

Thread Pitch Reference Chart

STANDARD (US) THREADS		
DIAMETER (INCH)	Thread Pitch	
	Course	Fine
#0		80
#1	64	72
#2	56	64
#3	48	56
#4	40	48
#5	40	44
#6	32	40
#8	32	36
#10	24	32
#12	24	28
1/4	20	28
5/16	18	24
3/8	16	24
7/16	14	20
1/2	13	20
9/16	12	18
5/8	11	18
3/4	10	16
7/8	9	14
1	8	14
1 1/8	7	12
1 1/4	7	12
1 1/2	6	12
1 3/4	5	
2	4 1/2	
2 1/4	4 1/2	
2 1/2	4	
2 3/4	4	
3	4	

METRIC THREADS			
DIAMETER (MM)	Thread Pitch		
	Course	Fine	Extra Fine
1	.25		
1.2	.25		
1.6	.35		
2	.4		
2.5	.45		
3	.5		
4	.7		
5	.8		
6	1.0		
8	1.25	1.00	
10	1.5	1.25	1.0
12	1.75	1.5	1.25
14	2	1.5	
16	2	1.5	
20	2.5	1.5	
24	3	2	
30	3.5	2	
36	4	3	

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Decimal Equivalents and Tap Sizes of Fraction, Number, Letter and Metric Sizes

