



SOMTA
World Class Cutting Tools

OSG GROUP COMPANY



shaping your dreams

Recommended Drill Sizes for Tapping

for 75% thread depth

METRIC COARSE / METRIC FINE - 60° included angle (*Fluteless)

Size	Metric Coarse		Metric Fine		Size	Metric Coarse		Metric Fine		Size	Metric Coarse		Metric Fine	
	Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm
1	0.25	0.75 (*0.9)	-	-	15	-	-	1.5	13.5	36	4	32 (*34)	1.5	34.5
1.1	0.25	0.85	-	-	16	2	14 (*15.1)	1	15	36	-	-	2	34
1.2	0.25	0.95 (*1.1)	-	-	16	-	-	1.5	14.5 (*15.3)	36	-	-	3	33
1.4	0.3	1.1 (*1.3)	-	-	17	-	-	1.5	15.5	38	-	-	1.5	36.5
1.6	0.35	1.25 (*1.5)	-	-	18	2.5	15.5 (*17)	1	17	38	-	-	2	36
1.8	0.35	1.45	-	-	18	-	-	1.25	16.8	39	4	35 (*37)	1.5	37.5
2	0.4	1.6 (*1.8)	0.25	1.75	18	-	-	1.5	16.5 (*17.3)	39	-	-	2	37
2.2	0.45	1.75	0.25	1.95	18	-	-	2	16	39	-	-	3	36
2.5	0.45	2.05 (*2.3)	0.35	2.15	20	2.5	17.5 (*18)	1	19	40	-	-	1.5	38.5
3	0.5	2.5 (*2.8)	0.35	2.65	20	-	-	1.5	18.5 (*19.3)	40	-	-	2	38
3.5	0.6	2.9 (*3.2)	0.35	3.15	20	-	-	2	18	40	-	-	3	37
4	0.7	3.3 (*3.7)	0.5	3.5	22	2.5	19.5 (*21)	1	21	42	4.5	37.5 (*40)	1.5	40.5
4.5	0.75	3.7 (*4.2)	0.5	4	22	-	-	1.5	20.5 (*21.3)	42	-	-	2	40
5	0.8	4.2 (*4.7)	0.5	4.5	22	-	-	2	20	42	-	-	3	39
5	-	-	0.75	4.3	24	3	21 (*22.5)	1	23	42	-	-	4	38
5.5	-	-	0.5	5	24	-	-	1.5	22.5 (*23.3)	45	4.5	40.5 (*43)	1.5	43.5
6	1	5 (*5.6)	0.75	5.25	24	-	-	2	22	45	-	-	2	43
7	1	6	0.75	6.25	25	-	-	1	24	45	-	-	3	42
8	1.25	6.8 (*7.4)	0.75	7.3	25	-	-	1.5	23.5	45	-	-	4	41
8	-	-	1	7 (*7.55)	25	-	-	2	23	48	5	43	1.5	46.5
9	1.25	7.8	0.75	8.3	27	3	24 (*25.5)	1.5	25.5	48	-	-	2	46
9	-	-	1	8	27	-	-	2	25	48	-	-	3	45
10	1.5	8.5 (*9.3)	0.75	9.3	28	-	-	1.5	26.5	48	-	-	4	44
10	-	-	1	9 (*9.55)	28	-	-	2	26	50	-	-	1.5	48.5
10	-	-	1.25	8.75 (*9.45)	30	3.5	26.5 (*28.5)	1	29	50	-	-	2	48
11	1.5	9.5	1	10	30	-	-	1.5	28.5	50	-	-	3	47
11	-	-	1.25	9.8	30	-	-	2	28	52	5	47	1.5	50.5
12	1.75	10.2 (*11.2)	1	11 (*11.55)	30	-	-	3	27	52	-	-	2	50
12	-	-	1.25	10.8 (*11.45)	32	3.5	28.5	1.5	30.5	52	-	-	3	49
12	-	-	1.5	10.5 (*11.3)	32	-	-	2	30	52	-	-	4	48
14	2	12 (*13.1)	1	13	33	3.5	29.5 (*31.5)	1.5	31.5	56	5.5	50.5	-	-
14	-	-	1.25	12.75 (*13.4)	33	-	-	2	31	60	5.5	54.5	-	-
14	-	-	1.5	12.5 (*13.3)	33	-	-	3	30	64	6	58	-	-
15	-	-	1	14	35	-	-	1.5	33.5	68	6	62	-	-

