



# EIS Tapping Guide



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| METRIC COARSE          |            | METRIC FINE            |            |                        |            | NOMINAL APPROX. |                 | B.S.W. |            | B.S.F. |            | U.N.C. |            | U.N.F. |            | U.N.E.F. |            | G BSP  |            | Rc BSP |            | N.P.S. |            | N.P.T. |            | BRASS  |            | BRITISH ASSOCIATION |            |        |            |  |
|------------------------|------------|------------------------|------------|------------------------|------------|-----------------|-----------------|--------|------------|--------|------------|--------|------------|--------|------------|----------|------------|--------|------------|--------|------------|--------|------------|--------|------------|--------|------------|---------------------|------------|--------|------------|--|
| NOMINAL DIAM AND PITCH | DRILL DIAM | NOMINAL DIAM AND PITCH | DRILL DIAM | NOMINAL DIAM AND PITCH | DRILL DIAM | DIAM (IN.)      | METRIC DIAMETER | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I.   | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | T.P.I. | DRILL DIAM | No                  | MAJOR DIAM | T.P.I. | DRILL DIAM |  |
| 1,0 x 0,25             | 0,75       | 2,5 x 0,35             | 2,15       | 24,0 x 1,0             | 23,00      | 1/16            | 1,587           | 60     | 1,15       |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        | 16         | 0,0311              | 133,3      | 0,60   |            |  |
| 1,1 x 0,25             | 0,85       | 3,0 x 0,35             | 2,65       | 24,0 x 1,5             | 22,50      | 3/32            | 2,381           | 48     | 1,80       |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        | 15         | 0,0354              | 120,5      | 0,70   |            |  |
| 1,2 x 0,25             | 0,95       | 3,5 x 0,35             | 3,15       | 24,0 x 2,0             | 22,00      | 1/8             | 3,175           | 40     | 2,60       |        |            |        |            |        |            |          | 28         | 8,80   | 28         | 8,60   | 27         | 8,90   | 27         | 8,50   |            | 14     | 0,0394     | 109,9               | 0,75       |        |            |  |
| 1,4 x 0,30             | 1,10       | 4,0 x 0,5              | 3,50       | 25,0 x 1,0             | 24,00      | 5/32            | 3,968           | 32     | 3,10       |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        | 13         | 0,0472              | 102,0      | 0,95   |            |  |
| 1,6 x 0,35             | 1,25       | 4,5 x 0,5              | 4,00       | 25,0 x 1,5             | 23,50      | 3/16            | 4,762           | 24     | 3,60       | 32     | 4,00       |        |            |        |            |          |            |        |            |        |            |        |            |        |            | 12     | 0,0512     | 90,9                | 1,00       |        |            |  |
| 1,8 x 0,35             | 1,45       | 5,0 x 0,5              | 4,50       | 25,0 x 2,0             | 23,00      | 7/32            | 5,556           | 24     | 4,40       | 28     | 4,70       |        |            |        |            |          |            |        |            |        |            |        |            |        |            | 11     | 0,0591     | 81,9                | 1,20       |        |            |  |
| 2,0 x 0,40             | 1,60       | 5,5 x 0,5              | 5,00       | 27,0 x 1,0             | 26,00      | 1/4             | 6,350           | 20     | 5,10       | 26     | 5,40       | 20     | 5,10       | 28     | 5,50       | 32       | 5,50       | 19     | 11,80      | 19     | 11,50      | 18     | 11,50      | 18     | 11,00      | 26     | 5,40       | 10                  | 0,0669     | 72,6   | 1,30       |  |
| 2,2 x 0,45             | 1,75       | 6,0 x 0,75             | 5,20       | 27,0 x 1,5             | 25,50      | 9/32            | 7,143           | 20     | 5,80       | 26     | 6,20       |        |            |        |            |          |            |        |            |        |            |        |            |        |            | 9      | 0,0748     | 65,1                | 1,50       |        |            |  |
| 2,5 x 0,45             | 2,05       | 7,0 x 0,75             | 6,20       | 27,0 x 2,0             | 25,00      | 5/16            | 7,937           | 18     | 6,50       | 22     | 6,80       | 18     | 6,60       | 24     | 6,90       | 32       | 7,10       |        |            |        |            |        |            |        | 26         | 6,90   | 8          | 0,0866              | 59,1       | 1,80   |            |  |
| 3,0 x 0,50             | 2,50       | 8,0 x 0,75             | 7,20       | 28,0 x 1,0             | 27,00      | 3/8             | 9,525           | 16     | 7,90       | 20     | 8,30       | 16     | 8,00       | 24     | 8,50       | 32       | 8,60       | 19     | 15,25      | 19     | 15,00      | 18     | 15,00      | 18     | 14,50      | 26     | 8,40       | 7                   | 0,0984     | 52,9   | 2,00       |  |