Recommended tap drill sizes for approximately 75% depth of thread

DRILL SIZE	DECIMAL INCHES	TAP SIZE*	DRILL SIZE	DECIMAL INCHES	TAP SIZE*	DRILL SIZE	DECIMAL INCHES	TAP SIZE*	DRILL SIZE	DECIMAL INCHES	TAP SIZE*	DRILL SIZE	DECIMAL INCHES	TAP SIZE*
97	.0059		58	.0420		27	.1440		H	.2660		17/32	.5312	5/8 - 11
.15mm	.0059		57	.0430		3.7mm	.1457		6.8mm	.2677		13.5mm	.5315	
96	.0063		1.1mm	.0433		26	.1470	3/16-24nc	6.9mm	.2717		35/64	.5469	
.16mm	.0063		1.15mm	.0453		3.75mm	.1476	m4.5x0.75	I	.2720		14mm	.5512	m16x2
95	.0067		56	.0465		25	.1495	#10 - 24	J	.2756		9/16	.5625	
.17mm	.0067		3/64	.0469	#0 - 80	3.8mm	.1496		7mm	.2770	5/16-24w	14.5mm	.5709	m16x1.5
94	.0071		1.2mm	.0472		24	.1520		7.1mm	.2795		37/64	.5781	3/8-18 RFI 5/8-18w
.18mm	.0071		1.25mm	.0492	m1.6x0.35	3.9mm	.1535		K	.2810		15mm	.5906	
93	.0075		1.3mm	.0512		23	.1540		9/32	.2812	5/16-32ns	19/32	.5938	3/8-18 wns rfs
.19mm	.0075		55	.0520		5/32	.1562		7.2mm	.2835		39/64	.6094	
92	.0079		1.35mm	.0531		22	.1570	3/16-32ns	7.25mm	.2854		15.5mm	.6102	m18x2.5
.2mm	.0079		54	.0550		4mm	.1575		7.3mm	.2874		5/8	.6250	1 1/16-16ns
91	.0083		1.4mm	.0551		21	.1590	#10 - 32	L	.2900		16mm	.6299	m18x2.0
.21mm	.0083		1.45mm	.0571	m1.8x0.35	20	.1610		7.4mm	.2913		41/64	.6406	
90	.0087		1.5mm	.0591		4.1mm	.1614		M	.2950		16.5mm	.6496	
.22mm	.0087		53	.0595	#1 - 64, 72	4.2mm	.1654	m5x0.8	7.5mm	.2953		21/32	.6562	3/4-10nc
89	.0091		1.55mm	.0610		19	.1660		19/64	.2969		17mm	.6693	
.23mm	.0091		1/16	.0625		4.25mm	.1673		7.6mm	.2992		43/64	.6719	
.24mm	.0094		1.6mm	.0630	m2x0.4	4.3mm	.1693		N	.3020		11/16	.6875	3/4-16w
88	.0095		52	.0635		18	.1695		7.7mm	.3031		17.5mm	.6890	m20x2.5
.25mm	.0098		1.65mm	.0650		11/64	.1719		7.75mm	.3051	m9x1.25	45/64	.7031	
87	.0100		1.7mm	.0669		17	.1730		7.8mm	.3071		18mm	.7087	m20x2.0
.26mm	.0102		51	.0670	#2 - 56	4.4mm	.1732		7.9mm	.3110		23/32	.7188	1/2-14w rfs
86	.0105		1.75mm	.0689	m2.2 x 0.45	16	.1770	#12 - 24	5/16	.3125	3/8-16w	18.5mm	.7283	m20x1.5
.27mm	.0106		50	.0700	#2 - 64	4.5mm	.1772		8mm	.3150		47/64	.7344	1/2-14w rfs
85	.0110		1.8mm	.0709		15	.1800		O	.3160		19mm	.7480	
.28mm	.0110		1.85mm	.0728		4.6mm	.1811		8.1mm	.3189		3/4	.7500	
.29mm	.0114		49	.0730		14	.1820	#12 - 28	8.2mm	.3228		49/64	.7656	7/8-9nc
84	.0115		1.9mm	.0748		13	.1850		P	.3230		19.5mm	.7677	m22x2.5
.3mm	.0118		48	.0760	m2.3x0.4	4.7mm	.1850		8.25mm	.3248		25/32	.7812	
83	.0120		1.95mm	.0768		4.75mm	.1870		8.3mm	.3268		20mm	.7874	m22x2.0
.32mm	.0125		5/64	.0781	#3 - 48	3/16	.1875		21/64	.3281		51/64	.7969	
81	.0130		47	.0785		4.8mm	.1890		8.4mm	.3307		20.5mm	.8071	m22x1.5
.34mm	.0134		2mm	.0787	m2.5x0.45	12	.1890	7/32-32ns	Q	.3320	3/8-24w	13/16	.8125	7/8-14w
80	.0135		46	.0810		11	.1910		8.5mm	.3346		21mm	.8268	m24x3
.35mm	.0138		45	.0820	#3 - 56	4.9mm	.1929		8.6mm	.3386	m10x1.5	53/64	.8281	
.36mm	.0142		2.1mm	.0827		10	.1935		R	.3390	1/8-27 wns rfs	27/32	.8438	
