

Thread · Class · **Tap drill** · Drill Ø · start drill for BORE · % of thread · **pitch Ø min-max** · **minor Ø min-max** — diameters in in * not yet checked against the standard

1/16-27 NPS	NPS	E	0.2500	—	—
1/16-27 NPSF	NPSF	E	0.2500	—	—
1/16-27 NPT	drill	D	0.2460	0.2712–0.2812	0.2416–0.2516
1/16-27 NPTF	drill	D	0.2460	0.2712–0.2812	0.2416–0.2516
1/16-27 NPT	ream	0.240	0.2400	0.2712–0.2812	0.2416–0.2516
1/16-27 NPTF	ream	A	0.2340	0.2712–0.2812	0.2416–0.2516
G 1/8-28 BSPP	Close	11/32	0.3438	86% 0.3601–0.3629	0.3373–0.3483
G 1/8-28 BSPP	Med	11/32	0.3438	86% 0.3601–0.3643	0.3373–0.3483
Rc 1/8-28 BSPT*	Rc	8.3 mm	0.3268	0.3500–0.3601	0.3272–0.3373
1/8-27 NPS	NPS	11/32	0.3438	—	—
1/8-27 NPSF	NPSF	11/32	0.3438	—	—
1/8-27 NPT	drill	Q	0.3320	0.3635–0.3736	0.3339–0.3440
1/8-27 NPTF	drill	R	0.3390	0.3635–0.3736	0.3339–0.3440
1/8-27 NPT	ream	21/64	0.3281	0.3635–0.3736	0.3339–0.3440
1/8-27 NPTF	ream	21/64	0.3281	0.3635–0.3736	0.3339–0.3440
G 1/4-19 BSPP	Close	29/64	0.4531	96% 0.4843–0.4875	0.4506–0.4681
G 1/4-19 BSPP	Med	29/64	0.4531	96% 0.4843–0.4892	0.4506–0.4681
Rc 1/4-19 BSPT*	Rc	11.1 mm	0.4370	0.4701–0.4843	0.4364–0.4506
1/4-18 NPS	NPS	7/16	0.4375	—	—
1/4-18 NPSF	NPSF	0.444	0.4440	—	—
1/4-18 NPT	drill	7/16	0.4375	0.4774–0.4916	0.4329–0.4472
1/4-18 NPTF	drill	7/16	0.4375	0.4774–0.4916	0.4329–0.4472
1/4-18 NPT	ream	27/64	0.4219	0.4774–0.4916	0.4329–0.4472
1/4-18 NPTF	ream	27/64	0.4219	0.4774–0.4916	0.4329–0.4472
G 3/8-19 BSPP	Close	19/32	0.5938	92% 0.6223–0.6256	0.5886–0.6061
G 3/8-19 BSPP	Med	19/32	0.5938	92% 0.6223–0.6273	0.5886–0.6061
Rc 3/8-19 BSPT*	Rc	14.5 mm	0.5709	0.6073–0.6223	0.5736–0.5886
3/8-18 NPS	NPS	37/64	0.5781	—	—
3/8-18 NPSF	NPSF	37/64	0.5781	—	—
3/8-18 NPT	drill	9/16	0.5625	0.6120–0.6270	0.5676–0.5826
3/8-18 NPTF	drill	37/64	0.5781	0.6120–0.6270	0.5676–0.5826
3/8-18 NPT	ream	9/16	0.5625	0.6120–0.6270	0.5676–0.5826
3/8-18 NPTF	ream	9/16	0.5625	0.6120–0.6270	0.5676–0.5826
G 1/2-14 BSPP	Close	3/4	0.7500	82% 0.7793–0.7830	0.7335–0.7548
G 1/2-14 BSPP	Med	3/4	0.7500	82% 0.7793–0.7849	0.7335–0.7548
Rc 1/2-14 BSPT*	Rc	18 mm	0.7087	0.7593–0.7793	0.7135–0.7335
1/2-14 NPS	NPS	23/32	0.7188	—	—
1/2-14 NPSF	NPSF	23/32	0.7188	—	—
1/2-14 NPT	drill	45/64	0.7031	0.7584–0.7784	0.7013–0.7213
1/2-14 NPTF	drill	45/64	0.7031	0.7584–0.7784	0.7013–0.7213
1/2-14 NPT	ream	11/16	0.6875	0.7584–0.7784	0.7013–0.7213
1/2-14 NPTF	ream	11/16	0.6875	0.7584–0.7784	0.7013–0.7213
G 5/8-14 BSPP	Close	53/64	0.8281	81% 0.8563–0.8601	0.8105–0.8318
G 5/8-14 BSPP	Med	53/64	0.8281	81% 0.8563–0.8619	0.8105–0.8318
G 3/4-14 BSPP	Close	61/64	0.9531	96% 0.9953–0.9993	0.9495–0.9708
G 3/4-14 BSPP	Med	61/64	0.9531	96% 0.9953–1.0013	0.9495–0.9708
