



# Recommended Tap Drill Sizes for Tapping and Cold-forming Internal Threads

Please note: The tap drill sizes shown are reference values and may vary to be altered to meet specific tapping requirements. EMUGE shall have no liability or responsibility of any kind resulting from the selection of a tap drill size from this chart. Values printed are correct at the time of printing and subject to change without notice.

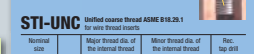
For thread systems or thread sizes not listed contact EMUGE Technical Department 060-323-3013.

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## Screen Thread Insert Threads (STI)



Normal size	P	Major thread dia. of the internal thread (D <sub>2</sub> )	Minor thread dia. of the internal thread (D <sub>1</sub> )	Rec. tap drill size
STI-1/8	1/8	0.3125	0.2812	0.2812
STI-1/4	1/4	0.6250	0.5625	0.5625
STI-3/8	3/8	0.9375	0.8125	0.8125
STI-1/2	1/2	1.2500	1.0625	1.0625
STI-5/8	5/8	1.5625	1.3125	1.3125
STI-3/4	3/4	1.8750	1.6125	1.6125
STI-7/8	7/8	2.1875	1.8625	1.8625
STI-1	1	2.5000	2.1250	2.1250

## Decimal Equivalents for Tap Drill Selection

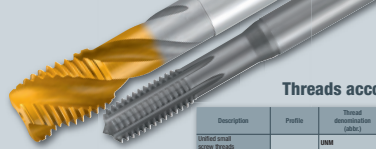
inch [mm]	Decimal inch	inch [mm]	Decimal inch	inch [mm]	Decimal inch
1/16	0.0625	1/8	0.1250	3/16	0.1875
1/8	0.1250	3/16	0.1875	1/4	0.2500
3/16	0.1875	1/4	0.2500	5/16	0.3125
1/4	0.2500	5/16	0.3125	3/8	0.3750
5/16	0.3125	3/8	0.3750	7/16	0.4375
3/8	0.3750	7/16	0.4375	1/2	0.5000
7/16	0.4375	1/2	0.5000	9/16	0.5625
1/2	0.5000	9/16	0.5625	5/8	0.6250
9/16	0.5625	5/8	0.6250	11/16	0.6875
5/8	0.6250	11/16	0.6875	3/4	0.7500
11/16	0.6875	3/4	0.7500	7/8	0.8750
3/4	0.7500	7/8	0.8750	1	1.0000

