

Threaded holes – hole size Metric ISO threads and inch threads

Rolled taps (fluteless taps)

THREAD	Inch sizes	Pitch	Hole Ø	Tolerance minimum	Tolerance maximum
M3	-	0.5	2.80	2.82	2.82
M3.5	-	0.6	3.25	3.25	3.28
M4	-	0.7	3.70	3.70	3.73
MF5	-	0.5	4.80	4.80	4.82
M5	-	0.8	4.65	4.65	4.68
M6	-	1	5.55	5.55	5.58
MF6X0.75	-	0.75	5.65	5.65	5.58
MF78	-	0.75	6.65	6.65	5.68
M7	-	1	6.55	6.55	5.68
MF8	-	0.75	7.65	7.65	5.58
MF8	-	1	7.55	7.55	7.68
M8	-	1.25	7.45	7.45	7.58
MF10	-	1	9.55	9.55	7.49
MF10	-	1.25	9.45	9.45	9.58
M10	-	1.5	9.35	9.35	9.49
MF12	-	1	11.55	11.55	11.58
MF12	-	1.25	11.45	11.45	11.49
MF12	-	1.5	11.35	11.35	11.39
M12	-	1.75	11.20	11.20	11.25
MF14	-	1	13.55	13.55	13.58
MF14	-	1.25	13.45	13.45	13.49
MF14	-	1.5	13.35	13.35	13.39
M14	-	2	13.10	13.10	13.15
MF16	-	1.5	15.35	15.35	15.39
M16	-	2	15.10	15.10	15.15
M20	-	2.5	18.90	18.90	18.95
M24	-	3	22.65	22.65	22.70

Threaded holes – hole size Metric ISO threads and inch threads

Rolled taps (fluteless taps)

THREAD	Inch sizes	Pitch	Hole Ø	Tolerance minimum	Tolerance maximum
M2	-	0.4	1.60	1.570	1.670
M2,5	-	0.45	2.05	2.015	2.130
-	UNC4-40	-	2.35	2.160	2.380
M3	-	0.5	2.50	2.470	2.590
-	UNC5-40	-	2.65	2.490	2.690
-	UNC6-32	-	2.85	2.645	2.890
M3,500	-	0.6	2.90	2.850	3.000
M4	-	0.7	3.30	3.250	3.400
-	UNC8-32	-	3.50	3.350	3.530
M4,5	-	0.75	3.70	3.690	3.870
-	UNC10-24	-	3.90	3.685	3.960
M5	-	0.8	4.20	4.140	4.330
-	UNC12-24	-	4.50	4.350	4.590
M6	-	1	5.00	4.920	5.150
-	UNC1/4-20	-	5.10	4.980	5.260
M7	-	1	6.00	5.980	6.260
-	NPT1/16	-	6.15	6.200	TAPER 1:16
-	UNC5/16-18	-	6.60	6.415	6.730
M8	-	1.25	6.80	6.650	6.910
-	UNC3/8-16	-	8.00	7.810	8.160
-	NPT1/8	-	8.40	8.500	TAPER 1:16
M10	-	1.5	8.50	8.380	8.675
-	G1/8	-	8.80	8.570	8.840
-	UNC7/16-14	-	9.40	9.150	9.550
M12	-	1.75	10.20	10.110	10.440
-	UNC1/2-13	-	10.80	10.590	11.010
-	NPT1/4	-	11.10	11.100	TAPER 1:16
-	G1/4	-	11.80	11.445	11.890
M14	-	2	12.00	11.835	12.210
-	UNC5/8-11	-	13.50	13.380	13.860
M16	-	2	14.00	13.835	14.210
-	NPT3/8	-	14.30	14.550	TAPER 1:16
-	G3/8	-	15.25	14.950	15.395
M18	-	2.5	15.50	15.295	15.740
M20	-	2.5	17.50	17.295	17.740
-	NPT1/2	-	17.90	18.000	TAPER 1:16
-	G1/2	-	19.00	18.635	19.170
M22	-	2.5	19.50	19.300	19.740
-	G5/8	-	21.00	20.590	21.120
M24	-	3	21.00	20.760	21.250
-	NPT3/4	-	23.20	23.250	TAPER 1:16
M27	-	3	24.00	23.760	24.250
-	G3/4	-	24.50	24.120	24.650
M30	-	3.5	26.50	26.380	26.670
-	G7/8	-	28.25	27.880	28.415
-	NPT1	-	29.00	29.200	TAPER 1:16
M33	-	3.5	29.50	28.706	29.211
-	G1	-	30.75	30.300	30.930
M36	-	4	32.00	31.670	32.270
M39	-	4	35.00	34.093	35.670
-	G1,1/8	-	35.50	34.940	35.580
M42	-	4.5	37.50	37.220	37.799
-	G1,1/4	-	39.50	38.960	39.590
-	G1,1/2	-	45.25	44.845	45.485