79	.0145		2.15mm	.0846	m2.6x0.45	9	.1960		8.7mm	.3425		21.5mm	.8465	
.38mm	.0150		44	.0860	#4 - 36	5mm	.1969	m6x1	11/32	.3438		55/64	.8594	
1/64	.0156		2.2mm	.0866		8	.1990		8.75mm	.3445	m10x1.25	22mm	.8661	m24x2
.4mm	.0157		2.25mm	.0886		7	.2010	1/4 - 20	8.8mm	.3465		7/8	.8750	1-8w
78	.0160		43	.0890	#4 - 40	13/64	.2031		S	.3480	1/8-27 wns rfs	22.25mm	.8760	
.42mm	.0165		2.3mm	.0906		6	.2040		8.9mm	.3504		22.5mm	.8858	m24x1.50
.44mm	.0173		2.35mm	.0925		5.2mm	.2047		9mm	.3543	m10x1.00	57/64	.8906	
.45mm	.0177		42	.0935	#4 - 48	5	.2055		T	.3580		23mm	.9055	
77	.0180		3/32	.0938		5.25mm	.2067	m6x0.75	9.1mm	.3583		29/32	.9062	
.46mm	.0181		2.4mm	.0945		4	.2090	1/4 - 24	23/64	.3594		59/64	.9219	3/4-14 wns rfs
.48mm	.0189		2.45mm	.0965		5.3mm	.2087		9.2mm	.3622		23.5mm	.9252	
.5mm	.0197		2.45mm	.0965		4	.2090	1/4 - 24	9.25mm	.3642		15/16	.9375	3/4-14 RFI 1-14w
76	.0200		40	.0980		5.4mm	.2126		9.3mm	.3661		24mm	.9449	m27x3
.55mm	.0217		39	.0995	m3x0.5	3	.2130	1/4 - 28	9.3mm	.3661		61/64	.9531	
75	.0210		38	.1015	#5 - 40	5.5mm	.2165		U	.3680	7/16-14w	24.5mm	.9646	
.6mm	.0236		37	.1040	#5 - 44	7/32	.2188		9.4mm	.3701		31/32	.9688	
.73	.0240		36	.1065	#6 - 32	5.6mm	.2205		9.5mm	.3740		25mm	.9843	m27x2
.72	.0250		2.7mm	.1063		2	.2210		V	.3750		63/64	.9844	1-1/8 - 7w
.65mm	.0256		2.75mm	.1083		1	.2280		9.6mm	.3770		1	1.0000	
71	.0260		2.8mm	.1102		5.8mm	.2283		9.7mm	.3819		25.5mm	1.0039	
.7mm	.0276		7/64	.1094		5.9mm	.2323		9.75mm	.3839		1-1/64	1.0156	
69	.0292		34	.1110		A	.2340		9.8mm	.3858		26mm	1.0236	
.75mm	.0295		33	.1130		15/64	.2344		9.9mm	.3898		1-1/32	1.0312	
68	.0310		32	.1160		B	.2380		10mm	.3937		26.5mm	1.0433	m30x3.5
.8mm	.0315		3mm	.1181		6.1mm	.2402	m7x1	25/64	.3906	7/16 - 20	1-3/64	1.0469	1-1/8-12w
66	.0330		31	.1200	#6 - 40	C	.2420		Y	.4040	m12x1.75	1-1/16	1.0625	
.85mm	.0335		3.1mm	.1220		6.2mm	.2441		X	.3970		27mm	1.0630	
.9mm	.0354		3.2mm	.1260		D	.2460	1/16-27 wns rfs	Z	.4130		1-5/64	1.0781	
64	.0360		3.25mm	.1280		6.25mm	.2461		13/32	.4062		27.5mm	1.0827	
63	.0370		30	.1285	5/32-32ns	6.33mm	.2480		10.5mm	.4134	m12x1.25	1-3/32	1.0938	
.95mm	.0374		3.3mm	.1299		E	.2500	1/16-27 wns rfs	10.5mm	.4134		28mm	1.1024	m30x2.0
62	.0380		3.4mm	.1339		6.4mm	.2520		27/64	.4219	1/2 - 13	1-7/64	1.1094	1-1/4-7w
61	.0390		29	.1360	#8 - 32	6.5mm	.2559		11mm	.4331		28.5mm	1.1220	
.1mm	.0394		3.5mm	.1378		F	.2570		7/16	.4375	1/4-18 wns rfs	1-1/8	1.1250	
60	.0400		28	.1405		6.6mm	.2598		11.5mm	.4528		1-9/64	1.1406	
59	.0410		27	.1406		6.7mm	.2638		29/64	.4531	1/4-18 RFI 1/2X20	29mm	1.1417	
1.05mm	.0413		9/64	.1406		17/64	.2656		15/32	.4688		1-5/32	1.1562	1-1 1/2 wns rfs
			3.6mm	.1417		6.75mm	.2657		12mm	.4724		29.5mm	1.1614	
									31/64	.4844		1-11/64	1.1719	1-1/4-12w
									12.5mm	.4921				
									1/2	.5000				
									13mm	.5118				
									33/64	.5156				

*To be used with drills as indicated.