TAP SIZE	T.P.I.	DRILL ONLY*	DRILL & REAMER
Rc 1/16"	28	6.4	6.2
Rc 1/8"	28	8.4	8.4
Rc 1/4"	19	11.2	10.8
Rc 3/8"	19	14.75	14.5
Rc 1/2"	14	18.25	18.0
Rc 3/4"	14	23.75	23.0
Rc 1"	11	30.0	29.0
Rc 1 - 1/4"	11	38.5	38.0
Rc 1 - 1/2"	11	44.5	44.0
Rc 2"	11	56.0	55.0

BSF BRITISH STANDARD FINE (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
3/16"	32	4.0
7/32"	28	4.6
1/4"	26	5.3
5/16"	22	6.8
3/8"	20	8.3
7/16"	18	9.8
1/2"	16	11.0
9/16"	16	12.7
5/8"	14	14.0
11/16"	14	15.5
3/4"	12	16.75
7/8"	11	19.75
1"	10	22.75
1 - 1/8"	9	25.5
1 - 1/4"	9	28.5
1 - 1/2"	8	34.5
1 - 3/4"	7	41.0

NPSF NATIONAL PIPE STRAIGHT (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/8"	27	8.6
1/4"	18	11.3
3/8"	18	14.5
1/2"	14	18.0

UNF UNIFIED NATIONAL FINE (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL
#3 (.099)	56	2.1
#4 (.112)	48	2.35
#5 (.125)	44	2.65
#6 (.138)	40	2.9
#8 (.164)	36	3.5
#10 (.190)	32	4.1
#12 (.216)	28	4.6
3/16"	32	4.0
1/4"	28	5.5
5/16"	24	6.9
3/8"	24	8.5
7/16"	20	9.8
1/2"	20	11.5
9/16"	18	12.8
5/8"	18	14.5
3/4"	16	17.5
7/8"	14	20.5
1"	12	23.5
1*	14	24.0
1 - 1/8"	12	26.5
1 - 1/4"	12	29.5
1 - 3/8"	12	33.01
1 - 1/2"	12	36.0

NPT-NPTF NATIONAL PIPE TAPER 1:16 (60°)			
TAP SIZE	T.P.I.	DRILL ONLY*	DRILL & REAMER
1/16"	27	6.3	6.0
1/8"	27	8.5	8.2
1/4"	18	11.0	10.8
3/8"	18	14.5	14.0
1/2"	14	18.0	17.5
3/4"	14	23.0	23.0
1"	11 - 1/2	29.0	28.5
1 - 1/4"	11 - 1/2	37.5	37.0
1 - 1/2"	11 - 1/2	44	43.5
2"	11 - 1/2	55.5	55.0

8UN (8 TPI) UNIFIED NATIONAL FORM (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1 - 1/8"	8	25.5
1 - 1/4"	8	28.5
1 - 3/8"	8	31.75
1 - 1/2"	8	35.0
1 - 5/8"	8	38.0
1 - 3/4"	8	41.5
1 - 7/8"	8	44.5
2"	8	47.5

UNEF UNIFIED NATIONAL FORM (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/4"	32	5.6
5/16"	32	7.2
3/8"	32	8.8
1/2"	28	11.8
5/8"	24	14.75
3/4"	20	18
1"	20	24.2

UNC UNIFIED NATIONAL COARSE (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL
#2 (.086)	56	1.85
#3 (.099)	48	2.1
#4 (.112)	40	2.3
#5 (.125)	40	2.6
#6 (.138)	32	2.8
#8 (.164)	32	3.4
#10 (.190)	24	3.8
#12 (.216)	24	4.5
1/4"	20	5.1
5/16"	18	6.6
3/8"	16	8.0
7/16"	14	9.4
1/2"	13	10.8
9/16"	12	12.2
5/8"	11	13.5
3/4"	10	16.5
7/8"	9	19.5
1"	8	22.2
1 - 1/8"	7	25.0
1 - 1/4"	7	28.0
1 - 3/8"	6	31.0
1 - 1/2"	6	34.0
1 - 3/4"	5	39.5
2"	4.5	45.0

BA (47.5°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
0	1	5.1
1	0.9	4.5
2	0.81	4.0
3	0.73	3.4
4	0.66	3.0
5	0.59	2.65
6	0.53	2.3
7	0.48	2.05
8	0.43	1.8
9	0.39	1.55
10	0.35	1.4
11	0.31	1.2
12	0.28	1.05
13	0.25	0.98
14	0.23	0.8
15	0.21	0.7
16	0.19	0.6

BSB BRITISH STANDARD BRASS (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/4"	26	5.2
5/16"	26	6.8
3/8"	26	8.4
7/16"	26	10.0
1/2"	26	11.6
9/16"	26	13.2
5/8"	26	14.8
3/4"	26	18.0
7/8"	26	20.8
1"	26	24.3

Rp (BSPL) SEALING PIPE THREAD PARALLEL (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
Rp 1/8"	28	8.6
Rp 1/4"	19	11.5
Rp 3/8"	19	15.0
Rp 1/2"	14	18.5
Rp 3/4"	14	24.0
Rp 1"	11	30.2
Rp 1 - 1/4"	11	39.0
Rp 1 - 1/2"	11	45.0
Rp 2"	11	56.4

THREAD FORMING (FLUTELESS TAPS)		
TAP SIZE	T.P.I.	TAPPING DRILL
METRIC COARSE		
M1	0.25	0.9
M1.1	0.25	1.0
M1.2	0.25	1.1
M1.4	0.3	1.28
M1.6	0.35	1.45
M1.7	0.35	1.55
M1.8	0.35	1.65
M2	0.4	1.8
M2.2	0.45	2.0
M2.3	0.4	2.1
M2.5	0.45	2.3
M2.6	0.45	2.4
M3	0.5	2.8
M3.5	0.6	3.2
M4	0.7	3.7
M5	0.8	4.6
M6	1.0	5.5
M8	1.25	7.4
M10	1.5	9.3
M12	1.75	11.2
BSW		
1/8"	40	2.9
5/32"	32	3.6
3/16"	24	4.3
1/4"	20	5.8
5/16"	18	7.3
3/8"	16	8.8
UNC		
#1 (.073)	64	1.7
#2 (.086)	56	2.0
#3 (.099)	48	2.3
#4 (.112)	40	2.6
#5 (.125)	40	2.9
#6 (.138)	32	3.2
#8 (.164)	32	3.8
#10 (.190)	24	4.4
#12 (.216)	24	5.0
1/4"	20	5.8
5/16"	18	7.3
3/8"	16	8.8
7/16"	14	10.2
1/2"	13	11.7
UNF		
#1 (.073)	72	1.7
#2 (.086)	64	2.0
#3 (.099)	56	2.3
#4 (.112)	48	2.6
#5 (.125)	44	2.9
#6 (.138)	40	3.2
#8 (.164)	36	3.9
#10 (.190)	32	4.5
#12 (.216)	28	5.1
1/4"	28	6.0
5/16"	24	7.5
3/8"	24	9.0
7/16"	20	10.6
1/2"	20	12.1
G (BSPF)		
1/8"	28	9.25
1/4"	19	12.5
3/8"	19	16.0
1/2"	14	20.0
5/8"	14	22.0
3/4"	14	25.5
7/8"	14	29.25
1"	11	32.0



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