



**TITANIUM NITRIDE COATING
REDUCES HEAT AND INCREASES
LUBRICITY FOR EXTENDED LIFE**

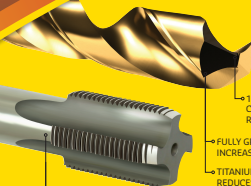
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THE HOLE ADVANTAGE



135° SPLIT POINT
CUTS FASTER AND
REDUCES WANDERING

FULLY GROUND M2 HSS
INCREASES DRILL LIFE

TITANIUM NITRIDE COATING
REDUCES HEAT AND
INCREASES LUBRICITY FOR
EXTENDED LIFE

MADE IN EUROPE

PRECISION MANUFACTURED
TO I.S.O. & D.I.N. STANDARDS

TAPPING CHART

M | MF | UNC | UNF | UNEF | 8UN | BSW | Rc (BSPT) | BSF | BA | BSB | Rp (BSPL) | NPT-NPTF | NPSF | Pg

M ISO METRIC COARSE (8°)		
TAP SIZE	PITCH MM	TAPPING DRILL
M1.6	0.35	1.25
M2	0.4	1.6
M2.5	0.45	2.06
M3	0.5	2.5
M3.5	0.6	2.9
M4	0.7	3.3
M4.5	0.75	3.7
M5	0.8	4.2
M6	1.0	5.0
M6	1.25	6.8
M8	1.0	8.5
M10	1.5	10.2
M12	1.75	10.2
M14	2.0	12.0
M16	2.0	14.0
M18	2.5	16.5
M20	2.5	17.5
M22	2.5	19.5
M24	3.0	21.0
M27	3.0	24.5
M30	3.5	26.5
M33	3.5	29.5
M36	4.0	32.0
M40	4.5	37.5
M45	4.5	40.5
M50	5.0	43.0
M56	5.0	47.0
M60	5.5	50.5

BSW BRITISH STANDARD WHITWORTH (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL
1/16"	80	1.2
1/8"	48	1.65
1/8"	40	2.35
5/16"	32	3.2
3/8"	24	3.7
1/2"	24	4.5
5/8"	20	5.1
3/4"	18	6.5
7/8"	16	7.9
1 1/8"	14	9.3
1 1/4"	12	10.5
1 1/2"	12	12.1
1 3/4"	11	13.5
1 7/8"	10	16.25
2"	9	19.25
2 1/8"	8	22.0
2 1/4"	7	24.75
2 1/2"	7	26.0
2 3/4"	6	35.5
3"	5	38.0
3 1/2"	4	44.5

ST STEEL CONDUIT (8°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
P1/2	20	11.3
P3/8	18	13.9
P1/2	18	17.3
P1 1/4	18	19.1
P1 1/2	18	21.2
P2"	15	26.8

MF ISO METRIC FINE (8°)		
TAP SIZE	PITCH MM	TAPPING DRILL
M6	0.5	3.5
M8	0.5	4.5
M8	0.75	5.3
M10	1.0	7.0
M10	1.0	8.0
M12	1.25	8.8
M12	1.25	10.8
M12	1.5	10.5
M14	1.25	12.8
M16	1.5	14.5
M16	1.5	16.5
M18	1.5	18.5
M20	1.5	20.5
M20	2.0	22.0
M22	1.5	23.5
M24	1.5	26.5
M24	1.5	38.5
M27	1.5	48.5

Rp (BSPP) ISO Rp TAPER FINE 1:16 (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL
Rp 1/16	28	8.4
Rp 1/4	19	11.2
Rp 3/8	19	14.75
Rp 1/2	14	16.5
Rp 3/4	14	20.75
Rp 1	11	30.0
Rp 1 1/4	11	38.5
Rp 1 1/2	11	44.5
Rp 2	11	56.0

BSF BRITISH STANDARD FINE (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/16	32	4.0
1/8	32	4.8
1/4	20	6.3
3/8	22	6.8
1/2	20	8.8
5/8	18	9.8
3/4	16	11.0
7/8	16	12.7
1	14	14.0
1 1/8	14	15.5
1 1/4	12	16.75
1 1/2	11	19.75
1 3/4	10	22.75

NPSF NATIONAL PIPE STRAIGHT (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/8	27	6.6
1/4	18	11.3
3/8	18	14.5
1/2	14	16.8

UNF UNIFIED NATIONAL FINE (8°)		
TAP SIZE	T.P.I.	TAPPING DRILL
#1-100	58	2.1
#1-112	48	2.35
#1-125	40	2.65
#1-138	40	2.9
#1-150	38	3.5
#1-160	32	4.1
#1-175	28	4.8
#1-200	32	4.8
#1-225	24	5.5
#1-250	24	6.0
#1-275	24	6.5
#1-300	20	6.8
#1-325	20	11.5
#1-350	18	12.8
#1-375	18	14.5
#1-400	16	17.5
#1-450	14	20.5
#1-500	12	23.5
#1-550	14	24.0
#1-600	12	26.5
#1-650	12	29.5
#1-700	12	33.0
#1-750	12	36.0

