

Thread Tables

BSP Thread Table

Dash thread size	BSP size (in)	Thread pitch		Thread major diameter		Thread minor diameter ^{[3][4]}		A/F (mm)	Gauge length (mm)	Corresponding pipe				Tapping drill size (mm)	
		/in (TPI)	(mm)	(mm)	(in)	(mm)	(in)			DN (mm)	OD (mm)	OD (in)	Thickness (mm)	BSP.PL (Rp)	BSP.F (G)
-1	1/16	28	0.907	7.723	0.304	6.561	0.2583		4±0.9					6.60	6.80
-2	1/8	28	0.907	9.728	0.383	8.565	0.3372	15	4±0.9	6	10.2	0.40	2	8.60	8.80
-4	1/4	19	1.337	13.157	0.518	11.445	0.4506	19	6±1.3	8	13.5	0.53	2.3	11.50	11.80
-6	3/8	19	1.337	16.662	0.656	14.950	0.5886	22/23	6.4±1.3	10	17.2	0.68	2.3	15.00	15.25
-8	1/2	14	1.814	20.955	0.825	18.633	0.7336	27	8.2±1.8	15	21.3	0.84	2.6	18.75	19.00
-10	5/8	14	1.814	22.911	0.902	20.589	0.8106			16			2.6	-	21.00
-12	3/4	14	1.814	26.441	1.041	24.120	0.9496	32	9.5±1.8	20	26.9	1.06	2.6	24.25	24.50
-16	1	11	2.309	33.249	1.309	30.292	1.1926	43	10.4±2.3	25	33.7	1.33	3.2	30.40	30.75
-20	1 1/4	11	2.309	41.910	1.650	38.953	1.5336	53	12.7±2.3	32	42.4	1.67	3.2	39.00	39.50
-24	1 1/2	11	2.309	47.803	1.882	44.846	1.7656	57	12.7±2.3	40	48.3	1.90	3.2	45.00	45.00
-32	2	11	2.309	59.614	2.347	56.657	2.2306	70	15.9±2.3	50	60.3	2.37	3.6	56.75	57.00
-40	2 1/2	11	2.309	75.184	2.960	72.227	2.8436		17.5±3.5	65	76.1	3.00	3.6		
-48	3	11	2.309	87.884	3.460	84.927	3.3436		20.6±3.5	80	88.9	3.50	4		
-64	4	11	2.309	113.030	4.450	110.073	4.3336		25.5±3.5	100	114.3	4.50	4.5		
-80	5	11	2.309	138.430	5.450	135.472	5.3335		28.6±3.5	125	139.7	5.50	5		
-96	6	11	2.309	163.830	6.450	160.872	6.3335		28.6±3.5	150	165.1	6.50	5		

NPT Thread Table

NPT - American Standard Pipe Thread Taper ¹⁾						
Pipe Size (inches)	Threads per Inch TPI - pitch	Approximate Length of Thread (inches)	Approximate Number of Threads to be Cut	Approximate Total thread Makeup, Hand and Wrench (inches)	Nominal Outside Pipe Diameter OD (inches)	Tap Drill (inches)
1/16"	27				0.313	
1/8"	27	3/8	10	1/4	0.405	R
1/4"	18	5/8	11	3/8	0.540	7/16
3/8"	18	5/8	11	3/8	0.675	37/64
1/2"	14	3/4	10	7/16	0.840	23/32
3/4"	14	3/4	10	1/2	1.050	59/64
1"	11-1/2	7/8	10	9/16	1.315	1-5/32
1-1/4"	11-1/2	1	11	9/16	1.660	1-1/2
1-1/2"	11-1/2	1	11	9/16	1.900	1-47/64
2"	11-1/2	1	11	5/8	2.375	2-7/32
2-1/2"	8	1 1/2	12	7/8	2.875	2-5/8
3"	8	1 1/2	12	1	3.500	3-1/4
3-1/2"	8	1 5/8	13	1 1/16	4.000	3-3/4
4"	8	1 5/8	13	1 1/16	4.500	4-1/4
4 1/2"	8				5.000	4-3/4
5"	8	1 3/4	14	1 3/16	5.563	5-9/32
6"	8	1 3/4	14	1 3/16	6.625	6-11/32
8"	8	1 7/8	15	1 5/16	8.625	
10"	8	2	16	1 1/2	10.750	
12"	8	2 1/8	17	1 5/8	12.750	
14"	8				14.000	
16"	8				16.000	

Metric Thread Table

Size - Nominal Diameter (mm)	Pitch ¹⁾ (mm)	Clearance Drill (mm)	Tap Drill (mm)
M 1.60	0.35	1.8	1.25
M 2.00	0.40	2.4	1.60
M 2.50	0.45	2.90	2.00
M 3.00	0.50	3.40	2.50
M 3.50	0.60	3.90	2.90
M 4.00	0.70	4.50	3.30
M 5.00	0.80	5.50	4.20
M 6.00	1.00	6.60	5.00
M 8.00	1.25	9.00	6.80
M 10.00	1.50	12.00	8.50
M 12.00	1.75	14.00	10.20
M 14.00	2.00	16.00	12.00
M 16.00	2.00	18.00	14.00
M 20.00	2.50	22.00	17.50
M 22.00	2.50	25.00	19.50
M 24.00	3.00	27.00	21.00
M 27.00	3.00	30.00	24.00
M 30.00	3.50	33.00	26.50
M 36.00	4.00	40.00	32.00
M 42.00	4.50	46.00	37.50
M 48.00	5.00	53.00	43.00
M 56.00	5.50	62.00	50.50
M 64.00	6.00	70.00	58.00
M 68.00	6.00	74.00	62.00