

Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

M



METRIC
METRIKA

According to
DIN 13 & DIN-ISO 965-1

shaping your dreams

		
M 1	0,25	0,75
M 1,1	0,25	0,85
M 1,2	0,25	0,95
M 1,4	0,3	1,1
M 1,6	0,35	1,25
M 1,7	0,35	1,35
M 1,8	0,35	1,45
M 2	0,4	1,6
M 2,2	0,45	1,75
M 2,3	0,4	1,85
M 2,5	0,45	2,05
M 2,6	0,45	2,15
M 3	0,5	2,5
M 3,5	0,6	2,9
M 4	0,7	3,3

		
M 4,5	0,75	3,7
M 5	0,8	4,2
M 5,5	0,9	4,6
M 6	1	5
M 7	1	6
M 8	1,25	6,8
M 9	1,25	7,8
M 10	1,5	8,5
M 11	1,5	9,5
M 12	1,75	10,2
M 14	2	12
M 16	2	14
M 18	2,5	15,5
M 20	2,5	17,5
M 22	2,5	19,5

		
M 24	3	21
M 27	3	24
M 30	3,5	26,5
M 33	3,5	29,5
M 36	4	32
M 39	4	35
M 42	4,5	37,5
M 45	4,5	40,5
M 48	5	43
M 52	5	47
M 56	5,5	50,5
M 60	5,5	54,5
M 64	6	58
M 68	6	62



Complete Chart

Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

MF



According to
DIN 13 & DIN-ISO 965-1

		
MF 2	0,25	1,75
MF 2,2	0,25	1,95
MF 2,3	0,25	2,05
MF 2,5	0,35	2,15
MF 2,6	0,35	2,25
MF 3	0,25	2,75
MF 3	0,35	2,65
MF 3,5	0,35	3,15
MF 4	0,35	3,65
MF 4	0,5	3,5
MF 4,5	0,5	4
MF 5	0,5	4,5
MF 6	0,5	5,5
MF 6	0,75	5,25
MF 7	0,5	6,5
MF 7	0,75	6,25
MF 8	0,5	7,5
MF 8	0,75	7,25
MF 8	1	7
MF 9	1	8
MF 10	0,5	9,5
MF 10	0,75	9,25

		
MF 10	1	9
MF 10	1,25	8,75
MF 11	1	10
MF 12	0,5	11,5
MF 12	1	11
MF 12	1,25	10,75
MF 12	1,5	10,5
MF 13	1	12
MF 14	0,75	13,2
MF 14	1	13
MF 14	1,25	12,75
MF 14	1,5	12,5
MF 15	1	14
MF 15	1,5	13,5
MF 16	0,75	15,2
MF 16	1	15
MF 16	1,25	14,8
MF 16	1,5	14,5
MF 18	1	17
MF 18	1,5	16,5
MF 18	2	16
MF 20	1	19

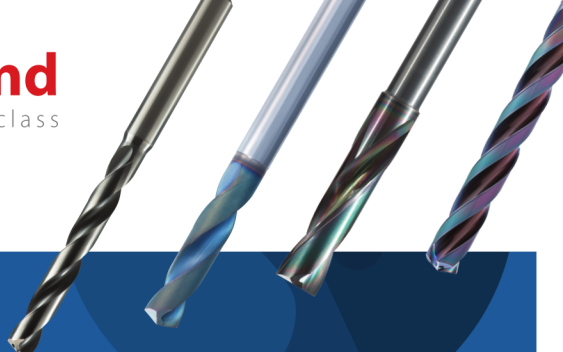
METRIC FINE

ΜΕΤΡΙΚΑ ΨΙΛΟΠΑΣΑ

		
MF 20	1,5	18,5
MF 20	2	18
MF 22	1	21
MF 22	1,5	20,5
MF 22	2	20
MF 24	1	23
MF 24	1,5	22,5
MF 24	2	22
MF 25	1	23
MF 25	1,5	23,5
MF 26	1,5	24,5
MF 27	1	26
MF 27	1,5	25,5
MF 27	2	25
MF 28	1,5	26,5
MF 28	2	26
MF 30	1	29
MF 30	1,5	28,5
MF 30	2	28



Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

UN

According to
ASME B 1.1



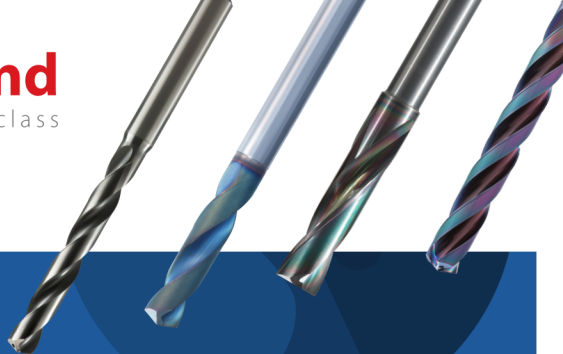
shaping your dreams

UN

ΑΜΕΡΙΚΑΝΙΚΗ ΙΝΤΣΑ

[illegible][illegible][illegible]

Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS



According to
ASME B 1.1

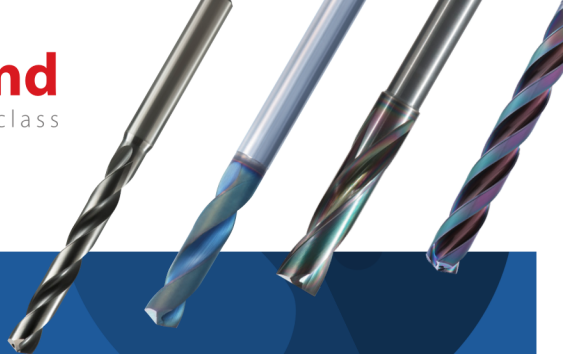
UNC

ΑΜΕΡΙΚΑΝΙΚΗ ΙΝΤΣΑ COARSE - ΧΟΝΤΡΟ ΠΑΣΟ

shaping your dreams

[illegible]

Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

UNF

According to
ASME B 1.1



shaping your dreams

UNF

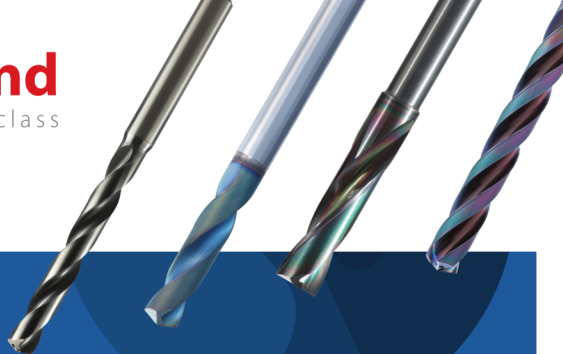
ΑΜΕΡΙΚΑΝΙΚΗ ΙΝΤΣΑ ΨΙΛΟΠΑΣΑ

[illegible][illegible][illegible]

Complete Chart

Recommended drill sizes for tapping

Recommended drill sizes for tapping



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

G

According to
DIN EN ISO 228



shaping your dreams

G

**ΙΝΤΣΑΣ
ΣΩΛΗΝΟΣ**

[illegible][illegible][illegible]

Complete Chart

Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

NPT

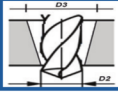


NPT

INTΣΑΣ
ΣΩΛΗΝΟΣ ΚΩΝΙΚΑ

According to
ASME B1.20.1 TAPER 1:16

shaping your dreams

					
1/16	27	6,15	5,95	6,39	10,70
1/8	27	8,40	8,31	8,74	10,80
1/4	18	11,10	10,73	11,36	15,60
3/8	18	14,30	14,15	14,80	16,00
1/2	14	17,90	17,47	18,32	20,80
3/4	14	23,30	22,79	23,67	21,30
1	11 1/2	29,00	28,64	29,69	25,60
1 1/4	11 1/2	37,70	37,37	38,45	26,10
1 1/2	11 1/2	43,70	43,44	44,52	26,10
2	11 1/2	55,60	55,45	56,56	26,50
2 1/2	8	66,30	66,14	67,62	36,30
3	8	82,30	81,90	83,52	38,50



Complete Chart

Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

Rc
(PT)

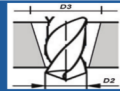


Rc (PT)

ΙΝΤΕΑΣ
ΣΩΛΗΝΟΣ ΚΩΝΙΚΑ

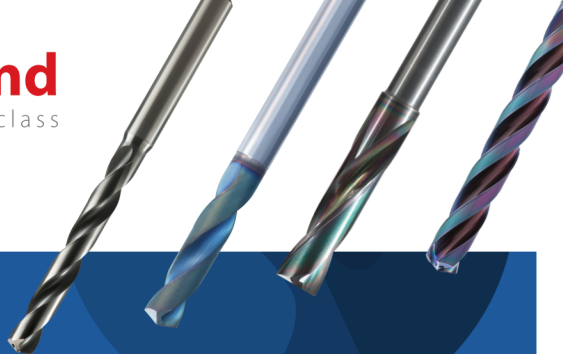
According to
DIN EN 10226-2 TAPER 1/16

shaping your dreams

			A	B min	
1/16	28	6,30	6,49	8,31	10,00
1/8	28	8,30	8,50	8,31	10,10
1/4	19	11,00	11,35	12,37	15,00
3/8	19	14,50	14,85	12,77	15,40
1/2	14	18,10	18,49	16,83	20,50
3/4	14	23,50	23,98	18,13	21,80
1	11	29,60	30,11	21,42	26,00
1 1/4	11	38,10	38,78	23,72	28,30
1 1/2	11	44,00	44,67	23,72	28,30
2	11	55,60	56,48	28,02	32,60
2 1/2	11	71,10	72,00	31,32	37,10
3	11	83,60	84,71	34,42	40,20



Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS



According to
BS 84



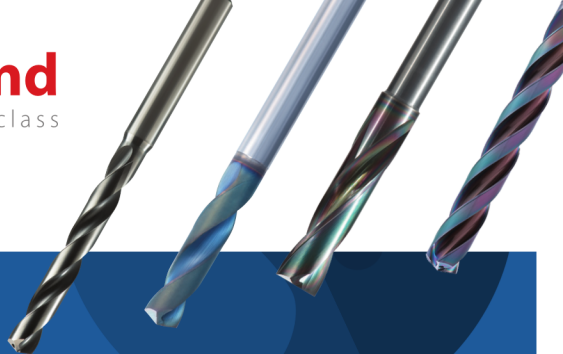
shaping your dreams

BSW

ΒΡΕΤΑΝΙΚΗ ΙΝΤΣΑ

[illegible][illegible][illegible]

Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS



According to
BS 84

shaping your dreams

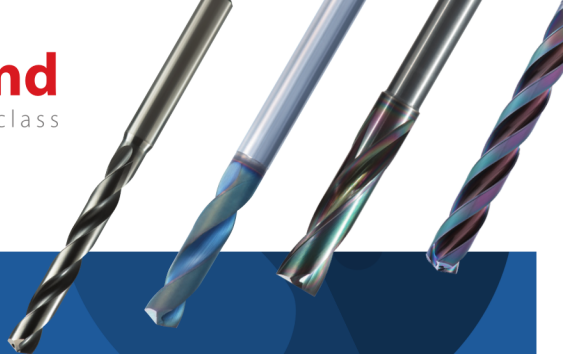
BSF

ΒΡΕΤΑΝΙΚΗ ΙΝΤΣΑ ΨΙΛΟΠΑΣΑ

[illegible][illegible][illegible]

Complete Chart

Recommended drill sizes for tapping



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS



According to
DIN-ISO 5855

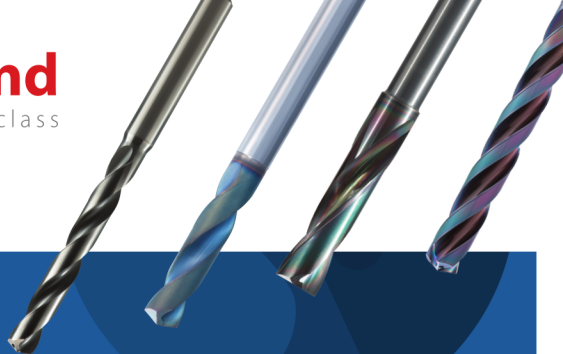
shaping your dreams

MJ

ΜΕΤΡΙΚΑ ΑΕΡΟΠΟΡΙΚΟΥ ΤΥΠΟΥ



Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

CUTTING TAPS

Pg

According to
DIN 40430



shaping your dreams

Pg

ΗΛΕΚΤΡΟΛΟΓΙΚΑ

[illegible][illegible][illegible]

Complete Chart

Guide to tap drill sizes

Recommended drill sizes for tapping

WIRE INSERTS TAPS (helicoil)

**EG
M**

According to
DIN 8140



shaping your dreams

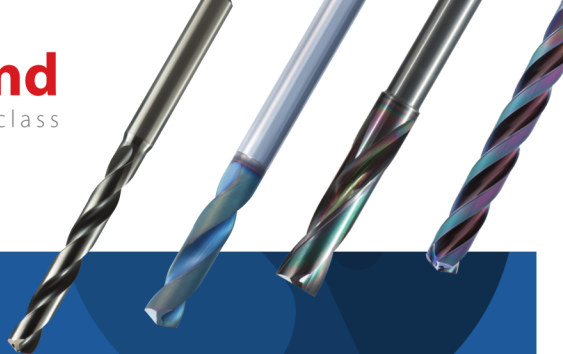
EG M

**METPIKA
HELICOIL**

		
2	0,4	2,10
2,5	0,45	2,60
3	0,5	3,20
4	0,7	4,20
5	0,8	5,20
6	1	6,30
8	1,25	8,40
10	1,5	10,40
12	1,75	12,50
16	2	16,60
20	2,5	20,70



Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

WIRE INSERTS TAPS (helicoil)



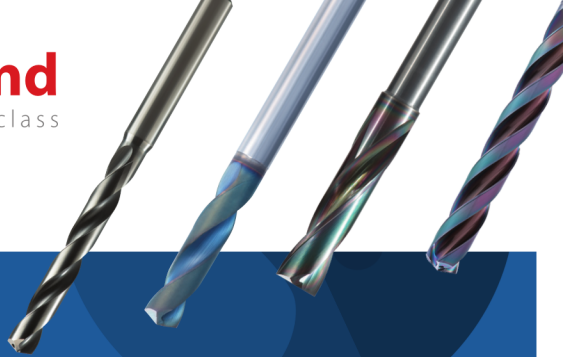
shaping your dreams

EG UNC

ΑΜΕΡΙΚΑΝΙΚΗ ΙΝΤΣΑ HELICOIL



Complete Chart



Guide to tap drill sizes

Recommended drill sizes for tapping

WIRE INSERTS TAPS (helicoil)

**EG
UNF**



shaping your dreams

EG UNF

**ΑΜΕΡΙΚΑΝΙΚΗ ΙΝΤΣΑ
ΨΙΛΟΠΑΣΑ
HELICOIL**



Complete Chart