



(Fluteless) Roll Taps:

THREAD SIZE			ISO COARSE		UNC		BSW	
Metric	Fraction	M/C Screw Gauge	Pitch mm	Tapping Drill mm	T.P.I.	Tapping Drill mm	T.P.I.	Tapping Drill mm
M1.0			0.25	0.90				
M1.1			0.25	1.00				
M1.2			0.25	1.10				
M1.4			0.3	1.25				
M1.6			0.35	1.45				
M1.7			0.35	1.55				
M1.8			0.35	1.65				
M2.0			0.4	1.80				
M2.2			0.45	2.00				
M2.3			0.4	2.10				
M2.5			0.45	2.30				
M2.6			0.45	2.40				
M3.0			0.5	2.75				
	1/8						40	2.90
M3.5			0.6	3.20				
		#6			32	3.10		
	5/32						32	3.60
M4			0.7	3.70				
		#8			32	3.80		
	3/16						24	4.30
		#10			24	4.30		
M5			0.8	4.60				
M6			1.0	5.55				
	1/4				20	5.80	20	5.80
	5/16				18	7.30	18	7.30
M8			1.25	7.40				
	3/8				16	8.80	16	8.80
M10			1.50	9.30				