BRITISH STANDARD WHITWORTH / PIPE / BRASS 55° included angle

Size	BSW		BSF		BSP		BSPT		BSB	
	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm
1/16	60	1.2	-	-	-	-	-	-	-	-
3/32	48	1.9	-	-	-	-	-	-	-	-
1/8	40	2.55	-	-	28	8.8	28	8.6	-	-
5/32	32	3.2	-	-	-	-	-	-	-	-
3/16	24	3.7	32	4	-	-	-	-	-	-
7/32	24	4.5	28	4.7	-	-	-	-	-	-
1/4	20	5.1	26	5.4	19	11.8	19	11.5	26	5.4
9/32	-	-	26	6.2	-	-	-	-	-	-
5/16	18	6.5	22	6.8	-	-	-	-	26	7
3/8	16	8	20	8.3	19	15.5	19	15	26	8.5
7/16	14	9.3	18	9.8	-	-	-	-	26	10.1
1/2	12	10.5	16	11	14	19	14	18.5	26	11.7
9/16	12	12.2	16	12.7	-	-	-	-	-	-
5/8	11	13.5	14	14	14	21	-	-	26	15
11/16	11	15.2	14	15.5	-	-	-	-	-	-
3/4	10	16.5	12	16.5	14	24.5	14	24	26	18
7/8	9	19.5	11	19.5	14	28.5	-	-	-	-
1"	8	22	10	22.5	11	31	11	30.25	26	24.5
1.1/8	7	25	9	25.5	-	-	-	-	-	-
1.1/4	7	28	9	29	11	40	11	39	-	-
1.3/8	-	-	8	31.8	-	-	-	-	-	-
1.1/2	6	34	8	34.5	11	45.5	11	45	-	-
1.5/8	-	-	8	38	-	-	-	-	-	-
1.3/4	5	39	7	41	11	51.5	-	-	-	-
2"	4.5	45	7	47	11	57	11	56.5	-	-
2.1/4	4	51	6	53	11	63.3	-	-	-	-
2.1/2	4	57	6	59	11	72.8	-	-	-	-
2.3/4	3.5	63	6	66	-	-	-	-	-	-
3"	3.5	69	5	71	11	85.5	-	-	-	-
3.1/4	3.25	75	5	77	-	-	-	-	-	-
3.1/2	3.25	81	4.5	83	-	-	-	-	-	-
3.3/4	3	87	4.5	90	-	-	-	-	-	-
4"	3	93	4.5	96	-	-	-	-	-	-

UNIFIED NATIONAL / NATIONAL PIPE - 60° included angle

Size	Nom. Dia.	UNC		UNF		NPS		NPT	
		TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm
No.1	1.85	64	1.55	72	1.55	-	-	-	-
No.2	2.18	56	1.85	64	1.9	-	-	-	-
No.3	2.51	48	2	56	2.1	-	-	-	-
No.4	2.84	40	2.25	48	2.35	-	-	-	-
No.5	3.18	40	2.6	44	2.65	-	-	-	-
No.6	3.51	32	2.75	40	2.9	-	-	-	-
No.8	4.17	32	3.4	36	3.5	-	-	-	-
No.10	4.83	24	3.8	32	4.1	-	-	-	-
No.12	5.49	24	4.4	28	4.6	-	-	-	-
1/8	-	-	-	-	-	27	9.1	27	8.4
1/4	-	20	5.1	28	5.5	18	12	18	11
5/16	-	18	6.6	24	6.9	-	-	-	-
3/8	-	16	8	24	8.5	18	15.5	18	14.25
7/16	-	14	9.4	20	9.8	-	-	-	-
1/2	-	13	10.8	20	11.5	14	19	14	17.5
9/16	-	12	12.2	18	12.8	-	-	-	-
5/8	-	11	13.5	18	14.5	-	-	-	-
3/4	-	10	16.5	16	17.5	14	24.5	14	23
7/8	-	9	19.5	14	20.5	-	-	-	-
1"	-	8	22	12	23.5	11.5	30.5	11.5	29
1.1/8	-	7	25	12	26.5	-	-	-	-
1.1/4	-	7	28	12	29.5	11.5	39.4	11.5	37.5
1.3/8	-	6	31	12	32.5	-	-	-	-
1.1/2	-	6	34	12	36	11.5	45.5	11.5	43.5
1.3/4	-	5	39	-	-	-	-	-	-
2"	-	4.5	45	-	-	11.5	57.5	11.5	55.5

BRITISH ASSOCIATION - 47½° included angle

Size	Nom. Dia.	TPI	Drill Size in mm	Size	Nom. Dia.	TPI	Drill Size in mm
No.12	1.3	90.1	1.05	No.5	3.2	43.1	2.65
No.10	1.7	72.6	1.4	No.4	3.6	38.3	3
No.9	1.9	65.1	1.55	No.3	4.1	34.8	3.4
No.8	2.2	59.1	1.8	No.2	4.7	31.3	3.9
No.7	2.5	52.9	2.05	No.1	5.3	28.2	4.5
No.6	2.8	47.9	2.3	No.0	6	25.4	5.1