| 3,5 x 0,60             | 2,90       | 8,0 x 1,0              | 7,00       | 28,0 x 1,5             | 26,50      | 7/16            | 11,112          | 14     | 9,30       | 18     | 9,80       | 14     | 9,40       | 20     | 9,90       | 28       | 10,10      |        |            |        |            |        |            |        | 26         | 10,00  | 6          | 0,1102              | 47,9       | 2,30   |            |  |
| 4,0 x 0,70             | 3,30       | 9,0 x 0,75             | 8,20       | 28,0 x 2,0             | 26,00      | 1/2             | 12,700          | 12     | 10,50      | 16     | 11,20      | 13     | 10,80      | 20     | 11,50      | 28       | 11,70      | 14     | 19,00      | 14     | 18,50      | 14     | 18,50      | 14     | 18,00      | 26     | 11,50      | 5                   | 0,1260     | 43,0   | 2,70       |  |
| 4,5 x 0,75             | 3,70       | 9,0 x 1,0              | 8,00       | 30,0 x 1,0             | 29,00      | 9/16            | 14,288          | 12     | 12,00      | 16     | 12,70      | 12     | 12,20      | 18     | 12,90      | 24       | 13,00      |        |            |        |            |        |            |        | 26         | 13,00  | 4          | 0,1417              | 38,5       | 3,00   |            |  |
| 5,0 x 0,80             | 4,20       | 10,0 x 0,75            | 9,20       | 30,0 x 1,5             | 28,50      | 5/8             | 15,875          | 11     | 13,50      | 14     | 14,00      | 11     | 13,50      | 18     | 14,50      | 24       | 14,75      | 14     | 21,00      |        |            |        |            |        | 26         | 14,70  | 3          | 0,1614              | 34,8       | 3,50   |            |  |
| 6,0 x 1,0              | 5,00       | 10,0 x 1,0             | 9,00       | 30,0 x 2,0             | 28,00      | 11/16           | 17,462          | 11     | 15,00      | 14     | 15,75      |        |            |        |            | 24       | 16,25      |        |            |        |            |        |            |        |            | 2      | 0,1850     | 34,1                | 4,00       |        |            |  |
| 7,0 x 1,0              | 6,00       | 10,0 x 1,25            | 8,80       | 30,0 x 3,0             | 27,00      | 3/4             | 19,050          | 10     | 16,50      | 12     | 17,00      | 10     | 16,50      | 16     | 17,50      | 20       | 17,50      | 14     | 24,50      | 14     | 24,00      | 14     | 24,00      | 14     | 23,00      | 26     | 17,80      | 1                   | 0,2087     | 28,2   | 4,50       |  |
| 8,0 x 1,25             | 6,80       | 11,0 x 0,75            | 10,20      | 32,0 x 1,5             | 30,50      | 13/16           | 20,638          | 10     | 18,00      | 12     | 18,50      |        |            |        |            | 20       | 19,25      |        |            |        |            |        |            |        |            |        | 0          | 0,2362              | 25,4       | 5,10   |            |  |
| 9,0 x 1,25             | 7,80       | 11,0 x 1,0             | 10,00      | 32,0 x 2,0             | 30,00      | 7/8             | 22,225          | 9      | 19,25      | 11     | 20,00      | 9      | 19,50      | 14     | 20,40      | 20       | 20,75      | 14     | 28,25      |        |            |        |            |        | 26         | 21,00  |            |                     |            |        |            |  |
| 10,0 x 1,50            | 8,50       | 12,0 x 1,0             | 11,00      | 33,0 x 1,5             | 31,50      | 15/16           | 23,812          | 9      | 20,75      | 11     | 21,75      |        |            |        |            | 20       | 22,25      |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 11,0 x 1,50            | 9,50       | 12,0 x 1,25            | 10,80      | 33,0 x 2,0             | 31,00      | 1"              | 25,400          | 8      | 22,00      | 10     | 23,00      | 8      | 22,25      | 12     | 23,25      | 20       | 23,75      | 11     | 30,75      | 11     | 30,25      | 11 1/2 | 30,00      | 11 1/2 | 29,00      | 26     | 24,20      | 1                   | 0,073      | 64     | 1,55       |  |
| 12,0 x 1,75            | 10,20      | 12,0 x 1,5             | 10,50      | 33,0 x 3,0             | 30,00      | 1 1/8           | 28,575          | 7      | 24,75      | 9      | 26,00      | 7      | 25,00      | 12     | 26,50      | 18       | 26,75      | 11     | 35,50      |        |            |        |            |        |            |        | 2          | 0,086               | 56         | 1,85   |            |  |
| 14,0 x 2,0             | 12,0       | 14,0 x 1,0             | 13,00      | 35,0 x 1,5             | 33,50      | 1 1/4           | 31,750          | 7      | 27,75      | 9      | 29,00      | 7      | 28,00      | 12     | 29,50      | 18       | 30,00      | 11     | 39,50      | 11     | 39,00      | 11 1/2 | 39,00      | 11 1/2 | 38,00      |        | 3          | 0,099               | 48         | 2,10   |            |  |
| 16,0 x 2,0             | 14,0       | 14,0 x 1,25            | 12,80      | 36,0 x 1,5             | 34,50      | 1 3/8           | 34,925          | 6      | 30,50      | 8      | 32,00      | 6      | 30,75      | 12     | 32,75      | 18       | 33,00      | 11     | 42,00      |        |            |        |            |        |            |        | 4          | 0,112               | 40         | 2,35   |            |  |