Threaded holes – hole size Metric ISO threads and inch threads

Tap threading – Thread milling – Fine threads

THREAD	Inch sizes	Pitch	Hole Ø	Tolerance minimum	Tolerance maximum
MF4X0.5	-	0.5	3.5	3.459	3.599
-	UNF8-36	-	3.5	3.404	3.607
-	UNF10-32	-	4.1	3.962	4.166
MF5X0.5	-	0.5	4.5	4.459	4.599
MF6X0.75	-	0.75	5.2	5.188	5.378
-	UNF1/4-28	-	5.5	5.367	5.580
-	NPTF1/16	-	6.1	6.200	TAPER 1:16
-	UNF5/16-24	-	6.9	6.792	7.038
MF8X1	-	1	7.0	6.917	7.153
MF8X0.75	-	0.75	7.2	7.188	7.378
-	NPTF1/8	-	8.4	8.500	TAPER 1:16
MF10X1.25	-	1.25	8.8	8.647	8.912
MF10X1	-	1	9.0	8.917	9.153
MF10X0.75	-	0.75	9.2	9.188	9.378
-	UNF7/16-20	-	9.9	9.738	10.030
MF12X1.5	-	1.5	11.5	10.376	10.676
MF12X1.25	-	1.25	12.52	10.647	10.912
MF12X1	-	1	11.0	10.917	11.153
-	NPTF1/4	-	11.0	11.00	TAPER 1:16
-	UNF1/2-20	-	11.5	11.326	11.618
MF14X1.5	-	1.5	12.5	12.376	12.676
MF14X1.25	-	1.25	12.8	12.647	12.912
MF14X1	-	1	13.0	12.917	13.153
-	NPTF3/8	-	14.3	14.500	TAPER 1:16
MF16X1.5	-	1.5	14.5	14.376	14.676
-	UNF5/8-18	-	14.5	14.348	14.671
MF16X1	-	1	15.0	14.917	15.153
MF18X1.5	-	1.5	16.5	16.376	16.676
MF18X1	-	1	17.0	16.917	17.153
-	NPTF1/2	-	17.6	17.800	TAPER 1:16
MF20X1.5	-	1.5	18.5	18.376	18.676
MF20X1	-	1	19.0	18.917	19.153
MF22X1.5	-	1.5	20.5	20.376	20.676
MF24X2	-	2.	22.0	21.385	22.210
MF24X1.5	-	1.5	22.5	22.376	22.676
-	NPTF3/4	-	23.0	23.100	TAPER 1:16
MF25X1.5	-	1.5	23.5	23.376	23.676
MF26X1.5	-	1.5	24.5	24.376	24.676
MF27X2	-	2.	25.0	24.385	25.210
MF27X1.5	-	1.5	25.5	25.376	25.676
MF28X1.5	-	1.5	26.5	26.376	26.676
MF30X2	-	2	28.0	27.835	28.210
MF30X1.5	-	1.5	28.5	28.376	28.676