



Tapping size holes for thread cutting

Std. ISO metric threads DIN 13					ISO metric fine threads DIN 13					UNC threads ASME B1.1					UNF threads ASME B1.1					(Whitworth) threads (DIN-ISO 228-1)					
nom. Ø	pitch P	tapping size hole Ø	core diameter of int. thread 6H*		nom. Ø	x	pitch P	tapping size hole Ø	core diameter of int. thread 6H		nom. Ø	threads	tapping size hole Ø	core diameter of int. thread 2B		nom. Ø	threads	tapping size hole Ø	core diameter of int. thread 2B		nom. Ø	threads	tapping size hole Ø	core diameter of int. thread	
		DIN 336 mm	min. mm	max. mm				DIN 336 mm	min. mm	max. mm			DIN 336 mm	min. mm	max. mm			DIN 336 mm	min. mm	max. mm			DIN 336 mm	min. mm	max. mm
	mm						mm					per inch					per inch				inch	per inch			
M 1	0.25	0.75	0.729	0.785	M 2.5	x	0.35	2.15	2.121	2.221	Nr. 1	- 64	1.55	1.425	1.580	Nr. 1	- 72	1.55	1.473	1.610	G 1/16	28	6.80	6.561	6.843
M 1.1	0.25	0.85	0.829	0.885	M 3.0	x	0.35	2.65	2.621	2.721	Nr. 2	- 56	1.85	1.694	1.872	Nr. 2	- 64	1.85	1.755	1.910	G 1/8	28	8.80	8.566	8.848
M 1.2	0.25	0.95	0.929	0.985	M 3.5	x	0.35	3.15	3.121	3.221	Nr. 3	- 48	2.10	1.941	2.146	Nr. 3	- 56	2.15	2.024	2.197	G 1/4	19	11.80	11.445	11.890
M 1.4	0.30	1.10	1.075	1.142	M 4.0	x	0.50	3.50	3.459	3.599	Nr. 4	- 40	2.35	2.157	2.385	Nr. 4	- 48	2.40	2.271	2.459	G 3/8	19	15.25	14.950	15.395
M 1.6	0.35	1.25	1.221	1.321	M 4.5	x	0.50	4.00	3.959	4.099	Nr. 5	- 40	2.65	2.487	2.698	Nr. 5	- 44	2.70	2.550	2.741	G 1/2	14	19.00	18.631	19.172
M 1.8	0.35	1.45	1.421	1.521	M 5.0	x	0.50	4.50	4.459	4.599	Nr. 6	- 32	2.85	2.642	2.896	Nr. 6	- 40	2.95	2.819	3.023	G 5/8	14	21.00	20.587	21.128
M 2	0.40	1.60	1.567	1.679	M 5.5	x	0.50	5.00	4.959	5.099	Nr. 8	- 32	3.50	3.302	3.531	Nr. 8	- 36	3.50	3.404	3.607	G 3/4	14	24.50	24.117	24.658
M 2.2	0.45	1.75	1.713	1.838	M 6.0	x	0.75	5.20	5.188	5.378	Nr. 10	- 24	3.90	3.683	3.937	Nr. 10	- 32	4.10	3.962	4.166	G 7/8	14	28.25	27.877	28.418
M 2.5	0.45	2.05	2.013	2.138	M 7.0	x	0.75	6.20	6.188	6.378	Nr. 12	- 24	4.50	4.343	4.597	Nr. 12	- 28	4.60	4.496	4.724	G 1	11	30.75	30.291	30.931
M 3	0.50	2.50	2.459	2.599	M 8.0	x	0.50	7.50	7.459	7.599	1/4	- 20	5.10	4.978	5.258	1/4	- 28	5.50	5.359	5.588	G 1 1/8	11	35.50	34.939	35.579
M 3.5	0.60	2.90	2.850	3.010	M 8.0	x	0.75	7.20	7.188	7.378	5/16	- 18	6.60	6.401	6.731	5/16	- 24	6.90	6.782	7.036	G 1 1/4	11	39.50	38.952	39.592
M 4	0.70	3.30	3.242	3.422	M 8.0	x	1.00	7.00	6.917	7.153	3/8	- 16	8.00	7.798	8.153	3/8	- 24	8.50	8.382	8.636	G 1 1/2	11	45.25	44.845	45.485
M 4.5	0.75	3.70	3.688	3.878	M 9.0	x	0.75	8.20	8.188	8.378	7/16	- 14	9.40	9.144	9.550	7/16	- 20	9.90	9.728	10.033	G 1 3/4	11	51.00	50.788	51.428
M 5	0.80	4.20	4.134	4.334	M 9.0	x	1.00	8.00	7.917	8.153	1/2	- 13	10.80	10.592	11.024	1/2	- 20	11.50	11.328	11.608	G 2	11	57.00	56.656	57.296