| 18,0 x 2,5             | 15,50      | 14,0 x 1,5             | 12,50      | 36,0 x 2,0             | 34,00      | 1 1/2           | 38,100          | 6      | 33,50      | 8      | 35,00      | 6      | 34,00      | 12     | 36,00      | 18       | 36,00      | 11     | 45,00      | 11     | 45,00      | 11 1/2 | 45,00      | 11 1/2 | 44,00      |        | 5          | 0,125               | 40         | 2,65   |            |  |
| 20,0 x 2,5             | 17,50      | 15,0 x 1,0             | 14,00      | 36,0 x 3,0             | 33,00      | 1 5/8           | 41,275          | 5      | 35,50      | 8      | 37,50      |        |            |        |            | 11       | 49,60      |        |            |        |            |        |            |        |            |        | 6          | 0,138               | 32         | 2,85   |            |  |
| 22,0 x 2,5             | 19,50      | 15,0 x 1,5             | 13,50      | 38,0 x 1,5             | 36,50      | 1 3/4           | 44,450          | 5      | 39,00      | 7      | 40,00      | 5      | 39,50      |        |            |          | 11         | 51,00  |            |        |            |        |            |        |            |        | 8          | 0,164               | 32         | 3,50   |            |  |
| 24,0 x 3,0             | 21,0       | 16,0 x 1,0             | 15,00      | 39,0 x 1,5             | 37,50      | 1 7/8           | 47,625          | 4 1/2  | 41,50      | 7      | 43,00      |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        | 10         | 0,190               | 24         | 3,90   |            |  |
| 27,0 x 3,0             | 24,0       | 16,0 x 1,5             | 14,50      | 39,0 x 2,0             | 37,00      | 2"              | 50,800          | 4 1/2  | 44,50      | 7      | 46,50      | 4 1/2  | 45,00      |        |            |          | 11         | 57,00  | 11         | 56,50  | 11 1/2     | 57,00  | 11 1/2     | 56,00  |            | 12     | 0,216      | 24                  | 4,50       |        |            |  |
| 30,0 x 3,5             | 26,5       | 17,0 x 1,0             | 16,00      | 39,0 x 3,0             | 36,00      | 2 1/4           | 57,150          | 4      | 50,00      | 6      | 52,00      | 4 1/2  | 51,50      |        |            |          | 11         | 63,30  |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 33,0 x 3,5             | 29,5       | 17,0 x 1,5             | 15,50      | 40,0 x 1,5             | 38,50      | 2 1/2           | 63,50           | 4      | 56,50      | 6      | 58,50      | 4      | 57,25      |        |            |          | 11         | 72,80  | 11         | 71,40  | 8          | 68,00  | 8          | 67,00  |            |        |            |                     |            |        |            |  |
| 36,0 x 4,0             | 32,0       | 18,0 x 1,0             | 17,00      | 40,0 x 2,0             | 38,00      | 2 3/4           | 69,850          | 3 1/2  | 62,00      | 6      | 64,50      | 4      | 63,50      |        |            |          | 11         | 79,10  |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 39,0 x 4,0             | 35,0       | 18,0 x 1,5             | 16,50      | 40,0 x 3,0             | 37,00      | 3"              | 76,200          | 3 1/2  | 68,50      | 5      | 69,75      | 4      | 70,00      |        |            |          | 11         | 85,50  |            |        |            | 8      | 84,00      | 8      | 83,00      |        |            |                     |            |        |            |  |
| 42,0 x 4,5             | 37,5       | 18,0 x 2,0             | 16,00      | 42,0 x 1,5             | 40,50      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 45,0 x 4,5             | 40,5       | 20,0 x 1,0             | 19,00      | 42,0 x 2,0             | 40,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 48,0 x 5,0             | 43,0       | 20,0 x 1,5             | 18,50      | 42,0 x 3,0             | 39,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 52,0 x 5,0             | 47,0       | 20,0 x 2,0             | 18,00      | 42,0 x 4,0             | 38,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
| 56,0 x 5,5             | 50,5       | 22,0 x 1,0             | 21,00      | 45,0 x 1,5             | 43,50      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
|                        |            | 22,0 x 1,5             | 20,50      | 45,0 x 2,0             | 43,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
|                        |            | 22,0 x 2,0             | 20,00      | 45,0 x 3,0             | 42,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |
|                        |            | 22,0 x 2,0             | 20,00      | 45,0 x 4,0             | 41,00      |                 |                 |        |            |        |            |        |            |        |            |          |            |        |            |        |            |        |            |        |            |        |            |                     |            |        |            |  |



