

ตารางแสดง ขนาดรูเจาะก่อนการตีابلเกลียว

M ISO METRIC COARSE (60°)			UNC UNIFIED NATIONAL COARSE (60°)			BSW BRITISH STANDARD WHITWORTH (55°)		
Tap Size	Pitch mm	Tapping Drill mm	Tap Size	TPI	Tapping Drill mm	Tap Size	TPI	Tapping Drill mm
M1.6	0.35	1.25	#2 (.086)	56	1.85	1/16*	60	1.2
M2	0.4	1.6	#3 (.099)	48	2.1	3/32*	48	1.85
M2.5	0.45	2.05	#4 (.112)	40	2.3	1/8	40	2.55
M3	0.5	2.5	#5 (.125)	40	2.6	5/32*	32	3.2
M3.5	0.6	2.9	#6 (.138)	32	2.8	3/16	24	3.7
M4	0.7	3.3	#8 (.164)	32	3.4	7/32*	24	4.5
M4.5	0.75	3.7	#10 (.190)	24	3.8	1/4	20	5.1
M5	0.8	4.2	#12 (.216)	24	4.5	5/16	18	6.5
M6	1.0	5.0	1/4	20	5.1	3/8	16	7.9
M8	1.25	6.8	5/16	18	6.6	7/16	14	9.3
M10	1.5	8.5	3/8	16	8.0	1/2	12	10.5
M12	1.75	10.2	7/16	14	9.4	9/16	12	12.1
M14	2.0	12.0	1/2	13	10.8	5/8	11	13.5
M16	2.0	14.0	9/16	12	12.2	3/4	10	16.25
M18	2.5	15.5	5/8	11	13.5	7/8	9	19.25
M20	2.5	17.5	3/4	10	16.5	1	8	22.0
M22	2.5	19.5	7/8	9	19.5	1-1/8	7	24.75
M24	3.0	21.0	1	8	22.2	1-1/4	7	28.0
M27	3.0	24.0	1-1/8	7	25.0	1-1/2	6	33.5
M30	3.5	26.5	1-1/4	7	28.0	1-3/4	5	39.0
M33	3.5	29.5	1-3/8	6	31.0	2	4-1/2	44.5
M36	4.0	32.0	1-1/2	6	34.0	*WHIT. Form		
M42	4.5	37.5	1-3/4	5	39.5			
M45	4.5	40.5	2	4.5	45.0			
M48	5.0	43.0						
M52	5.0	47.0						
M56	5.5	50.5						
MF ISO METRIC FINE (60°)			UNF UNIFIED NATIONAL FINE (60°)			BSF BRITISH STANDARD FINE (55°)		
M4	0.5	3.5	#3 (.099)	56	2.1	3/16	32	4.0
M5	0.5	4.5	#4 (.112)	48	2.35	7/32	28	4.6
M6	0.75	5.3	#5 (.125)	44	2.65	1/4	26	5.3
M8	1.0	7.0	#6 (.138)	40	2.9	5/16	22	6.8
M10**	1.0	9.0	#8 (.164)	36	3.5	3/8	20	8.3
M10	1.25	8.8	#10 (.190)	32	4.1	7/16	18	9.8
M12**	1.25	10.8	#12 (.216)	28	4.6	1/2	16	11.0
M12	1.5	10.5	3/16*	32	4.0	9/16	16	12.7
M14**	1.25	12.8	1/4	28	5.5	5/8	14	14.0
M14	1.5	12.5	5/16	24	6.9	11/16	14	15.5
M16*	1.5	14.5	3/8	24	8.5	3/4	12	16.75
M18**	1.5	16.5	7/16	20	9.8	7/8	11	19.75
M20*	1.5	18.5	1/2	20	11.5	1	10	22.75
M22	1.5	20.5	9/16	18	12.8	1-1/8	9	25.5
M24	2.0	22.0	5/8	18	14.5	1-1/4	9	28.5
M25*	1.5	23.5	3/4	16	17.5	1-1/2	8	34.5
M32*	1.5	30.5	7/8	14	20.5	1-3/4	7	41.0
M40*	1.5	38.5	1	12	23.5			
M50*	1.5	48.5	1*	14	24.0			
			1-1/8	12	26.5			
			1-1/4	12	29.5			
			1-3/8	12	33.01			
			1-1/2	12	36.0			
8UN (8 TPI) UNIFIED NATIONAL FORM (60°)			UNEF UNIFIED NATIONAL FORM (60°)			BSB BRITISH STANDARD BRASS (55°)		
1-1/8	8	25.5	1/4	32	5.6	1/4	26	5.2
1-1/4	8	28.5	5/16	32	7.2	5/16	26	6.8
1-3/8	8	31.75	3/8	32	8.8	3/8	26	8.4
1-1/2	8	35.0	1/2	28	11.8	7/16	26	10.0
1-5/8	8	38.0	5/8	24	14.75	1/2	26	11.6
1-3/4	8	41.5	3/4	20	18	9/16	26	13.2
1-7/8	8	44.5	1	20	24.2	5/8	26	14.8
2	8	47.5				3/4	26	18.0
						7/8	26	20.8
						1	26	24.3