NPT-NPTF NATIONAL PIPE TAPER 1:16 (60°)		
TAP SIZE	T.P.I.	TAPPING DRILL
1/16	27	6.3
1/8	27	8.5
1/4	18	11.0
3/8	18	14.5
1/2	14	18.0
5/8	14	23.0
3/4	11	28.0
1	11	37.5
1 1/4	11	44.5
1 1/2	11	50.5

8UN (8°) UNIFIED NATIONAL FINE (8°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1-1/8	8	25.5
1-1/4	8	28.5
1-3/8	8	31.75
1-1/2	8	35.0
1-5/8	8	38.0
1-3/4	8	41.5
1-7/8	8	44.5
2	8	47.5

UNF UNIFIED NATIONAL FINE (8°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/4	32	6.6
5/8	32	7.2
3/8	32	8.8
1/2	28	11.3
5/8	24	14.75
3/4	20	18.2

UNC UNIFIED NATIONAL COARSE (8°)		
TAP SIZE	T.P.I.	TAPPING DRILL
#1-100	58	1.85
#1-112	48	2.1
#1-125	40	2.3
#1-138	40	2.6
#1-150	32	3.4
#1-160	32	3.4
#1-175	24	3.8
#1-200	34	4.5
#1-225	20	5.1
#1-250	18	5.6
#1-275	18	6.0
#1-300	16	6.8
#1-325	14	9.4
#1-350	13	10.8
#1-375	12	12.2
#1-400	11	13.5
#1-450	10	16.5
#1-500	9	19.5
#1-550	8	22.2
#1-600	7	25.0
#1-650	7	28.0
#1-700	6	31.0
#1-750	6	34.0
#1-800	5	38.5
#1-850	4	45.0

BA (47.5°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
0	1	5.1
1	8	5.9
2	8	6.5
3	7	7.3
4	6	8.0
5	6	8.6
6	5	9.5
7	4	10.5
8	4	11.5
9	3	12.5
10	3	13.5
11	3	14.5
12	2	15.5
13	2	16.5
14	2	17.5
15	2	18.5
16	2	19.5

BSB BRITISH STANDARD BRASS (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
1/4	20	5.2
5/8	20	6.8
3/8	20	8.4
1/2	20	10.0
5/8	20	11.6
3/4	20	13.2
7/8	20	14.8
1	20	16.0
1 1/8	20	18.0
1 1/4	20	20.0
1 1/2	20	22.0

Rp (BSPP) SEALING PIPE THREAD PARALLEL (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL MM
Rp 1/8	28	6.6
Rp 1/4	19	11.5
Rp 3/8	19	15.0
Rp 1/2	14	18.5
Rp 3/4	14	24.0
Rp 1	11	30.2
Rp 1 1/4	11	39.0
Rp 1 1/2	11	45.0
Rp 2	11	56.4

THREAD FORMING (FLUTELESS TAP)		
TAP SIZE	T.P.I.	TAPPING DRILL
M1	0.25	0.5
M1.1	0.25	1.0
M1.2	0.25	1.1
M1.4	0.3	1.28
M1.6	0.35	1.45
M1.7	0.35	1.55
M1.8	0.35	1.65
M2	0.4	1.8
M2.2	0.45	2.0
M2.3	0.45	2.1
M2.5	0.45	2.3
M2.6	0.45	2.4
M3	0.5	2.8
M3.5	0.6	3.2
M4	0.7	3.7
M5	0.8	4.8
M6	1.0	5.5
M8	1.25	7.4
M10	1.5	9.1
M12	1.75	11.2

BSW BRITISH STANDARD WHITWORTH (55°)		
TAP SIZE	T.P.I.	TAPPING DRILL
#1 (57.3)	84	1.7
#2 (58.6)	56	2.0
#3 (59.9)	48	2.3
#4 (61.2)	40	2.6
#5 (62.5)	40	2.9
#6 (63.8)	32	3.2
#7 (65.1)	24	3.7
#8 (66.4)	24	4.1
#9 (67.7)	24	4.5
#10 (69.0)	20	5.0
#11 (70.3)	18	5.5
#12 (71.6)	16	6.0
#13 (72.9)	14	6.5
#14 (74.2)	12	7.0
#15 (75.5)	11	7.5
#16 (76.8)	10	8.0
#17 (78.1)	9	8.5
#18 (79.4)	8	9.0
#19 (80.7)	7	9.5
#20 (82.0)	6	10.0
#21 (83.3)	5	10.5
#22 (84.6)	4	11.0
#23 (85.9)	3	11.5

G (BSPP)		
TAP SIZE	T.P.I.	TAPPING DRILL
G 1/8	28	6.6
G 1/4	19	11.5
G 3/8	19	15.0
G 1/2	14	18.5
G 3/4	14	24.0
G 1	11	30.2
G 1 1/4	11	39.0
G 1 1/2	11	45.0
G 2	11	56.4



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