

BRITISH STANDARD WHITWORTH FORM THREADS 5 1/2° INC. ANGLE

Nominal Dia.	B. S. W.		B. S. F.		B. S. B.		B. S. P. & B. S. P. T.		B. S. Cond.		M. E.		WHITWORTH FORM SPECIAL	
	Fractional	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm
1/16"	60	1.2	---	---	---	---	---	---	---	---	---	---	---	---
3/32"	48	1.9	---	---	---	---	---	---	---	---	---	---	---	---
1/8"	40	2.55	---	---	26	---	28	8.80	---	---	40	2.55	---	---
5/32"	32	3.2	---	---	---	---	---	---	---	---	40	3.30	---	---
3/16"	24	3.7	32	4.0	---	---	---	---	---	---	40	4.00	---	---
7/32"	24	4.5	28	4.6	---	---	---	---	---	---	40	4.80	---	---
1/4"	20	5.1	26	5.3	26	5.3	19	11.8	---	---	40	5.50	24,28,32	5.3, 5.4, 5.5
9/32"	20	5.8	26	6.0	26	6.1	---	---	---	---	32	6.10	---	---
5/16"	18	6.5	22	6.8	26	7.20	---	---	---	---	32	7.00	24,40	6.75, 7.3
3/8"	16	7.9	20	8.3	26	8.4	19	15.25	---	---	32	8.60	24,40	8.4, 8.9
7/16"	14	9.3	18	9.7	26	10	---	---	---	---	32	10.30	20,24,40	9.8, 10, 10.5
1/2"	12	10.5	16	11.1	26	11.5	14	19.00	18	11.5	32	11.90	20,24,40	11.5, 11.9, 12
9/16"	12	12.1	16	12.7	26	13.1	---	---	---	---	---	---	20.	13.1
5/8"	11	13.5	14	14	26	14.7	14	21.00	18	14.2	---	---	20.	14.5
11/16"	11	15.1	14	15.5	26	16.5	---	---	---	---	---	---	20.	16.2
3/4"	10	16.25	12	16.75	26	17.8	14	24.5	16	17.5	---	---	14,20.	17.1, 17.8
7/8"	9	19.25	11	19.75	26	21.0	14	28.25	16	20.6	---	---	14,16,20	20.2, 20.6, 21.0
15/16"	9	20.6	11	21.5	---	---	---	---	---	---	---	---	---	---
1"	8	22	10	22.75	26	24.2	11	30.75	16	23.8	---	---	12,20.	23.0, 24.0
1.1/8"	7	24.75	9	25.5	26	27.5	---	---	---	---	---	---	---	---
1.1/4"	7	28.0	9	28.5	26	30.5	11	39.5	16	30.1	---	---	---	---
1.3/8"	6	30.1	8	31.5	26	33.7	---	---	---	---	---	---	---	---
1.1/2"	6	33.5	8	34.5	26	36.9	11	45.00	14	36.1	---	---	---	---
1.5/8"	5	35.7	8	37.7	26	40.0	---	---	---	---	---	---	---	---
1.3/4"	5	39	7	41.0	26	43.5	11	51.00	---	---	---	---	---	---
1.7/8"	4 1/2	41.3	7	43.7	26	46.5	---	---	---	---	---	---	---	---
2"	4 1/2	44.5	7	47	26	49.6	11	57.00	14	48.8	---	---	---	---