*Metric Conduit **Spark Plug

*UNS

Threading Tapping Drill Size Chart

Rc (BSPT)*
ISO Rc TAPER SERIES 1:16 (55°)

Tap Size	TPI	Drill Only*	Drill & Reamer
Rc 1/16	28	6.4	6.2
Rc 1/8	28	8.4	8.4
Rc 1/4	19	11.2	10.8
Rc 3/8	19	14.75	14.5
Rc 1/2	14	18.25	18.0
Rc 3/4	14	23.75	23.0
Rc 1	11	30.0	29.0
Rc 1-1/4	11	38.5	38.0
Rc 1-1/2	11	44.5	44.0
Rc 2	11	56.0	55.0

G (BSPF)
ISO G PARALLEL SERIES (55°)

Tap Size	TPI	Tapping Drill mm
G 1/16	28	6.8
G 1/8	28	8.8
G 1/4	19	11.8
G 3/8	19	15.3
G 1/2	14	19.0
G 5/8	14	21.0
G 3/4	14	24.5
G 7/8	14	28.5
G 1	11	31.0
G 1-1/4	11	39.5
G 1-1/2	11	45.5
G 1-3/4	11	51.5
G 2	11	57.5
G 2-1/2	11	72.5

Rp (BSPPL)
SEALING PIPE THREAD PARALLEL (55°)

Rp 1/8	28	8.6
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

Pg (Steel Conduit)
(80°)

Pg7	20	11.3
Pg9	18	13.9
Pg11	18	17.3
Pg13.5	18	19.1
Pg16	18	21.2
Pg21	15	26.8

THREAD FORMING
(FLUTELESS TAPS)

Tap Size	Pitch mm	Tapping Drill mm
METRIC COARSE		
M1	0.25	0.9
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	0.40	1.8
M2.2	0.45	2.0
M2.3	0.4	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	4.6
M6	1.0	5.5
M8	1.25	7.4
M10	1.5	9.3
M12	1.75	11.2
BSW		
1/8	40	2.9
5/32	32	3.6
3/16	24	4.3
1/4	20	5.8
5/16	18	7.3
3/8	16	8.8

NPT-NPTF*
NATIONAL PIPE TAPER 1:16 (60°)

Tap Size	TPI	Drill Only*	Drill & Reamer
1/16	27	6.3	6.0
1/8	27	8.5	8.2
1/4	18	11.0	10.8
3/8	18	14.5	14.0
1/2	14	18.0	17.5
3/4	14	23.0	23.0
1	11-1/2	29.0	28.5
1-1/4	11-1/2	37.5	37.0
1-1/2	11-1/2	44	43.5
2	11-1/2	55.5	55.0

NPSF
NATIONAL PIPE STRAIGHT (60°)

Tap Size	TPI	Tapping Drill mm
1/8	27	8.6
1/4	18	11.3
3/8	18	14.5
1/2	14	18.0

THREAD FORMING
(FLUTELESS TAPS)

Tap Size	T.P.I.	Tapping Drill mm
UNC		
#1 (.073)	64	1.7
#2 (.086)	56	2.0
#3 (.099)	48	2.3
#4 (.112)	40	2.6
#5 (.125)	40	2.9
#6 (.138)	32	3.2
#8 (.164)	32	3.8
#10 (.190)	24	4.4
#12 (.216)	24	5.0
1/4	20	5.8
5/16	18	7.3
3/8	16	8.8
7/16	14	10.2
1/2	13	11.7
UNF		
#1 (.073)	72	1.7
#2 (.086)	64	2.0
#3 (.099)	56	2.3
#4 (.112)	48	2.6
#5 (.125)	44	2.9
#6 (.138)	40	3.2
#8 (.164)	36	3.9
#10 (.190)	32	4.5
#12 (.216)	28	5.1
1/4	28	6.0
5/16	24	7.5
3/8	24	9.0
7/16	20	10.6
1/2	20	12.1
G (BSPF)		
1/8	28	9.25
1/4	19	12.5
3/8	19	16.0
1/2	14	20.0
5/8	14	22.0
3/4	14	25.5
7/8	14	29.25
1	11	32.0

BA
BRITISH ASSOCIATION (47.5°)

Tap Size	Pitch mm	Tapping Drill mm
0	1	5.1
1	0.9	4.5
2	0.81	4.0
3	0.73	3.4
4	0.66	3.0
5	0.59	2.65
6	0.53	2.3
7	0.48	2.05
8	0.43	1.8
9	0.39	1.55
10	0.35	1.4
11	0.31	1.2
12	0.28	1.05
13	0.25	0.98
14	0.23	0.8
15	0.21	0.7
16	0.19	0.6

