

Metric Coarse (ISO M)				
Thread	Pitch	Tap mm	Form mm	Clear mm
M1	0.25	0.75	0.9	1.2
M1.2	0.25	0.95	1.1	1.4
M1.4	0.3	1.1	1.25	1.6
M1.6	0.35	1.25	1.45	1.8
M1.8	0.35	1.45	1.65	2.1
M2	0.4	1.6	1.8	2.4
M2.2	0.45	1.75	2	2.6
M2.5	0.45	2.05	2.3	2.9
M3	0.5	2.5	2.8	3.4
M3.5	0.6	2.9	3.25	3.9
M4	0.7	3.3	3.7	4.5
M4.5	0.75	3.75	4.15	5
M5	0.8	4.2	4.65	5.5
M6	1	5	5.55	6.6
M7	1	6	6.55	7.6
M8	1.25	6.75	7.45	9
M9	1.25	7.75	8.45	10
M10	1.5	8.5	9.35	11
M11	1.5	9.5	10.35	12
M12	1.75	10.25	11.25	13.5
M14	2	12	13.1	15.5
M16	2	14	15.1	17.5
M18	2.5	15.5	16.9	20
M20	2.5	17.5	18.9	22
M22	2.5	19.5	20.9	24
M24	3	21	22.65	26
M27	3	24	25.65	30
M30	3.5	26.5	28.45	33
M33	3.5	29.5	31.45	36
M36	4	32	34.25	39

Metric Coarse (ISO M) (cont.)				
Thread	Pitch	Tap mm	Form mm	Clear mm
M39	4	35	37.25	42
M42	4.5	37.5	40	45
M45	4.5	40.5	43	48
M48	5	43	45.8	52
M52	5	47	49.8	56
M56	5.5	50.5	53.55	62
M60	5.5	54.5	57.55	66
M64	6	58	61.35	70

Metric Fine (ISO MF)				
Thread	Pitch	Tap mm	Form mm	Clear mm
M6x0.75	0.75	5.25	5.65	6.6
M8x1	1	7	7.55	9
M8x0.75	0.75	7.25	7.65	9
M10x1.25	1.25	8.75	9.45	11
M10x1	1	9	9.55	11
M10x0.75	0.75	9.25	9.65	11
M12x1.5	1.5	10.5	11.35	13.5
M12x1.25	1.25	10.75	11.45	13.5
M12x1	1	11	11.55	13.5
M14x1.5	1.5	12.5	13.35	15.5
M16x1.5	1.5	14.5	15.35	17.5
M18x1.5	1.5	16.5	17.35	20
M20x1.5	1.5	18.5	19.35	22
M22x1.5	1.5	20.5	21.35	24
M24x2	2	22	23.1	26
M24x1.5	1.5	22.5	23.35	26
M27x2	2	25	26.1	30
M30x2	2	28	29.1	33
M30x1.5	1.5	28.5	29.35	33

BSW (British Standard Whitworth)				
Thread	TPI	Tap mm	Clear	mm
1/8"	40	2.5	#28	3.57
3/16"	24	3.6	#7	5.11
1/4"	20	5.1	H	6.76
5/16"	18	6.5	Q	8.43
3/8"	16	7.9	X	10.08
7/16"	14	9.3	15/32"	11.91
1/2"	12	10.5	17/32"	13.49
9/16"	12	12.1	39/64"	15.48
5/8"	11	13.5	43/64"	17.07
3/4"	10	16.5	13/16"	20.64
7/8"	9	19.25	29/32"	23.02
1"	8	22	1.1/32"	26.19
1.1/8"	7	24.75	1.5/32"	29.37
1.1/4"	7	27.75	1.9/32"	32.54
1.1/2"	6	33.5	1.17/32"	38.89
1.3/4"	5	39	1.25/32"	45.24
2"	4.1/2	44.5	2.1/32"	51.59

BSF (British Standard Fine)				
Thread	TPI	Tap mm	Clear	mm
3/16"	32	4	#7	5.11
7/32"	28	4.6	A	5.94
1/4"	26	5.3	H	6.76
9/32"	26	6.1	19/64"	7.54
5/16"	22	6.8	Q	8.43
3/8"	20	8.3	X	10.08
7/16"	18	9.7	15/32"	11.91
1/2"	16	11.1	17/32"	13.49
9/16"	16	12.7	39/64"	15.48
5/8"	14	14	43/64"	17.07
11/16"	14	15.5	23/32"	18.26
3/4"	12	16.75	13/16"	20.64
7/8"	11	19.75	29/32"	23.02
1"	10	22.75	1.1/32"	26.19
1.1/8"	9	25.75	1.5/32"	29.37
1.1/4"	9	28.75	1.9/32"	32.54
1.1/2"	8	34.5	1.17/32"	38.89

BA (British Association)			
Thread	Pitch	Tap mm	Clear mm
0BA	1.00	5.1	6.1
1BA	0.90	4.5	5.4
2BA	0.81	4	4.8
3BA	0.73	3.4	4.2
4BA	0.66	3	3.7
5BA	0.59	2.65	3.3
6BA	0.53	2.3	2.9
7BA	0.48	2.05	2.6
8BA	0.43	1.8	2.25
9BA	0.39	1.55	1.95
10BA	0.35	1.4	1.75

