

THRESHAVERS – METRIC

SIZE	THEORETICAL HOLE SIZES FOR				CLASS 6H						CLASS 4H					
	85% THREAD	75% THREAD	65% THREAD	55% THREAD	MINOR DIA. (mm)		MINOR DIA. (in.)		RECOMMENDED DRILL SIZE		MINOR DIA. (mm)		MINOR DIA. (in.)		RECOMMENDED DRILL SIZE	
M2 X 0.4	.061	.063	.065	.067	1.567	1.679	.0617	.0661	1.60mm	(.0630)	1.567	1.638	.0617	.0645	1/16	(.0625)
M2.5 X 0.45	.079	.081	.083	.086	2.013	2.138	.0793	.0842	#45	(.0820)	2.013	2.093	.0793	.0824	2.05mm	(.0807)
M3 X 0.5	.096	.099	.101	.104	2.459	2.599	.0968	.1023	#39	(.0995)	2.459	2.549	.0968	.1004	#40	(.0980)
M3.5 X 0.6	.112	.115	.118	.121	2.850	3.010	.1122	.1185	2.9mm	(.1142)	2.850	2.950	.1122	.1161	#33	(.1130)
M4 X 0.7	.127	.131	.134	.138	3.242	3.422	.1276	.1347	3.3mm	(.1299)	3.242	3.354	.1276	.1320	#30	(.1285)
M5 X 0.8	.162	.166	.170	.174	4.134	4.334	.1628	.1706	#19	(.1660)	4.134	4.259	.1628	.1677	4.2mm	(.1654)
M6 X 1	.193	.198	.203	.208	4.917	5.153	.1936	.2029	5mm	(.1969)	4.917	5.067	.1936	.1995	#9	(.1960)
M8 X 1.25	.261	.267	.273	.280	6.647	6.912	.2617	.2721	H	(.2660)	6.647	6.817	.2617	.2684	17/64	(.2656)
M10 X 1.5	.328	.336	.344	.351	8.376	8.676	.3298	.3416	8.5mm	(.3346)	8.376	8.566	.3298	.3372	Q	(.3320)
M10 X 1.25	.339	.346	.352	.359	8.647	8.912	.3404	.3509	8.75mm	(.3445)	8.647	8.817	.3404	.3471	8.75mm	(.3445)
M12 X 1.75	.396	.405	.414	.423	10.106	10.441	.3979	.4111	13/32	(.4063)	10.106	10.318	.3979	.4062	Y	(.4040)
M12 X 1.5	.407	.415	.423	.430	10.376	10.676	.4085	.4203	10.5mm	(.4134)	10.376	10.566	.4085	.4160	10.5mm	(.4134)
M12 X 1.25	.418	.424	.431	.437	10.647	10.912	.4192	.4296	10.75mm	(.4232)	10.647	10.817	.4192	.4259	10.75mm	(.4232)
M14 X 2	.464	.474	.485	.495	11.835	12.210	.4659	.4807	12mm	(.4724)	11.835	12.071	.4659	.4752	12mm	(.4724)
M14 X 1.5	.486	.494	.501	.509	12.376	12.676	.4872	.4991	12.5mm	(.4921)	12.376	12.566	.4872	.4947	12.5mm	(.4921)
M16 X 2	.543	.553	.563	.574	13.835	14.210	.5447	.5594	14mm	(.5512)	13.835	14.071	.5447	.5540	14mm	(.5512)
M16 X 1.5	.565	.572	.580	.588	14.376	14.676	.5660	.5778	14.5mm	(.5709)	14.376	14.566	.5660	.5735	14.5mm	(.5709)
M18 X 2.5	.600	.613	.625	.638	15.294	15.744	.6021	.6198	15.5mm	(.6102)	15.294	15.574	.6021	.6131	15.5mm	(.6102)
M18 X 1.5	.643	.651	.659	.666	16.376	16.676	.6447	.6565	16.5mm	(.6496)	16.376	16.566	.6447	.6522	16.5mm	(.6496)
M20 X 2.5	.679	.692	.704	.717	17.294	17.744	.6809	.6986	17.5mm	(.6890)	17.294	17.574	.6809	.6919	17.5mm	(.6890)
M20 X 1.5	.722	.730	.737	.745	18.376	18.676	.7235	.7353	18.5mm	(.7283)	18.376	18.566	.7235	.7309	18.5mm	(.7283)
M22 X 2.5	.757	.770	.783	.796	19.294	19.744	.7596	.7773	19.5mm	(.7677)	19.294	19.574	.7596	.7706	19.5mm	(.7677)
M22 X 1.5	.801	.809	.816	.824	20.376	20.676	.8022	.8140	20.5mm	(.8071)	20.376	20.566	.8022	.8097	20.5mm	(.8071)
M24 X 3	.814	.830	.845	.860	20.752	21.252	.8170	.8367	21mm	(.8268)	20.752	21.067	.8170	.8294	21mm	(.8268)
M24 X 2	.858	.868	.878	.889	21.835	22.210	.8596	.8744	22mm	(.8661)	21.835	22.071	.8596	.8689	22mm	(.8661)

THRESHAVER PIPE TAP DRILL SIZES – NPT, NPTF & NPSF

SIZE	NPT & NPTF DRILL ONLY		NPT & NPTF DRILL / TAPER REAM		NPSF STRAIGHT THREAD
	NPT DRILL SIZE	NPTF DRILL SIZE	DRILL SIZE	REAM DIAMETER LARGE END	SUGGESTED HOLE SIZE
1/16-27	D (.246)	D (.246)	15/64"	.2515	.250/.252
1/8-27	Q (.332)	R (.339)	21/64"	.3440	.343/.345
1/4-18	7/16"	7/16"	27/64"	.4472	.444/.447
3/8-18	9/16"	37/64"	9/16"	.5826	.580/.583
1/2-14	45/64"	45/64"	11/16"	.7213	.715/.719
3/4-14	29/32"	59/64"	57/64"	.9317	.926/.930