

PRESTO

TAP DRILLS & SCREW THREAD CHART PREFERRED THREAD SERIES

METRIC (I.S.O.)			*M10.0			M25.0			1.50			23.50		
Nominal Dia. of Threads mm.	Pitch (P) mm.	Tapping Drill Dia. mm.	M10.0	1.25	8.80	M25.0	2.00	23.00	M10.0	1.50	8.50	M27.0	1.50	25.50
M2.0	0.25	1.75	M11.0	1.00	10.00	M27.0	3.00	24.00	M11.0	1.50	9.50	M28.0	1.50	26.50
M2.0	0.40	1.60	M12.0	1.00	11.00	M30.0	1.50	28.50	M12.0	1.25	10.80	M30.0	3.50	26.50
M2.2	0.25	1.95	M12.0	1.50	10.50	M32.0	1.50	30.50	M12.0	1.75	10.20	M33.0	2.00	31.00
M2.2	0.45	1.75	M14.0	1.00	13.00	M33.0	3.50	29.50	M14.0	1.25	12.80	M36.0	3.00	33.00
M2.5	0.35	2.15	M14.0	1.50	12.50	M36.0	4.00	32.00	M14.0	2.00	12.00	M39.0	3.00	36.00
M2.5	0.45	2.05	M16.0	1.00	15.00	M39.0	4.00	35.00	M16.0	1.50	14.50	M40.0	1.50	38.50
M3.0	0.35	2.65	M16.0	2.00	14.00	M40.0	3.00	37.00	M16.0	2.50	13.50	M42.0	4.00	38.00
M3.0	0.50	2.50	M18.0	1.00	17.00	M42.0	4.00	38.00	M18.0	1.50	16.50	M42.0	4.50	37.50
M3.5	0.35	3.15	M18.0	2.00	16.00	M45.0	4.00	41.00	M18.0	2.50	15.50	M45.0	4.50	40.50
M3.5	0.60	2.90	M20.0	1.00	19.00	M45.0	4.50	40.50	M20.0	1.50	18.50	M48.0	4.00	44.00
M4.0	0.50	3.50	M20.0	2.00	18.00	M48.0	5.00	43.00	M20.0	2.50	17.50	M52.0	4.00	48.00
M4.0	0.70	3.30	M22.0	1.00	21.00	M52.0	5.00	47.00	M22.0	1.50	20.50	M56.0	4.00	52.00
M4.5	0.5	4.00	M22.0	2.00	20.00	M56.0	5.50	50.50	M22.0	2.50	19.50	M60.0	4.00	56.00
M4.5	0.75	3.70	M24.0	1.00	23.00	M60.0	5.50	54.50	M24.0	1.50	22.50			
M5.0	0.5	4.50	M24.0	2.00	22.00				M24.0	2.00	22.00			
M5.0	0.8	4.20	M24.0	3.00	21.00									
M6.0	0.75	5.20												
M6.0	1.00	5.00												
M7.0	0.75	6.20												
M7.0	1.00	6.00												
M8.0	0.75	7.20												
M8.0	1.00	7.00												
M8.0	1.25	6.80												
M9.0	0.75	8.20												
M9.0	1.00	8.00												
M9.0	1.25	7.80												

* Spark Plug Pitches

UNIFIED NATIONAL COARSE (U.N.C.)			
Nominal Dia. of Threads	Pitch (P) mm.	T.P.I.	Tapping Drill Dia. mm.
No. 1	0.397	64	1.55
No. 2	0.454	56	1.85
No. 3	0.529	48	2.10
No. 4	0.635	40	2.35
No. 5	0.635	40	2.65
No. 6	0.794	32	2.85
No. 8	0.794	32	3.50
No. 10	1.058	24	3.90
No. 12	1.058	24	4.50
1/4"	1.270	20	5.10
5/16"	1.411	18	6.60
3/8"	1.588	16	8.00
7/16"	1.814	14	9.40
1/2"	1.954	13	10.80
9/16"	2.117	12	12.20
5/8"	2.309	11	13.50
3/4"	2.540	10	16.50
7/8"	2.822	9	19.50
1"	3.175	8	22.25
1.1/8"	3.629	7	25.00
1.1/4"	3.629	7	28.00
1.3/8"	4.233	6	30.75
1.1/2"	4.233	6	34.00
1.3/4"	5.080	5	39.50

