

Thread Chart

BRITISH STANDARD WHITWORTH THREADS (55° INCLUDED 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	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	TPi Drill Size in mm
1/16"	60	1.20
3/32"	48	1.90
1/8"	40	2.55	...	28	8.80	40	2.55
5/32"	32	3.20	40	3.30
3/16"	24	3.70	40	4.00
7/32"	24	4.50	40	4.80
1/4"	20	5.10	...	19	11.80	40	5.50
9/32"	20	5.80	32	6.10
5/16"	18	6.50	32	7.00
3/8"	16	7.90	...	19	15.25	32	8.60
7/16"	14	9.30	26	10.00
1/2"	12	10.50	...	14	19.00	18	11.50
9/16"	12	12.10
5/8"	11	13.50	...	14	21.00	18	14.20
11/16"	11	15.10
3/4"	10	16.25	...	14	24.50	16	17.50
7/8"	9	19.25	...	14	28.25	16	20.60
15/16"	9	20.60
1"	8	22.00	30.75	16	23.80
1.1/8"	7	24.75
1.1/4"	7	28.00	...	11	39.50	16	30.10
1.3/8"	6	30.10
1.1/2"	6	33.50	...	11	45.00	14	36.10
1.5/8"	5	35.70
1.3/4"	5	39.00	...	11	51.00
1.7/8"	4 1/2	41.30
2"	4 1/2	44.50	...	11	57.00	14	48.80



TOREM

UNIFIED NATIONAL THREADS (60° INCLUDED ANGLE)

Nominal Dia	N.C. & U.N.C.		N.F. & U.N.F.		N.P.T. & N.P.S.		N.S.		N.E.F.
	TPI	Drill size in mm	TPI	Drill size in mm	TPI	Drill size in mm	TPI	Drill size in mm	
Fractional									
1/16"	--	--	27	6.00	64	1.20	--	--	--
3/32"	--	--	--	--	48	1.85	--	--	--
1/8"	--	--	27	8.40	40	2.60	--	--	--
5/32"	--	--	--	--	32/35	3.20/3.30	--	--	--
3/16"	--	--	--	--	24/32	3.80/4.00	--	--	--
7/32"	--	--	--	--	24/32	4.50/4.80	--	--	--
1/4"	20	5.10	28	10.70	11.10	24/32	5.30/5.60	32	5.60
5/16"	18	6.60	24	6.90	--	20/32	6.70/7.20	32	7.20
3/8"	16	8.00	24	8.50	18	14.25	14.50	20	8.30
7/16"	14	9.40	20	9.90	--	--	24	10.00	28
1/2"	13	10.80	20	11.50	14	17.50	18.00	12/24	10.50/11.50
9/16"	12	12.20	18	12.90	--	--	--	--	24
5/8"	11	13.50	18	14.50	--	--	--	--	24
11/16"	--	--	--	--	--	--	11/16	15.00/15.90	24
3/4"	10	16.50	16	17.50	14	22.75	23.25	12	16.70
13/16"	--	--	--	--	--	--	--	--	20
7/8"	9	19.50	14	20.40	--	--	--	--	20
15/16"	--	--	--	--	--	--	--	--	20
1"	8	22.25	12	23.25	11.50	28.50	29.00	14	23.50
1.1/8"	7	25.00	12	26.50	--	--	--	--	18
1.1/4"	7	28.00	12	29.50	11.50	37.50	38.00	--	18
1.3/8"	6	30.75	12	32.75	--	--	--	--	18
1.1/2"	6	34.00	12	36.00	11.50	43.50	44.00	--	18
1.5/8"	--	--	--	--	--	--	--	5.5	36.90
1.3/4"	5	39.50	--	--	--	--	--	--	16
1.7/8"	--	--	--	--	--	--	--	5	42.90
2"	--	--	--	--	11.50	55.00	56.00	--	16

AMERICAN NATIONAL THREADS (60° INCLUDED ANGLE)

Nominal Dia	N.C. & U.N.C.		N.F. & U.N.F.		N.P.T. & N.P.S.		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	4.10
12	24	4.50	28	4.70	--	--	--

BRITISH ASSOCIATION (47 1/2° INCLUDED ANGLE)				BRITISH STANDARD CYCLE (60° INCLUDED ANGLE)			
SIZE	NOM. DIA.	TPI	DRILL SIZE in mm	SIZE	TPI	DRILL SIZE in mm	
0	0.2362	25.4	5.10	1/8"	40	2.65	
1	0.2087	28.2	4.50	5/32"	32	3.30	
2	0.1850	31.4	4.00	3/16"	32	4.10	
3	0.1614	34.8	3.40	7/32"	26	4.80	
4	0.1417	38.5	3.00	1/4"	26	5.60	
5	0.1260	43.0	2.65	9/32"	26	6.35	
6	0.1102	47.9	2.30	5/16"	26	7.20	
7	0.0984	52.9	2.05	3/8"	26	8.70	
8	0.0866	59.1	1.80	7/16"	26	10.30	
9	0.0748	65.1	1.55	1/2"	26	11.90	
10	0.0669	72.6	1.40	9/16"	20	13.10	
11	0.0591	81.9	1.20	9/16"	26	13.50	
12	0.0512	90.9	1.05	5/8"	26	15.00	
13	0.0472	102.0	0.98	11/16"	26	16.70	
14	0.0394	109.9	0.80	3/4"	26	18.20	
15	0.0354	120.5	0.70	1"	24	24.50	
16	0.0311	133.3	0.60				

METRIC (60° INCLUDED ANGLE)					
SIZE in mm	PITCH	DRILL SIZE in mm		SIZE in mm	PITCH
		Fluted	Fluteless		
2.0	0.40	1.60	1.80	14.0	1.50
2.2	0.45	1.75	1.90	14.0	2.00
2.3	0.40	1.90	2.10	16.0	1.50
2.5	0.45	2.05	2.25	16.0	2.00
2.6	0.45	2.15	2.40	18.0	1.50
3.0	0.50	2.50	2.75	18.0	2.50
3.5	0.60	2.90	3.20	20.0	1.50
4.0	0.70	3.30	3.70	20.0	2.50
4.5	0.75	3.70	4.10	22.0	1.50
5.0	0.80	4.20	4.60	22.0	2.50
6.0	1.00	5.00	5.50	24.0	1.50
7.0	1.00	6.00	6.50	24.0	3.00
8.0	1.00	7.00	7.50	27.0	3.00
8.0	1.25	6.80	7.40	30.0	3.50
10.0	1.00	9.00	9.50	33.0	3.50
10.0	1.50	8.50	9.30	36.0	4.00
11.0	1.50	9.50	10.30	39.0	4.00
12.0	1.50	10.50	11.30	42.0	4.50
12.0	1.75	10.20	11.10	45.0	4.50