



EIS Tapping Guide



50/54 BALFOUR ROAD • JACOBS • Email: sales@eis.co.za • TEL: 031 451 7700 • WHATSAPP: 064 742 0402

145 CROMPTON STREET • PINETOWN • Email: salesp@eis.co.za • TEL: 031 713 3500 • WHATSAPP: 064 453 1479

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	NATIONAL COARSE			
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										No	MAJOR DIAM	T.P.I.	DRILL DIAM	
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									NATIONAL FINE				
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		No	MAJOR DIAM	T.P.I.	DRILL DIAM		
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									0	0,060	80	1,25	
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		1	0,073	72	1,55	
42,0 x 4,5	37,5	18,0 x 2,0	16,00	42,0 x 1,5	40,50																						2	0,086	64	1,90	
45,0 x 4,5	40,5	20,0 x 1,0	19,00	42,0 x 2,0	40,00																						3	0,099	56	2,15	
48,0 x 5,0	43,0	20,0 x 1,5	18,50	42,0 x 3,0	39,00																						4	0,112	48	2,40	
52,0 x 5,0	47,0	20,0 x 2,0	18,00	42,0 x 4,0	38,00																						5	0,125	44	2,70	
56,0 x 5,5	50,5	22,0 x 1,0	21,00	45,0 x 1,5	43,50																						6	0,138	40	2,95	
		22,0 x 1,5	20,50	45,0 x 2,0	43,00																						8	0,164	36	3,50	
		22,0 x 2,0	20,00	45,0 x 3,0	42,00																						10	0,190	32	4,10	
		22,0 x 2,0	20,00	45,0 x 4,0	41,00																						12	0,216	28	4,70	



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.

NOTES:

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