UNIFIED NATIONAL FINE (U.N.F.)			
Nominal Dia. of Threads	Pitch (P) mm.	T.P.I.	Tapping Drill Dia. mm.
No. 0	0.318	80	1.25
No. 1	0.353	72	1.55
No. 2	0.397	64	1.90
No. 3	0.454	56	2.15
No. 4	0.529	48	2.40
No. 5	0.577	44	2.70
No. 6	0.635	40	2.95
No. 8	0.706	36	3.50
No. 10	0.794	32	4.10
No. 12	0.907	28	4.70
1/4"	0.907	28	5.50
5/16"	1.058	24	6.90
3/8"	1.058	24	8.50
7/16"	1.270	20	9.90
1/2"	1.270	20	11.50
9/16"	1.411	18	12.90
5/8"	1.411	18	14.50
3/4"	1.588	16	17.50
7/8"	1.814	14	20.40
1"	2.117	12	23.25
1.1/8"	2.117	12	26.50
1.1/4"	2.117	12	29.50
1.3/8"	2.117	12	32.75

PREFERRED THREAD SERIES

BRITISH STANDARD PIPE PARALLEL (B.S.P.PI.) Rp			
Nominal Dia. of Threads	Pitch (P) mm.	T.P.I.	Tapping Drill Dia. mm.
1/8"	0.907	28	8.60
1/4"	1.337	19	11.50
3/8"	1.337	19	15.00
1/2"	1.814	14	18.75
3/4"	1.814	14	24.25
1"	2.309	11	30.40
1.1/4"	2.309	11	39.00
1.1/2"	2.309	11	45.00
2"	2.309	11	56.75

BRITISH STANDARD PIPE FASTENING (B.S.P.F.) G			
Nominal Dia. of Threads	Pitch (P) mm.	T.P.I.	Tapping Drill Dia. mm.
1/8"	0.907	28	8.80
1/4"	1.337	19	11.80
3/8"	1.337	19	15.25
1/2"	1.814	14	19.00
5/8"	1.814	14	21.00
3/4"	1.814	14	24.50
7/8"	1.814	14	28.25
1"	2.309	11	30.75
1.1/4"	2.309	11	39.50
1.1/2"	2.309	11	45.00
1.3/4"	2.309	11	51.00
2"	2.309	11	57.00

NON-PREFERRED THREAD SERIES

BRITISH STANDARD WHITWORTH (B.S.W.)			
Nominal Dia. of Threads	Pitch (P) inch	T.P.I.	Tapping Drill Dia. mm.
1/8"	0.0250	40	2.35
3/16"	0.0417	24	3.70
1/4"	0.0500	20	5.10
5/16"	0.0556	18	6.50
3/8"	0.0625	16	7.90
7/16"	0.0714	14	9.30
1/2"	0.0833	12	10.50
9/16"	0.0833	12	12.10
5/8"	0.0909	11	13.50
11/16"	0.0909	11	15.00
3/4"	0.1000	10	16.25
7/8"	0.1111	9	19.25
1"	0.1250	8	22.00
1.1/8"	0.1429	7	24.75
1.1/4"	0.1429	7	28.00
1.1/2"	0.1667	6	33.50
1.3/4"	0.2000	5	39.00
2"	0.2222	4.5	44.50

BRITISH STANDARD FINE (B.S.F.)			
Nominal Dia. of Threads	Pitch (P) inch	T.P.I.	Tapping Drill Dia. mm.
3/16"	0.0312	32	4.00
7/32"	0.0357	28	4.60
1/4"	0.0385	26	5.30
9/32"	0.0385	26	6.10
5/16"	0.0455	22	6.80
3/8"	0.0500	20	8.30
7/16"	0.0556	18	9.70
1/2"	0.0625	16	11.10
9/16"	0.0625	16	12.70
5/8"	0.0714	14	14.00
11/16"	0.0714	14	15.50
3/4"	0.0833	12	16.75
7/8"	0.0909	11	19.75
1"	0.1000	10	22.75
1.1/8"	0.1111	9	25.50
1.1/4"	0.1111	9	28.50
1.3/8"	0.1250	8	31.50
1.1/2"	0.1250	8	34.50

BRITISH ASSOCIATION (B.A.)			
Nominal Dia. of Threads	Pitch (P) mm.	T.P.I.	Tapping Drill Dia. mm.
No. 0	1.00		5.10
No. 1	0.90		4.50
No. 2	0.81		4.00
No. 3	0.73		3.40
No. 4	0.66		3.00
No. 5	0.59		2.65
No. 6	0.53		2.30
No. 7	0.48		2.05
No. 8	0.43		1.80
No. 9	0.39		1.55
No. 10	0.35		1.40

PRESTO TOOLS

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