AMERICAN NATIONAL FORM THREADS 60° INC. ANGLE

Nominal Dia.	N.C. & U.N.C.		N.F. & U.N.F.		N.P.T. & N.P.S.		N.S.		N.E.F.		Nominal Dia.	N.C. & U.N.C.		N.F. & U.N.F.		N.P.T. & N.P.S.		N.S.		N.E.F.		
	Fractional	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm		Fractional	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm
1/16"	---	---	---	---	27	6.0	6.3	64	1.20	---	1.3/8"	6	30.75	12	32.75	---	---	---	---	---	---	18
3/32"	---	---	---	---	---	---	---	48	1.85	---	1.1/2"	6	34.00	12	36.00	11.5	43.5	44.0	---	---	---	18
1/8"	---	---	---	---	27	8.4	8.7	40	2.60	---	1.5/8"	---	---	---	---	---	---	---	5.5	36.90	---	18
5/32"	---	---	---	---	---	---	---	32&35	3.20 & 3.30	---	1.3/4"	5	39.50	---	---	---	---	---	---	---	---	16
3/16"	---	---	---	---	---	---	---	24&32	3.80 & 4.00	---	1.7/8"	---	---	---	---	---	---	---	5	42.90	---	---
7/32"	---	---	---	---	---	---	---	24&32	4.50 & 4.80	---	2"	---	---	---	---	---	---	---	---	---	---	16
1/4"	20	5.10	28	5.50	18	10.7	11.1	24&32	5.30 & 5.60	32	---	---	---	---	---	---	---	---	---	---	---	
5/16"	18	6.60	24	6.90	---	---	---	20&32	6.70 & 7.20	32	---	---	---	---	---	---	---	---	---	---	---	
3/8"	16	8.00	24	8.50	18	14.25	14.5	20	8.30	32	---	---	---	---	---	---	---	---	---	---	---	
7/16"	14	9.40	20	9.90	---	---	---	24	10.00	28	---	---	---	---	---	---	---	---	---	---	---	
1/2"	13	10.80	20	11.50	14	17.5	18.0	12&24	10.50 & 11.50	28	---	---	---	---	---	---	---	---	---	---	---	
9/16"	12	12.20	18	12.90	---	---	---	---	---	24	---	---	---	---	---	---	---	---	---	---	---	---
5/8"	11	13.50	18	14.50	---	---	---	12	13.90	24	---	---	---	---	---	---	---	---	---	---	---	---
11/16"	---	---	---	---	---	---	---	11&16	15.00 & 15.90	24	---	---	---	---	---	---	---	---	---	---	---	---
3/4"	10	16.5	16	17.50	14	22.75	23.25	12	16.70	20	---	---	---	---	---	---	---	---	---	---	---	
13/16"	---	---	---	---	---	---	---	---	---	20	---	---	---	---	---	---	---	---	---	---	---	---
7/8"	9	19.50	14	20.40	---	---	---	12	20.20	20	---	---	---	---	---	---	---	---	---	---	---	
15/16"	---	---	---	---	---	---	---	---	---	20	---	---	---	---	---	---	---	---	---	---	---	---
1"	8	22.25	12	23.25	11.5	28.5	29.0	14	23.50	20	---	---	---	---	---	---	---	---	---	---	---	
1.1/8"	7	25.00	12	26.50	---	---	---	---	---	18	---	---	---	---	---	---	---	---	---	---	---	---
1.1/4"	7	28.00	12	29.50	11.5	37.5	38.0	---	---	18	---	---	---	---	---	---	---	---	---	---	---	---

AMERICAN NATIONAL THREADS 60° INC. ANGLE

Nominal Dia.	N.C.		N.F.		U.N.C.		U.N.F.		
	Size No.	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm	TPI	Drill Size In mm
0	---	---	---	80	1.25	---	---	---	---
1	64	1.55	72	1.55	---	---	---	---	
2	56	1.85	64	1.90	---	---	---	---	
3	48	2.10	56	2.15	---	---	---	---	
4	40	2.35	48	2.40	40	2.35	---	---	
5	40	2.65	44	2.70	---	---	---	---	
6	32	2.85	40	2.95	32	2.85	---	---	
8	32	3.50	36	3.50	32	3.50	---	---	
10	24	3.90	32	4.10	24	3.90	32	4.10	
12	24	4.50	28	4.70	---	---	---	---	

BRITISH ASSOCIATION 47 1/2° INC. ANGLE

BRITISH STANDARD CYCLE 60° INC. ANGLE

METRIC SPECIAL 60° INC. ANGLE

Size	Dia.	TPI	Drill Size In mm	Size	TPI	Drill Size In mm	Size M.M.	Pitch	Drill Size In mm		Size M.M.	Pitch	Drill Size In mm
									For Fluted	For Flutless			
0	.2362	25.4	5.10	1/8"	40	2.65	2	.4	1.60	1.80	14	1.5	12.50
1	.2087	28.2	4.50	5/32"	32	3.30	2.2	.45	1.75	1.9	14	2	12.00
2	.1850	31.4	4.00	3/16"	32	4.10	2.3	.4	1.90	2.10	16	1.5	14.50
3	.1614	34.8	3.40	7/32"	26	4.80	2.5	.45	2.05	2.25	16	2	14.00
4	.1417	38.5	3.00	1/4"	26	5.60	2.6	.45	2.15	2.40	18	1.5	16.50
5	.1260	43.0	2.65	9/32"	26	6.35	3	.5	2.50	2.65	18	2.5	15.50
6	.1102	47.9	2.30	5/16"	26	7.20	3.5	.6	2.90	3.2	20	1.5	18.50
7	.0984	52.9	2.05	3/8"	26	8.70	4	.7	3.30	3.60	20	2.5	17.50
8	.0866	59.1	1.80	7/16"	26	10.30	4.5	.75	3.70	4.00	22	1.5	20.50
9	.0748	65.1	1.55	1/2"	26	11.90	5	.8	4.20	4.50	22	2.5	19.50
10	.0669	72.6	1.40	9/16"	20	13.10	6	1	5.00	5.30	24	1.5	22.50
11	.0591	81.9	1.20	5/8"	26	15.00	7	1	6.00	6.35	24	3	21.00
12	.0512	90.9	1.05	3/4"	26	16.70	8	1	7.00	7.40	27	3	24.00
13	.0472	102	0.98	11/16"	26	18.20	8	1.25	6.80	7.20	30	3.5	26.50
14	.0394	109.9	0.80	1"	26	24.50	10	1	9.00	9.50	33	3.5	29.50
15	.0354	120.5	0.70	---	24	---	10	1.5	8.50	9.00	36	4	32.00
16	.0311	133.3	0.60	---	---	---	11	1.5	9.50	10.00	39	4	35.00
---	---	---	---	---	---	---	12	1.5	10.50	11.00	42	4.5	37.50
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Tapping drill equivalents in 'Inch' or 'Number' can be recommended