

BRITISH STANDARD WHITWORTH FORM THREADS (55° angle)						
DIA.	BSW		BSF		BSP & BSPT	
Sizes	TPI	Tapping Drill MM	TPI	Tapping Drill MM	TPI	Tapping Drill MM
1/16"	60	1.2				
3/32"	48	1.9				
1/8"	40	2.55			28	8.8
5/32"	32	3.2				
3/16"	24	3.7	32	4.0		
7/32"	24	4.5	28	4.6		
1/4"	20	5.1	26	5.3	19	11.8
9/32"	20	5.8	26	6.0		
5/16"	18	6.5	22	6.8		
3/8"	16	7.9	20	8.3	19	15.25
7/16"	14	9.3	18	9.7		
1/2"	12	10.5	16	11.1	14	19.0
9/16"	12	12.1	16	12.7		
5/8"	11	13.5	14	14	14	21.0
11/16"	11	15.1	14	15.5		
3/4"	10	16.25	12	16.75	14	24.5
7/8"	9	19.25	11	19.75	14	28.25
15/16"	9	20.6	11	21.5		
1"	8	22.0	10	22.75	11	30.75
1.1/8"	7	24.75	9	25.5		
1.1/4"	7	28.0	9	28.5	11	39.5
1.3/8"	6	30.1	8	31.5		
1.1/2"	6	33.5	8	34.5	11	45.00
1.5/8"	5	35.7	8	37.7		
1.3/4"	5	39	7	41.0	11	51.0
1.7/8"	4.1/2	41.3	7	43.7		
2"	4.1/2	44.5	7	47.0	11	57.0

BRITISH STD CYCLE (60°)		
Sizes	TPI	Tapping Drill MM
1/8"	40	2.65
5/32"	32	3.3
3/16"	32	4.1
1/4"	26	5.6
5/16"	26	7.2
3/8"	26	8.7
7/16"	26	10.3
1/2"	26	11.9
9/16"	20	13.1
9/16"	26	13.5
5/8"	20	14.5
5/8"	26	15.0
3/4"	20	17.8
3/4"	26	18.2

BA (47.1/2°)				
Sizes	Dia	Pitch	TPI	Tapping Drill MM
0	6.0	1.0	25.4	5.1
1	5.3	0.9	28.2	4.5
2	4.7	0.81	31.4	4.0
3	4.1	0.73	34.8	3.4
4	3.6	0.66	38.5	3.0
5	3.2	0.59	43.0	2.65
6	2.8	0.53	47.9	2.3
7	2.5	0.48	52.9	2.05
8	2.2	0.43	59.1	1.8
9	1.9	0.39	65.1	1.55
10	1.7	0.35	72.6	1.4
11	1.5	0.31	81.9	1.2
12	1.3	0.28	90.9	1.05
13	1.2	0.25	102.0	0.98
14	1.0	0.23	109.9	0.80
15	0.9	0.21	120.5	0.70
16	0.79	0.19	133.3	0.60

METRIC FORM THREADS (coarse) (60° angle)					
Sizes	Pitch	Tapping Drill MM	Sizes	Pitch	Tapping Drill MM
0.8	.19	0.6	10	1.5	8.5
0.9	.21	0.7	11	1.5	9.5
1	.25	0.8	12	1.75	10.2
1.2	.25	1.0	14	2	12.0
1.3	.28	1.05	16	2	14.0
1.4	.3	1.1	18	2.5	15.5
1.5	.3	1.2	20	2.5	17.5
1.6	.35	1.25	22	2.5	19.5
1.7	.35	1.35	24	3	21.0
1.8	.35	1.45	25		
1.9	.39	1.55	27	3	24.0
2	.4	1.60	30	3.5	26.5
2.2			32	3.5	30.5
2.3			33	3.5	29.5
2.5	.45	2.05	36	4	32.0
2.6			39	4	35.0
3	.5	2.5	40		
3.5	.6	2.9	42	4.5	37.5
4	.7	3.3	45	4.5	40.5
4.5	.75	3.7	48	5	43.0
5	.8	4.2	50		
6	1	5.0	52	5	47.0
7	1	6.0	56	5.5	50.5
8	1.25	6.8	60	5.5	45.5
9	1.25	7.75			

Spark plug taps			Metric Conduit taps		
Sizes mm	Pitch	Drill	Sizes mm	Pitch	Drill
10	1.0		16	1.5	
12	1.25		20	1.5	
14	1.25		32	1.5	
18	1.5		50	1.5	