

TAPPING DATA

UNF Screw Thread Data

Thread Size	Clearance Drill Diameter (mm)	Cutting Tap Drill Diameter (mm)	Forming Tap Drill Diameter (mm)
No 0 UNF 80	1.60	1.25	1.40
No 1 UNF 72	1.95	1.55	1.70
No 2 UNF 64	2.30	1.90	2.00
No 3 UNF 56	2.65	2.15	2.30
No 4 UNF 48	2.95	2.40	2.60
No 5 UNF 44	3.30	2.70	2.90
No 6 UNF 40	3.60	2.95	3.20
No 8 UNF 36	4.30	3.50	3.80
No 10 UNF 32	4.90	4.10	4.50
No 12 UNF 28	5.60	4.70	5.10
1/4 UNF 28	6.50	5.50	5.90
5/16 UNF 24	8.10	6.90	7.50
3/8 UNF 24	9.70	8.50	9.00
7/16 UNF 20	11.30	9.90	10.50
1/2 UNF 20	13.00	11.50	12.20
9/16 UNF 18	14.50	12.90	-
5/8 UNF 18	16.25	14.50	-
3/4 UNF 16	19.25	17.50	-
7/8 UNF 14	22.50	20.40	-
1 UNF 12	25.75	23.25	-
1 1/8 UNF 12	29.00	26.50	-
1 1/4 UNF 12	32.00	29.50	-
1 3/8 UNF 12	35.50	32.75	-
1 1/2 UNF 12	38.50	36.00	-

UNC Screw Thread Data

Thread Size	Clearance Drill Diameter (mm)	Cutting Tap Drill Diameter (mm)	Forming Tap Drill Diameter (mm)
No 1 UNC 64	1.95	1.55	1.65
No 2 UNC 56	2.30	1.85	1.95
No 3 UNC 48	2.65	2.10	2.25
No 4 UNC 40	2.95	2.35	2.55
No 5 UNC 40	3.30	2.65	2.85
No 6 UNC 32	3.60	2.85	3.10
No 8 UNC 32	4.30	3.50	3.80
No 10 UNC 24	4.90	3.90	4.30
No 12 UNC 24	5.60	4.50	5.00
1/4 UNC 20	6.50	5.10	5.80
5/16 UNC 18	8.10	6.60	7.30
3/8 UNC 16	9.70	8.00	8.80
7/16 UNC 14	11.30	9.40	10.46
1/2 UNC 13	13.00	10.80	11.90
9/16 UNC 12	14.50	12.20	-
5/8 UNC 11	16.25	13.50	-
3/4 UNC 10	19.25	16.50	-
7/8 UNC 9	22.50	19.50	-
1 UNC 8	25.75	22.25	-
1 1/8 UNC 7	29.00	25.00	-
1 1/4 UNC 7	32.00	28.00	-

Metric Fine Screw Thread Data

Thread Size	Clearance Drill Diameter (mm)	Cutting Tap Drill Diameter (mm)	Forming Tap Drill Diameter (mm)
M3 x 0.35	3.10	2.65	-
M4 x 0.50	4.10	3.50	-
M5 x 0.50	5.10	4.50	-
M6 x 0.75	6.10	5.20	-
M7 x 0.75	7.20	6.20	-
M8 x 1.00	8.20	7.00	-
M10 x 1.25	10.20	8.80	-
M12 x 1.25	12.20	10.80	-
M14 x 1.50	14.25	12.50	-
M16 x 1.50	16.25	14.50	-
M18 x 1.50	18.25	16.50	-
M20 x 1.50	20.25	18.50	-
M22 x 1.50	22.25	20.50	-
M24 x 2.00	24.25	22.00	-
M27 x 2.00	27.25	25.00	-
M30 x 2.00	30.50	28.00	-

Metric Coarse Screw Thread Data

Thread Size	Clearance Drill Diameter (mm)	Cutting Tap Drill Diameter (mm)	Forming Tap Drill Diameter (mm)
M1 x 0.25	1.05	0.75	-
M1.1 x 0.25	1.15	0.85	-
M1.2 x 0.25	1.25	0.95	-
M1.4 x 0.30	1.45	1.10	-
M1.6 x 0.35	1.65	1.25	1.45
M1.8 x 0.35	1.85	1.45	1.65
M2 x 0.40	2.05	1.60	1.80
M2.2 x 0.45	2.25	1.75	2.00
M2.5 x 0.45	2.60	2.05	2.30
M3 x 0.50	3.10	2.50	2.80
M3.5 x 0.60	3.60	2.90	3.20
M4 x 0.70	4.10	3.30	3.70
M4.5 x 0.75	4.60	3.70	4.10
M5 x 0.80	5.10	4.20	4.60
M6 x 1.00	6.10	5.00	5.60
M7 x 1.00	7.20	6.00	6.50
M8 x 1.25	8.20	6.80	7.40
M9 x 1.25	9.20	7.80	8.36
M10 x 1.50	10.20	8.50	9.30
M11 x 1.50	11.20	9.50	-
M12 x 1.75	12.20	10.20	11.20
M14 x 2.00	14.25	12.00	13.00
M16 x 2.00	16.25	14.00	15.00
M18 x 2.50	18.25	15.50	16.80
M20 x 2.50	20.25	17.50	18.80
M22 x 2.50	22.25	19.50	-
M24 x 3.00	24.25	21.00	-
M27 x 3.00	27.25	24.00	-