

G / R size	Thread pitch		Major diameter		Minor diameter		Gauge length		Tapping drill	
	(in)	(in <sup>-1</sup> ) (mm)	(in)	(mm)	(in)	(mm)	(in)	(mm)	R 95% (mm)	G 80% (mm)
1/16	28	0.91	0.304	7.723	0.258	6.561	5/32	4	6.6	6.8
1/8	28	0.91	0.383	9.728	0.337	8.566	5/32	4	8.6	8.8
1/4	19	1.34	0.518	13.157	0.451	11.445	0.2367	6	11.5	11.8
3/8	19	1.34	0.656	16.662	0.589	14.95	1/4	6.4	15	15.3
1/2	14	1.81	0.825	20.955	0.734	18.631	0.3214	8.2	18.7	19.1
5/8	14	1.81	0.902	22.911	0.811	20.587	0.3214	8.2	20.7	21.1
3/4	14	1.81	1.041	26.441	0.95	24.117	3/8	9.5	24.2	24.6
7/8	14	1.81	1.189	30.201	1.098	27.877	3/8	9.5	28	28.3
1	11	2.31	1.309	33.249	1.193	30.291	0.4091	10.4	30.4	30.9
1 1/8	11	2.31	1.492	37.897	1.376	34.939	0.4091	10.4	35.1	35.5
1 1/4	11	2.31	1.65	41.91	1.534	38.952	1/2	12.7	39.1	39.5
1 3/8	11	2.31	1.745	44.323	1.629	41.365	1/2	12.7	41.5	42
1 1/2	11	2.31	1.882	47.803	1.766	44.845	1/2	12.7	45	45.4
1 5/8	11	2.31	2.082	52.883	1.966	49.926	5/8	15.9	50.1	50.5
1 3/4	11	2.31	2.116	53.746	2	50.788	5/8	15.9	50.9	51.4
1 7/8	11	2.31	2.244	56.998	2.128	54.041	5/8	15.9	54.2	54.6
2	11	2.31	2.347	59.614	2.231	56.656	5/8	15.9	56.8	57.2
2 1/4	11	2.31	2.587	65.71	2.471	62.752	11/16	17.5	62.9	63.3
2 1/2	11	2.31	2.96	75.184	2.844	72.226	11/16	17.5	72.4	72.8
2 3/4	11	2.31	3.21	81.534	3.094	78.576	13/16	20.6	78.7	79.2
3	11	2.31	3.46	87.884	3.344	84.926	13/16	20.6	85.1	85.5
3 1/4	11	2.31	3.7	93.98	3.584	91.022	7/8	22.2	91.2	91.6
3 1/2	11	2.31	3.95	100.33	3.834	97.372	7/8	22.2	97.5	98
3 3/4	11	2.31	4.2	106.68	4.084	103.72	7/8	22.2	104	104.3
4	11	2.31	4.45	113.03	4.334	110.07	1	25.4	110	110.7
4 1/2	11	2.31	4.95	125.73	4.834	122.77	1	25.4	123	123.4
5	11	2.31	5.45	138.43	5.334	135.47	1 1/8	28.6	136	136.1
5 1/2	11	2.31	5.95	151.13	5.834	148.17	1 1/8	28.6	148	148.8
6	11	2.31	6.45	163.83	6.334	160.87	1 1/8	28.6	161	161.5
7	10	2.54	7.45	189.23	7.322	185.98	1 3/8	34.9	186	186.6
8	10	2.54	8.45	214.63	8.322	211.38	1 1/2	38.1	212	212
9	10	2.54	9.45	240.03	9.322	236.78	1 1/2	38.1	237	237.4
10	10	2.54	10.45	265.43	10.32	262.18	1 5/8	41.3	262	262.8
11	8	3.18	11.45	290.83	11.29	286.77	1 5/8	41.3	287	287.6
12	8	3.18	12.45	316.23	12.29	312.17	1 5/8	41.3	312	313
13	8	3.18	13.68	347.47	13.52	343.41	1 5/8	41.3	344	344.2
14	8	3.18	14.68	372.87	14.52	368.81	1 3/4	44.5	369	369.6
15	8	3.18	15.68	398.27	15.52	394.21	1 3/4	44.5	394	395
16	8	3.18	16.68	423.67	16.52	419.61	1 7/8	47.6	420	420.4
17	8	3.18	17.68	449.07	17.52	445.01	2	50.8	445	445.8
18	8	3.18	18.68	474.47	18.52	470.41	2	50.8	471	471.2