**NOTES:**

- A) PLEASE NOTE ALL TAP DRILL SIZES ARE IN MILLIMETERS.
  - B) APPROX. METRIC DIAMETER FOLLOWS NOMINAL INCH DIAMETER
  - C) PIPE THREAD NOMINAL DIAMETERS DO NOT REPRESENT ACTUAL SIZE OF TAP
  - D) WHEN TAPPING WITH TAPER PIPE TAPS USE A TAPER REAMER IF AVAILABLE.
  - E) 1/4 INCH BRASS IS IDENTICAL TO 1/4 INCH BSF
- 1" NATIONAL FINE = 14 T.P.I.

| NATIONAL COARSE |            |        |            |
|-----------------|------------|--------|------------|
| No              | MAJOR DIAM | T.P.I. | DRILL DIAM |
| 1               | 0,073      | 64     | 1,55       |
| 2               | 0,086      | 56     | 1,85       |
| 3               | 0,099      | 48     | 2,10       |
| 4               | 0,112      | 40     | 2,35       |
| 5               | 0,125      | 40     | 2,65       |
| 6               | 0,138      | 32     | 2,85       |
| 8               | 0,164      | 32     | 3,50       |
| 10              | 0,190      | 24     | 3,90       |
| 12              | 0,216      | 24     | 4,50       |

  

| NATIONAL FINE |            |        |            |
|---------------|------------|--------|------------|
| No            | MAJOR DIAM | T.P.I. | DRILL DIAM |
| 0             | 0,060      | 80     | 1,25       |
| 1             | 0,073      | 72     | 1,55       |
| 2             | 0,086      | 64     | 1,90       |
| 3             | 0,099      | 56     | 2,15       |
| 4             | 0,112      | 48     | 2,40       |
| 5             | 0,125      | 44     | 2,70       |
| 6             | 0,138      | 40     | 2,95       |
| 8             | 0,164      | 36     | 3,50       |
| 10            | 0,190      | 32     | 4,10       |
| 12            | 0,216      | 28     | 4,70       |