BSP / BSPP (G, parallel pipe)		
Thread	TPI	Tap mm
1/8"	28	8.8
1/4"	19	11.8
3/8"	19	15.25
1/2"	14	19
5/8"	14	21
3/4"	14	24.5
7/8"	14	28.25
1"	11	30.75
1.1/4"	11	39.5
1.1/2"	11	45.25
2"	11	57

BSPT (R / Rc, taper pipe)		
Thread	TPI	Tap mm
1/8"	28	8.4
1/4"	19	11.2
3/8"	19	14.75
1/2"	14	18.25
3/4"	14	23.75
1"	11	30
1.1/4"	11	38.5
1.1/2"	11	44.5
2"	11	56

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UNC (Unified Coarse)						
Thread	TPI	Tap	mm	Form	Clear	mm
#1	64	#53	1.51	1.70	#46	2.06
#2	56	#50	1.78	2.00	#41	2.44
#3	48	#47	1.99	2.30	#35	2.79
#4	40	#43	2.26	2.55	#30	3.26
#5	40	#38	2.58	2.90	#29	3.45
#6	32	#36	2.71	3.15	#25	3.80
#8	32	#29	3.45	3.80	#16	4.50
#10	24	#25	3.80	4.35	#7	5.11
#12	24	#16	4.50	5.00	#1	5.79
1/4"	20	#7	5.11	5.80	H	6.76
5/16"	18	F	6.53	7.30	Q	8.43
3/8"	16	5/16"	7.94	8.80	X	10.08
7/16"	14	U	9.35	10.30	15/32"	11.91
1/2"	13	27/64"	10.72	11.85	17/32"	13.49
9/16"	12	31/64"	12.30	13.35	39/64"	15.48
5/8"	11	17/32"	13.49	14.85	43/64"	17.07
3/4"	10	21/32"	16.67	17.95	13/16"	20.64
7/8"	9	49/64"	19.45	21.00	29/32"	23.02
1"	8	7/8"	22.22	24.00	1.1/32"	26.19
1.1/8"	7	63/64"	25.00	26.95	1.5/32"	29.37
1.1/4"	7	1.7/64"	28.18	30.15	1.9/32"	32.54
1.3/8"	6	1.7/32"	30.96	33.05	1.13/32"	35.72
1.1/2"	6	1.11/32"	34.13	36.25	1.17/32"	38.89
1.3/4"	5	1.9/16"	39.69	42.20	1.25/32"	45.24
2"	4.1/2	1.25/32"	45.24	48.30	2.1/32"	51.59

UNF (Unified Fine)						
Thread	TPI	Tap	mm	Form	Clear	mm
#0	80	3/64"	1.19	1.40	#50	1.78
#1	72	#53	1.51	1.70	#46	2.06
#2	64	#50	1.78	2.00	#41	2.44
#3	56	#45	2.08	2.30	#35	2.79
#4	48	#42	2.37	2.60	#30	3.26
#5	44	#37	2.64	2.90	#29	3.45
#6	40	#33	2.87	3.20	#25	3.80
#8	36	#29	3.45	3.85	#16	4.50
#10	32	#21	4.04	4.50	#7	5.11
#12	28	#14	4.62	5.10	#1	5.79
1/4"	28	#3	5.41	5.95	H	6.76

UNF (Unified Fine) (cont.)						
Thread	TPI	Tap	mm	Form	Clear	mm
5/16"	24	I	6.91	7.45	Q	8.43
3/8"	24	Q	8.43	9.05	X	10.08
7/16"	20	25/64"	9.92	10.55	15/32"	11.91
1/2"	20	29/64"	11.51	12.15	17/32"	13.49
9/16"	18	33/64"	13.10	13.65	39/64"	15.48
5/8"	18	37/64"	14.68	15.25	43/64"	17.07
3/4"	16	11/16"	17.46	18.35	13/16"	20.64
7/8"	14	13/16"	20.64	21.40	29/32"	23.02
1"	12	59/64"	23.42	24.45	1.1/32"	26.19
1.1/8"	12	1.3/64"	26.59	27.65	1.5/32"	29.37
1.1/4"	12	1.11/64"	29.77	30.80	1.9/32"	32.54
1.3/8"	12	1.19/64"	32.94	34.00	1.13/32"	35.72
1.1/2"	12	1.27/64"	36.12	37.15	1.17/32"	38.89

NPT (American taper pipe)			
Thread	TPI	Tap	mm
1/16"	27	D	6.25
1/8"	27	R	8.61
1/4"	18	7/16"	11.11
3/8"	18	37/64"	14.68
1/2"	14	23/32"	18.26
3/4"	14	59/64"	23.42
1"	11.1/2	1.5/32"	29.37
1.1/4"	11.1/2	1.1/2"	38.10
1.1/2"	11.1/2	1.47/64"	44.05
2"	11.1/2	2.7/32"	56.36

NPS (American straight pipe, NPSM)			
Thread	TPI	Tap	mm
1/8"	27	S	8.84
1/4"	18	29/64"	11.51
3/8"	18	19/32"	15.08
1/2"	14	47/64"	18.65
3/4"	14	15/16"	23.81
1"	11.1/2	1.3/16"	30.16
1.1/4"	11.1/2	1.33/64"	38.50
1.1/2"	11.1/2	1.3/4"	44.45
2"	11.1/2	2.7/32"	56.36