M 6	1.00	5.00	4.917	5.153	M 10	x	0.75	9.20	9.188	9.378	9/16	- 12	12.20	11.989	12.446	9/16	- 18	12.90	12.751	13.081					
M 7	1.00	6.00	5.917	6.153	M 10	x	1.00	9.00	8.917	9.153	5/8	- 11	13.50	13.386	13.868	5/8	- 18	14.50	14.351	14.681					
M 8	1.25	6.80	6.647	6.912	M 10	x	1.25	8.80	8.647	8.912	3/4	- 10	16.50	16.307	16.840	3/4	- 16	17.50	17.323	17.678					
M 9	1.25	7.80	7.647	7.912	M 11	x	0.75	10.20	10.188	10.378	7/8	- 9	19.50	19.177	19.761	7/8	- 14	20.40	20.269	20.650					
M 10	1.50	8.50	8.376	8.676	M 11	x	1.00	10.00	9.917	10.153	1	- 8	22.25	21.971	22.606	1	- 12	23.25	23.114	23.571					
M 11	1.50	9.50	9.376	9.676	M 12	x	1.00	11.00	10.917	11.153	1 1/8	- 7	25.00	24.638	25.349	1 1/8	- 12	26.50	26.289	26.746					
M 12	1.75	10.20	10.106	10.441	M 12	x	1.25	10.80	10.647	10.912	1 1/4	- 7	28.00	27.813	28.524	1 1/4	- 12	29.50	29.464	29.921					
M 14	2.00	12.00	11.835	12.210	M 12	x	1.50	10.50	10.376	10.676	1 3/8	- 6	30.75	30.353	31.115	1 3/8	- 12	32.75	32.639	33.096					
M 16	2.00	14.00	13.835	14.210	M 14	x	1.00	13.00	12.917	13.153	1 1/2	- 6	34.00	33.528	34.290	1 1/2	- 12	36.00	35.814	36.271					
M 18	2.50	15.50	15.294	15.744	M 14	x	1.25	12.80	12.647	12.912	1 3/4	- 5	39.50	38.938	39.802										
M 20	2.50	17.50	17.294	17.744	M 14	x	1.50	12.50	12.376	12.676	2	- 4.5	45.00	44.679	45.593										
M 22	2.50	19.50	19.294	19.744	M 15	x	1.00	14.00	13.917	14.153															
M 24	3.00	21.00	20.752	21.252	M 15	x	1.50	13.50	13.376	13.676															
M 27	3.00	24.00	23.752	24.252	M 16	x	1.00	15.00	14.917	15.153															
M 30	3.50	26.50	26.211	26.771	M 16	x	1.25	14.80	14.647	14.912															
M 33	3.50	29.50	29.211	29.771	M 16	x	1.50	14.50	14.376	14.676															
M 36	4.00	32.00	31.670	32.270	M 17	x	1.00	16.00	15.917	16.153															
M 39	4.00	35.00	34.670	35.270	M 17	x	1.50	15.50	15.376	15.676															
M 42	4.50	37.50	37.129	37.799	M 18	x	1.00	17.00	16.917	17.153															
M 45	4.50	40.50	40.129	40.799	M 18	x	1.50	16.50	16.376	16.676															
M 48	5.00	43.00	42.587	43.297	M 20	x	1.00	19.00	18.917	19.153															
M 52	5.00	47.00	46.587	47.297	M 20	x	1.50	18.50	18.376	18.676															
M 56	5.50	50.50	50.046	50.796	M 20	x	2.00	18.00	17.835	18.210	Pg 7	20	11.40	11.280	11.430	1/16	- 27	6.39	9.29	10.7	W 1/16	60	1.20	1.045	1.230
					M 22	x	1.00	21.00	20.917	21.153	Pg 9	18	14.00	13.860	14.010	1/8	- 27	8.74	9.32	10.8	W 3/32	48	1.80	1.704	1.912
					M 22	x	1.50	20.50	20.376	20.676	Pg 11	18	17.30	17.260	17.410	1/4	- 18	11.36	13.52	15.6	W 1/8	40	2.50	2.362	2.591
					M 22	x	2.00	20.00	19.835	20.210	Pg 13.5	18	19.00	19.060	19.210	3/8	- 18	14.80	13.83	16.0	W 5/32	32	3.20	2.952	3.214