

CONVERSION CHARTS

**Tapping Drill Tables Metric Threads,
Coarse & Fine Pitch (Dimensions in mm)**

Diameter	Coarse Pitch	Fine Pitch	Tapping Hole
M2	0.4	-	1.60
M2.5	0.45	-	2.05
M3	0.5	-	2.50
M3.5	0.6	-	2.90
M4	0.7	-	3.30
M4.5	0.75	-	3.70
M5	0.8	-	4.20
M6	1	-	5.00
M8	1.25	-	6.80
M10	1.5	-	8.50
M10	-	1.25	8.80
M12	1.75	-	10.20
M12	-	1.25	10.80
M12	-	1.5	10.50
M14	2	-	12.00
M14	-	1.5	12.50
M16	2	-	14.00
M16	-	1.5	14.50
M18	2.5	-	15.50
M18	-	1.5	16.50
M20	2.5	-	17.50
M20	-	1.5	18.50
M22	2.5	-	19.50
M22	-	1.5	20.50
M24	3	-	21.00
M24	-	1.5	22.50
M24	-	2	22.00
M27	3	-	24.00
M30	3.5	-	26.50
M33	3.5	-	29.50
M36	4	-	32.00

**Drill Tapping Tables Imperial UNF Threads
(Dimensions in mm)**

Diameter	Pitch TPI	Tapping Hole
#1	72	1.60
#2	64	1.90
#3	56	2.15
#4	48	2.40
#5	44	2.70
#6	40	2.95
#8	36	3.50
#10	32	4.10
#12	28	4.70
1/4	28	5.50
5/16	24	6.90
3/8	24	8.50
7/16	20	10.00
1/2	20	11.50
9/16	18	12.80
5/8	18	14.50
3/4	16	17.50
7/8	14	20.50
1	12	23.50
1	14	24.00
1 1/8	12	26.50
1 1/4	12	29.50
1 3/8	12	33.00
1 1/2	12	36.00

**Drill Tapping Tables Imperial UNC Threads
(Dimensions in mm)**

Diameter	Pitch TPI	Tapping Hole
#1	64	1.50
#2	56	1.85
#3	48	2.10
#4	40	2.35
#5	40	2.65
#6	32	2.85
#8	32	3.50
#10	24	3.90
#12	24	4.50
1/4	20	5.10
5/16	18	6.60
3/8	16	8.00
7/16	14	9.50
1/2	13	10.80
9/16	12	12.20
5/8	11	13.50
3/4	10	16.50
7/8	9	19.50
1	8	22.50
1 1/8	7	25.00
1 1/4	7	28.00
1 3/8	6	31.00
1 1/2	6	34.00

**Tapping Drill Tables Imperial BSW Threads
(Dimensions in mm)**

Diameter	BSW Pitch TPI	Tapping Hole
1/16	60	1.20
3/32	48	1.90
1/8	40	2.55
5/32	32	3.20
3/16	24	3.70
7/32	24	4.50
1/4	20	5.10
5/16	18	6.50
3/8	16	7.90
7/16	14	9.50
1/2	12	10.50
9/16	12	12.20
5/8	11	13.50
3/4	10	16.50
7/8	9	19.50
1	8	22.00
1 1/8	7	25.00
1 1/4	7	28.00
1 1/2	6	33.50
1 3/4	5	39.00
2	4.5	44.50

Screw Gauge Conversion Chart

2g	=	2.2mm
4g	=	2.9mm
6g	=	3.5mm
7g	=	3.9mm
8g	=	4.2mm
10g	=	4.8mm

For more technical support, please contact your local **United Fasteners** branch

