

Thread Identification and Drill Chart



METRIC

DIAMETER IN INCHES	THREAD SIZE MM	ISO COARSE			OTHER FINE PITCH	ISO FINE			BA				
		PITCH	DRILL SIZE INCH	MM		PITCH	DRILL SIZE INCH	MM	SIZE	DIAMETER INCH	MM	PITCH	DRILL MM
.079	M2	.40		2.1					0	0.236	6.0	1	6.2
.087	M2.2	.45	No.42	2.3					2	0.185	4.7	0.8	4.9
.098	M2.5	.45	No.37	2.6					4	0.142	3.6	0.66	3.8
.118	M3	.5	1/8	3.2					6	0.11	2.8	0.53	2.9
.138	M3.5	.6	No.27	3.7					8	0.86	2.2	0.43	2.3
.157	M4	.7	11/64	4.2					10	0.67	1.7	0.35	1.7
.197	M5	.8	3/64	5.2									
.236	M6	1	1/4	6.3									
.276	M7	1	9/32	7.3									
.315	M8	1.25	21/64	8.3	.75	1	21/64	8.3					
.354	M9	1.25		9.4		1		9.3					
.394	M10	1.5	13/32	10.4	1*	1.25	13/32	10.25					
.433	M11	1.5		11.5	1	1.25		11.25					
.472	M12	1.75	31/64	12.5	1, 1.25*	1.5	31/64	12.25					
.512	M13	1.75		13.5	1.25	1.5		13.25					
.551	M14	2	37/64	14.5	1.25*	1.5	9/16	14.25					
.630	M16	2	21/32	16.5		1.5	21/32	16.5					
.709	M18	2.5	47/64	18.75	1.5*	2	23/32	18.5					
.787	M20	2.5	13/16	20.75	1.5	2	3/16	20.5					
.866	M22	2.5		22.75	1.5	2		22.5					
.945	M24	3		24.75	1.5	2		24.5					

* M10 - 1, M12 - 1.25, M14 - 1.25, M18 - 1.5 - popular sparkplug sizes. Above M24 is available on request.

INCH

DIAMETER IN INCHES		THREAD SIZE MM	THREADS PER INCH (TPI)						DRILL SIZE						
			UNC	BSW (SAE)	UNF	BSF	BSP*	NPT*	UNC/BSW		UNF/SAE/BSF		BSP/NPT		
	MM							INCH	MM	INCH	MM	INCH	MM		
.86	2.18	#2	56	40	64			3/32	2.3	No.37	2.3				
.99	2.51	#3	48		56			No.36	2.7		2.7				
.112	2.84	#4	40		48			No.31	3.0	No.31	3.0				
.125	3.17	#5, 1/8	40	40	44		28	No.29	3.4		3.3	3/8	9.9		
.138	3.50	#6	32		40			No.25	3.7	No.26	3.7				
.164	4.16	#8	32		36			11/64	4.4	11/64	4.4				
.190	4.82	#10, 3/16	24		32			13/64	5.1	13/64	5.1				
.187	4.76	#3/16		24		32		13/64	5.0	13/64	5.0				
.216	5.49	#12, 7/32	24		28			15/64	5.6						
.250	6.35	1/4	20	20	28	26	19	17/64	6.7	17/64	6.6	33/64	13.5		
.312	7.93	5/16	18	18	24	22		21/64	8.3	21/64	8.2				
.375	9.52	3/8	16	16	24	20	19	25/64	9.9	25/64	9.8	21/32	17.0		
.437	11.11	7/16	14	14	20	18		29/64	11.5	29/64	11.5				
.500	12.70	1/2	13	12	20	16	14	17/32	13.0	33/64	13.0	13/16	21.5		
.562	14.28	9/16	12	12	18	16		19/32	14.5	37/64	14.5				
.625	15.87	5/8	11	11	18	14		21/32	16.5	41/64	16.25				
.750	19.05	3/4	10	10	16	12	14	25/32	19.75	49/64	19.5	1 1/64	27.0		
.875	22.22	7/8	9	6	14	11		29/32	23.0	57/64	22.5				
1.00	25.40	1"	8	8	12, 14	10	11	1 1/32	26.0	1 1/64	26.0	1 9/32	33.5		
1.125	28.57	1 1/8"	7	7	12	9	11	1 5/32	29.5	1 5/32	29.5				
1.25	31.75	1 1/4"	7	7	12	9	11	1 9/32	33.0	1 9/32	32.5				
1.375	34.92	1 3/8"	6	6	12	8	11	1 13/32	36.0	1 13/32	36.0				
1.50	38.10	1 1/2"	6	6	12	8	11	1 17/32	39.0	1 17/32	39.0				

* Nominal diameters for BSP and NPT are not thread diameters but relate to the inside diameter of the pipe.