

METRIC COARSE

HAND TAPS

I.S.O 529 : 1975

B.S. 949 : Pt 1 : 1976

D	Pitch mm	L mm	l mm	l1 mm	d mm	a mm	Tapping Drill Sizes mm	Tapping Drill Sizes (Fluteless) mm
M 2.0	0.4	41	8	4	2.5	2	1.6	1.8
M 2.2	0.45	44.5	9.5	5	2.8	2.24	1.75	2
M 2.5	0.45	44.5	9.5	5	2.8	2.24	2.05	2.25
M 3.0	0.5	48	11	5	3.15	2.5	2.5	2.75
M 3.5	0.6	50	13	5	3.55	2.8	2.9	3.2
M 4.0	0.7	53	13	6	4	3.15	3.3	3.65
M 4.5	0.75	53	13	6	4.5	3.55	3.7	4.1
M 5.0	0.8	58	16	7	5	4	4.2	4.6
M 6.0	1	66	19	8	6.3	5	5	5.5
M 7.0	1	66	19	8	7.1	5.6	6	6.5
M 8.0	1.25	72	22	9	8	6.3	6.8	7.4
M 9.0	1.25	72	22	10	9	7.1	7.8	8.4
M 10.0	1.5	80	24	11	10	8	8.5	9.25
M 11.0	1.5	85	25	9	8	6.3	9.5	10.25
M 12.0	1.75	89	29	10	9	7.1	10.2	11.1
M 14.0	2	95	30	12	11.2	9	12	
M 16.0	2	102	32	13	12.5	10	14	
M 18.0	2.5	112	37	14	14	11.2	15.5	
M 20.0	2.5	112	37	14	14	11.2	17.5	
M 22.0	2.5	118	38	16	16	12.5	19.5	
M 24.0	3	130	45	18	18	14	21	
M 27.0	3	135	45	20	20	16	24	
M 30.0	3.5	138	48	20	20	16	26.5	
M 33.0	3.5	151	51	22	22.4	18	29.5	
M 36.0	4	162	57	24	25	20	32	
M 39.0	4	170	60	26	28	22.4	35	
M 42.0	4.5	170	60	26	28	22.4	37.5	
M 45.0	4.5	187	67	28	31.5	25	40.5	
M 48.0	5	187	67	28	31.5	25	43	
M 52.0	5	200	70	31	35.5	28	47	
M 56.0	5.5	200	70	31	35.5	28	50.5	