

## Thread Conversion - Imperial to Metric

Imperial						Metric				
Series	Pitch Tpi	mm	Major dia. Mm	Tapping Drill (mm)	Clearance Drill (mm)	Series	Pitch mm	Major Dia.	Tapping Drill	Clearance Drill
<b>BA - British Association</b>										
12	90.9	0.279	1.30	1.1	1.4	M1.4	0.2	1.344	1.2	
11	81.9	0.310	1.50	1.2	1.6	M1.6	0.2	1.527	1.4	1.8
						M1.7	0.2	1.627		
10	72.6	0.350	1.70	1.4	1.8					
9	65.1	0.390	1.91	1.6	2.0	M2	0.4	1.886	1.75	2.4
						M2.2	0.45	2.08	1.95	
8	59.1	0.430	2.18	1.8	2.3	M2.3	0.4	2.188		
7	52.9	0.480	2.49	2.1	2.6	M2.5	0.45	2.58	2.1	2.9
6	47.9	0.530	2.79	2.3	2.7	M3	0.5	2.874	2.5	3.4
5	47.9	0.530	3.20	2.7	3.3					
						M3.5	0.6	3.354	2.9	3.9
4	38.5	0.660	3.61	3	3.7					
						M4	0.5	3.874	3.5	4.5
3	34.8	0.730	4.09	3.4	4.2					
2	31.4	0.809	4.70	4	4.8					
						M4.5	0.5	4.874	3.9	
1	28.2	0.901	5.31	4.5	5.4	M5.5	0.5	5.374	5	
						M6	1	5.794	5	6.6
0	25.4	1.000	5.99	5.1	6.1					

Imperial						Metric				
Series	Pitch Tpi	mm	Major dia. Mm	Tapping Drill (mm)	Clearance Drill (mm)	Series	Pitch mm	Major Dia.	Tapping Drill	Clearance Drill
<b>BSF - British Standard Whitworth - fine</b>										
3/16	32	0.794	4.76	4	5	M5	0.8	4.826	4.5	5.5
1/4	26	0.977	6.35	5.2	6.6					
						M7	0.75	6.838	6	7.2
9/32	26	0.977	7.14	6	7.2					
						M8	0.75	7.836	7.25	8.2
5/16	22	1.155	7.94	6.6	8.2					
						M9	0.75	8.838	8	9.4
3/8	20	1.270	9.53	8	9.8					
						M10	0.75	9.838	9.25	10.2
7/16	18	1.411	11.11	9.5	11.4					
1/2	16	1.588	12.7	11.1	13					

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<b>BSW - British Standard Whitworth - coarse</b>						M1.6	0.2	1.527	1.4	1.8
1/16	60	0.423	1.59	1.2	0	M2.5	0.45	2.58	2.1	2.9
3/32	48	0.529	2.38	1.9	0	M3	0.5	2.874	2.5	3.4
1/8	40	0.635	3.18	2.5	3.3	M4	0.7	3.978	3.3	4.5
5/32	32	0.794	3.97	3	0	M5	0.8	4.826	4.5	5.5
3/16	24	1.058	4.76	3.6	5	M6	0.75	5.838	5.2	6.1
7/32	24	1.058	5.56	4.3	0	M7	0.75	6.838	6	7.2
1/4	20	1.270	6.35	4.9	6.6	M8	0.75	7.836	7.25	8.2
9/32	20	1.270	7.14	5.6	0	M9	0.75	8.838	8	9.4
5/16	18	1.411	7.94	6.2	8.2	M10	0.75	9.838	9.25	10.2
3/8	16	1.588	9.53	7.7	9.8	M12	1	11.794	11	12.2
7/16	14	1.814	11.11	8.8	11.4					
1/2	12	2.117	12.7	10.1	13					

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<b>ME - Model Engineer</b>						M3	0.5	2.874	2.5	3.4
1/8	40	0.635	3.175	2.4	3.3					
5/32	40	0.635	3.969	3.3	4.2	M4	0.7	3.978	3.3	4.5
3/16	40	0.635	4.763	3.9	5	M5	0.8	4.826	4.5	5.5
7/32	40	0.635	5.556	4.8	5.8					
						M6	0.75	5.838	5.2	6.1
1/4	32	0.794	6.35	5.6	6.6					
1/4	40	0.635	6.35	5.5	6.6					
						M7	0.75	6.838	6	7.2
9/32	32	0.794	7.144	6.6	7.2					
9/32	40	0.635	7.144	6.5	7.2					
5/16	32	0.794	7.938	7	8.2					
5/16	40	0.635	7.938	7.3	8.2	M8	0.75	7.836	7.25	8.2
						M9	0.75	8.838	8	9.4
3/8	32	0.794	9.525	8.6	9.8					
3/8	40	0.635	9.525	8.9	9.8	M10	0.75	9.838	9.25	10.2
7/16	32	0.794	11.113	10.3	11.4					
7/16	40	0.635	11.113	10.5	11.4					
						M12	1	11.794	11	12.2
1/2	32	0.794	12.7	11.9	13					
1/2	40	0.635	12.7	12.1	13					

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