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ISO Imperial Threads Diameter/Pitch Combinations			
Diameter	UNC	UNF	BSW
# 0	-	80	-
# 1	64	72	-
# 2	56	64	-
# 3	48	56	-
# 4	40	48	-
# 5	40	44	40
# 6	32	40	-
# 8	32	36	-
# 10	24	32	24
# 12	24	28	-
1/4	20	28	20
5/16	18	24	18
3/8	16	24	16
7/16	14	20	14
1/2	13	20	12
9/16	12	18	12
5/8	11	18	11
3/4	10	16	10
7/8	9	14	9
1	8	12 (14)	8
1 1/8	7	12	7
1 1/4	7	12	7
1 3/8	6	12	6
1 1/2	6	12	6
1 5/8	-	-	5
1 3/4	5	-	5
1 7/8	-	-	-
2	4.5	-	4.5
2 1/4	4.5	-	4
2 1/2	4	-	3.5
2 3/4	4	-	3.25

ISO Metric Threads Diameter/Pitch Combinations			
Diameter	Coarse Thread	Fine Thread	Extra Fine Thread
M1.6	0.35	0.25	-
M2	0.40	0.25	-
M2.5	0.45	0.35	-
M3	0.50	0.35	-
M3.5	0.60	-	-
M4	0.70	0.50	-
M5	0.80	0.50	-
M6	1.00	0.75	-
M8	1.25	1.00	0.75
M10	1.50	1.25	1.00
M12	1.75	1.50	1.25
M14	2.00	1.25	1.00
M16	2.00	1.50	1.00
M18	2.50	1.50	-
M20	2.50	2.00	1.50
M22	2.50	2.00	-
M24	3.00	2.00	1.50
M27	3.00	2.00	-
M30	3.50	2.00	-
M33	3.50	2.00	-
M36	4.00	3.00	-
M39	4.00	3.00	-
M42	4.50	4.00	-
M45	4.50	4.00	-
M48	5.00	4.00	-
M52	5.00	4.00	-
M56	5.50	4.00	-
M60	5.50	4.00	-
M64	6.00	4.00	-
M72	6.00	4.00	-

Length Conversion Chart			
Imperial (Inches)	Metric (mm)	Imperial (Inches)	Metric (mm)
1/64	0.397	1	25.4
1/32	0.794	1 - 1/4	31.75
3/64	1.19	1 - 3/8	34.93
1/16	1.587	1 - 1/2	38.1
5/64	2	1 - 3/4	44.45
3/32	2.381	2	50.8
7/64	2.778	2 - 1/4	57.15
1/8	3.175	2 - 1/2	63.5
9/64	3.571	2 - 3/4	69.85
5/32	3.968	3	76.2
11/64	4.365	3 - 1/4	82.55
3/16	4.762	3 - 1/2	88.9
13/64	5.159	4	101.6
7/32	5.556	4 - 1/2	114.3
15/64	5.953	4 - 3/4	120.7
1/4	6.35	5	127
17/64	6.746	5 - 1/2	139.7
9/32	7.143	6	152.4
19/64	7.54	6 - 1/2	165.1
5/16	7.937	7	177.8
21/64	8.334	7 - 1/2	190.5
11/32	8.731	8	203.2
23/64	9.128	9	228.6
3/8	9.525	10	254
25/64	9.921	10-1/4	260.35
13/32	10.318	10-1/2	266.7
27/64	10.715	10-3/4	273.05
7/16	11.112	11	279.4
29/64	11.509	11-1/4	285.75
15/32	11.908	11-1/2	292.1
31/64	12.303	11-3/4	298.45
1/2	12.7	12	304.8
33/64	13.097		
17/32	13.494		
35/64	13.891		
9/16	14.288		
37/64	14.684		
19/32	15.081		
39/64	15.478		
5/8	15.875		
41/64	16.272		
21/32	16.669		
43/64	17.066		
11/16	17.462		
45/64	17.859		
23/32	18.256		
47/64	18.653		
3/4	19.05		
49/64	19.447		
25/32	19.844		
51/64	20.241		
13/16	20.638		
53/64	21.034		
27/32	21.431		
55/64	21.828		
7/8	22.225		
57/64	22.622		
29/32	23.019		
59/64	23.416		
15/16	23.812		
61/64	24.209		
31/32	24.606		
63/64	25.003		