Rc 3/4-14 BSPT*	Rc	23.5 mm	0.9252	0.9741–0.9953	0.9283–0.9495
3/4-14 NPS	NPS	59/64	0.9219	—	—
3/4-14 NPSF	NPSF	0.955	0.9550	—	—
3/4-14 NPT	drill	29/32	0.9063	0.9677–0.9889	0.9105–0.9317
3/4-14 NPTF	drill	59/64	0.9219	0.9677–0.9889	0.9105–0.9317
3/4-14 NPT	ream	57/64	0.8906	0.9677–0.9889	0.9105–0.9317
3/4-14 NPTF	ream	57/64	0.8906	0.9677–0.9889	0.9105–0.9317
G 7/8-14 BSPP	Close	1-7/64	1.1094	87% 1.1433–1.1473	1.0975–1.1188
G 7/8-14 BSPP	Med	1-7/64	1.1094	87% 1.1433–1.1494	1.0975–1.1188
G 1-11 BSPP	Close	1-13/64	1.2031	91% 1.2508–1.2551	1.1926–1.2178
G 1-11 BSPP	Med	1-13/64	1.2031	91% 1.2508–1.2573	1.1926–1.2178
Rc 1-11 BSPT*	Rc	29.5 mm	1.1614	1.2258–1.2508	1.1676–1.1926
1-11.5 NPS	NPS	1-5/32	1.1563	—	—
1-11.5 NPSF	NPSF	1-5/32	1.1563	—	—
1-11.5 NPT	drill	1-9/64	1.1406	1.2136–1.2386	1.1441–1.1691
1-11.5 NPTF	drill	1-5/32	1.1563	1.2136–1.2386	1.1441–1.1691
1-11.5 NPT	ream	1-1/8	1.1250	1.2136–1.2386	1.1441–1.1691
1-11.5 NPTF	ream	1-1/8	1.1250	1.2136–1.2386	1.1441–1.1691
G 1-1/4-11 BSPP	Close	1-35/64	1.5469	89% 1.5918–1.5964	1.5336–1.5588
G 1-1/4-11 BSPP	Med	1-35/64	1.5469	89% 1.5918–1.5987	1.5336–1.5588
Rc 1-1/4-11 BSPT*	Rc	38.5 mm	1.5157	1.5655–1.5918	1.5073–1.5336
1-1/4-11.5 NPS	NPS	1-1/2	1.5000	—	—
1-1/4-11.5 NPT	drill	1-31/64	1.4844	1.5571–1.5834	1.4876–1.5138
1-1/4-11.5 NPTF	drill	1-1/2	1.5000	1.5571–1.5834	1.4876–1.5138
1-1/4-11.5 NPT	ream	1-15/32	1.4688	1.5571–1.5834	1.4876–1.5138
1-1/4-11.5 NPTF	ream	1-15/32	1.4688	1.5571–1.5834	1.4876–1.5138
G 1-1/2-11 BSPP	Close	1-25/32	1.7813	87% 1.8238–1.8286	1.7656–1.7908
G 1-1/2-11 BSPP	Med	1-25/32	1.7813	87% 1.8238–1.8310	1.7656–1.7908
Rc 1-1/2-11 BSPT*	Rc	44 mm	1.7323	1.7975–1.8238	1.7393–1.7656
1-1/2-11.5 NPS	NPS	1-3/4	1.7500	—	—
1-1/2-11.5 NPT	drill	1-47/64	1.7344	1.7961–1.8223	1.7265–1.7528
1-1/2-11.5 NPTF	drill	1-47/64	1.7344	1.7961–1.8223	1.7265–1.7528
1-1/2-11.5 NPT	ream	1-23/32	1.7188	1.7961–1.8223	1.7265–1.7528
1-1/2-11.5 NPTF	ream	1-45/64	1.7031	1.7961–1.8223	1.7265–1.7528
2-11.5 NPS	NPS	2-7/32	2.2188	—	—
2-11.5 NPT	drill	2-13/64	2.2031	2.2690–2.2963	2.1995–2.2267
2-11.5 NPTF	drill	2-7/32	2.2188	2.2690–2.2963	2.1995–2.2267
2-11.5 NPT	ream	2-3/16	2.1875	2.2690–2.2963	2.1995–2.2267
2-11.5 NPTF	ream	2-3/16	2.1875	2.2690–2.2963	2.1995–2.2267
2-1/2-8 NPS	NPS	2-21/32	2.6563	—	—
2-1/2-8 NPT	drill	2-5/8	2.6250	2.7195–2.7622	2.6195–2.6622
2-1/2-8 NPTF	drill	2-41/64	2.6406	2.7195–2.7622	2.6195–2.6622
2-1/2-8 NPT	ream	2-19/32	2.5938	2.7195–2.7622	2.6195–2.6622
2-1/2-8 NPTF	ream	2-19/32	2.5938	2.7195–2.7622	2.6195–2.6622
3-8 NPTF	drill	3-17/64	3.2656	3.3406–3.3885	3.2406–3.2885
3-8 NPTF	ream	3-7/32	3.2188	3.3406–3.3885	3.2406–3.2885