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		Metr
Nominal Diameter	Pitches mm.	Drill Sizes for Taps mm.
M2	0.25 0.40	1.75 1.6
M2.2	0.25 0.45	1.95 1.75
M2.5	0.35 0.45	2.15 2.05
М3	0.35 0.50	2.65 2.50
M3.5	0.35 0.60	3.15 2.90
M4	0.50 0.70	3.50 3.30
M4.5	0.50 0.75	4.0 3.7
M5	0.5 0.8	4.5 4.2
M6	0.75 1.0	5.2 5.0
M7	0.75 1.0	6.2 6.0
M8	0.75 1.0 1.25	7.2 7.0 6.8
M9	0.75 1.0 1.25	8.2 8.0 7.8
M10	1.0 1.25 1.5	9.0 8.8 8.5
M11	1.0 1.5	10 9.5
M12	1.00 1.25 1.50 1.75	11.0 10.8 10.5 10.2
M14	1.0 1.25 1.50 2.0	13.0 12.8 12.5 12.0
M16	1.0 1.5 2.0	15.0 14.5 14.0
M18	1.0 1.5 2.0 2.5	17.0 16.5 16.0 15.5
M20	1.0 1.5 2.0 2.5	19.0 18.5 18.0 17.5

Mominal Diameter M22 M24 M25 M27 M28 M30	Pitches mm. 1.0 1.5 2.0 2.5 1.0 1.5 2.0 3.0 1.5 2.0 3.0 1.5 2.0 1.5 3.0	Drill Sizes for Taps mm. 21.0 20.5 20.0 19.5 23.0 22.5 22.0 21.0 23.5 23.0 25.5 24.0
M24 M25 M27 M28	1.5 2.0 2.5 1.0 1.5 2.0 3.0 1.5 2.0 1.5 3.0	20.5 20.0 19.5 23.0 22.5 22.0 21.0 23.5 23.0 25.5 24.0
M25 M27 M28	2.0 2.5 1.0 1.5 2.0 3.0 1.5 2.0 1.5 3.0	20.0 19.5 23.0 22.5 22.0 21.0 23.5 23.0 25.5 24.0
M25 M27 M28	2.5 1.0 1.5 2.0 3.0 1.5 2.0 1.5 3.0	23.0 22.5 22.0 21.0 23.5 23.0 25.5 24.0
M25 M27 M28	1.0 1.5 2.0 3.0 1.5 2.0 1.5 3.0	23.0 22.5 22.0 21.0 23.5 23.0 25.5 24.0
M25 M27 M28	1.5 2.0 3.0 1.5 2.0 1.5 3.0	22.5 22.0 21.0 23.5 23.0 25.5 24.0
M25 M27 M28	1.5 2.0 3.0 1.5 2.0 1.5 3.0	22.5 22.0 21.0 23.5 23.0 25.5 24.0
M27 M28	3.0 1.5 2.0 1.5 3.0	21.0 23.5 23.0 25.5 24.0
M27 M28	1.5 2.0 1.5 3.0	23.5 23.0 25.5 24.0
M27 M28	2.0 1.5 3.0 1.5	23.0 25.5 24.0
M27 M28	2.0 1.5 3.0 1.5	23.0 25.5 24.0
M28	1.5 3.0 1.5	25.5 24.0
M28	3.0	24.0
7011500	1.5	
7011500	W. W. S.	26.5
M30	1.5	
	1.0	28.5
	3.5	26.5
M32	1.5	30.5
M33	2.0	31.0
	3.5	29.5
M36	3.0	33
14130	4.0	32
	000-	
M39	3.0	36
	4.0	35
M42	4.0	38.0
	4.5	37.5
M45	4.0	41.0
M45		40.5
M48		44
	5.0	43
M52	4.0	48
	5.0	47
M54	4.0	52.0
14130		50.5
1/1/2/2	10000	
M60		56.0 54.5
	M48 M52 M56 M60	M45 4.0 4.5 M48 4.0 5.0 M52 4.0 5.0 M56 4.0 5.5



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U.N.F.		
Nominal dia.	T.P.I.	Tap drill sizes mm
No. 0	80	1.25
No. 1	72	1.55
No. 2	64	1.9
No. 3	56	2.15
No. 4	48	2.4
No. 5	44	2.7
No. 6	40	2.95
No. 8	36	3.5
No. 10	32	4.1
No. 12	28	4.7
1/4"	28	5.5
5/16"	24	6.9
3/8"	24	8.5
7/16"	20	9.9
1/2"	20	11.5
9/16"	18	12.9
5/8"	18	14.5
3/4"	16	17.5
7/8"	14	20.4
1"	12	23.25
1.1/8"	12	26.5
1.1/4"	12	29.5
1.3/8"	12	32.75
1.1/2"	12	36.0

B.S.F.		
Nominal dia.	T.P.I.	Tap drill sizes mm
3/16"	32	4.0
7/32"	28	4.6
1/4"	26	5.3
9/32"	26	6.1
5/16"	22	6.8
3/8"	20	8.3
7/16"	18	9.7
1/2"	16	11.1
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
1.3/8"	8	31.5
1.1/2"	8	34.5

U.N.C.		
Nominal dia.	T.P.I.	Tap drill sizes mm
No. 1	64	1.55
No. 2	56	1,85
No. 3	48	2.1
No. 4	40	2.35
No. 5	40	2.65
No. 6	32	2.85
No. 8	32	3.5
No. 10	24	3.9
No. 12	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	22.25
1.1/8"	7	25.0
1.1/4"	7	28.0
1.3/8"	6	30.75
1.1/2"	6	34.0
1.3/4"	5	39.5
2"	4.5	45.0

B.S.W.		
Nominal dia.	T.P.I.	Tap drill sizes mm.
1/8"	40	2.55
3/16"	24	3.7
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
11/16"	11	15.0
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"	4.5	44.5