## American Standard Threads

Normal size	P	Major thread dia. of the internal thread (D <sub>2</sub> )	Minor thread dia. of the internal thread (D <sub>1</sub> )	Rec. tap drill size
UNC No. 1-20	20	1.3150	1.1875	1.1875
UNC No. 1-28	28	1.3150	1.2000	1.2000
UNC No. 1-32	32	1.3150	1.2125	1.2125
UNC No. 1-40	40	1.3150	1.2250	1.2250
UNC No. 1-48	48	1.3150	1.2375	1.2375
UNC No. 1-56	56	1.3150	1.2500	1.2500
UNC No. 1-64	64	1.3150	1.2625	1.2625
UNC No. 1-72	72	1.3150	1.2750	1.2750
UNC No. 1-80	80	1.3150	1.2875	1.2875
UNC No. 1-90	90	1.3150	1.3000	1.3000
UNC No. 1-100	100	1.3150	1.3125	1.3125
UNC No. 1-110	110	1.3150	1.3250	1.3250
UNC No. 1-120	120	1.3150	1.3375	1.3375
UNC No. 1-140	140	1.3150	1.3500	1.3500
UNC No. 1-160	160	1.3150	1.3625	1.3625
UNC No. 1-180	180	1.3150	1.3750	1.3750
UNC No. 1-200	200	1.3150	1.3875	1.3875
UNC No. 1-220	220	1.3150	1.4000	1.4000
UNC No. 1-240	240	1.3150	1.4125	1.4125
UNC No. 1-270	270	1.3150	1.4250	1.4250
UNC No. 1-300	300	1.3150	1.4375	1.4375
UNC No. 1-330	330	1.3150	1.4500	1.4500
UNC No. 1-360	360	1.3150	1.4625	1.4625
UNC No. 1-390	390	1.3150	1.4750	1.4750
UNC No. 1-420	420	1.3150	1.4875	1.4875
UNC No. 1-450	450	1.3150	1.5000	1.5000
UNC No. 1-480	480	1.3150	1.5125	1.5125
UNC No. 1-510	510	1.3150	1.5250	1.5250
UNC No. 1-540	540	1.3150	1.5375	1.5375
UNC No. 1-570	570	1.3150	1.5500	1.5500
UNC No. 1-600	600	1.3150	1.5625	1.5625
UNC No. 1-630	630	1.3150	1.5750	1.5750
UNC No. 1-660	660	1.3150	1.5875	1.5875
UNC No. 1-690	690	1.3150	1.6000	1.6000
UNC No. 1-720	720	1.3150	1.6125	1.6125
UNC No. 1-750	750	1.3150	1.6250	1.6250
UNC No. 1-780	780	1.3150	1.6375	1.6375
UNC No. 1-810	810	1.3150	1.6500	1.6500
UNC No. 1-840	840	1.3150	1.6625	1.6625
UNC No. 1-870	870	1.3150	1.6750	1.6750
UNC No. 1-900	900	1.3150	1.6875	1.6875
UNC No. 1-930	930	1.3150	1.7000	1.7000
UNC No. 1-960	960	1.3150	1.7125	1.7125
UNC No. 1-990	990	1.3150	1.7250	1.7250
UNC No. 1-1020	1020	1.3150	1.7375	1.7375
UNC No. 1-1050	1050	1.3150	1.7500	1.7500
UNC No. 1-1080	1080	1.3150	1.7625	1.7625
UNC No. 1-1110	1110	1.3150	1.7750	1.7750
UNC No. 1-1140	1140	1.3150	1.7875	1.7875
UNC No. 1-1170	1170	1.3150	1.8000	1.8000
UNC No. 1-1200	1200	1.3150	1.8125	1.8125
UNC No. 1-1230	1230	1.3150	1.8250	1.8250
UNC No. 1-1260	1260	1.3150	1.8375	1.8375
UNC No. 1-1290	1290	1.3150	1.8500	1.8500
UNC No. 1-1320	1320	1.3150	1.8625	1.8625
UNC No. 1-1350	1350	1.3150	1.8750	1.8750
UNC No. 1-1380	1380	1.3150	1.8875	1.8875
UNC No. 1-1410	1410	1.3150	1.9000	1.9000
UNC No. 1-1440	1440	1.3150	1.9125	1.9125
UNC No. 1-1470	1470	1.3150	1.9250	1.9250
UNC No. 1-1500	1500	1.3150	1.9375	1.9375
UNC No. 1-1530	1530	1.3150	1.9500	1.9500
UNC No. 1-1560	1560	1.3150	1.9625	1.9625
UNC No. 1-1590	1590	1.3150	1.9750	1.9750
UNC No. 1-1620	1620	1.3150	1.9875	1.9875
UNC No. 1-1650	1650	1.3150	2.0000	2.0000
UNC No. 1-1680	1680	1.3150	2.0125	2.0125
UNC No. 1-1710	1710	1.3150	2.0250	2.0250
UNC No. 1-1740	1740	1.3150	2.0375	2.0375
UNC No. 1-1770	1770	1.3150	2.0500	2.0500
UNC No. 1-1800	1800	1.3150	2.0625	2.0625
UNC No. 1-1830	1830	1.3150	2.0750	2.0750
UNC No. 1-1860	1860	1.3150	2.0875	2.0875
UNC No. 1-1890	1890	1.3150	2.1000	2.1000
UNC No. 1-1920	1920	1.3150	2.1125	2.1125
UNC No. 1-1950	1950	1.3150	2.1250	2.1250
UNC No. 1-1980	1980	1.3150	2.1375	2.1375
UNC No. 1-2010	2010	1.3150	2.1500	2.1500
UNC No. 1-2040	2040	1.3150	2.1625	2.1625
UNC No. 1-2070	2070	1.3150	2.1750	2.1750
UNC No. 1-2100	2100	1.3150	2.1875	2.1875
UNC No. 1-2130	2130	1.3150	2.2000	2.2000
UNC No. 1-2160	2160	1.3150	2.2125	2.2125
UNC No. 1-2190	2190	1.3150	2.2250	2.2250
UNC No. 1-2220	2220	1.3150	2.2375	2.2375
UNC No. 1-2250	2250	1.3150	2.2500	2.2500
UNC No. 1-2280	2280	1.3150	2.2625	2.2625
UNC No. 1-2310	2310	1.3150	2.2750	2.2750
UNC No. 1-2340	2340	1.3150	2.2875	2.2875
UNC No. 1-2370	2370	1.3150	2.3000	2.3000
UNC No. 1-2400	2400	1.3150	2.3125	2.3125
UNC No. 1-2430	2430	1.3150	2.3250	2.3250
UNC No. 1-2460	2460	1.3150	2.3375	2.3375
UNC No. 1-2490	2490	1.3150	2.3500	2.3500
UNC No. 1-2520	2520	1.3150	2.3625	2.3625
UNC No. 1-2550	2550	1.3150	2.3750	2.3750
UNC No. 1-2580	2580	1.3150	2.3875	2.3875
UNC No. 1-2610	2610	1.3150	2.4000	2.4000
UNC No. 1-2640	2640	1.3150	2.4125	2.4125
UNC No. 1-2670	2670	1.3150	2.4250	2.4250
UNC No. 1-2700	2700	1.3150	2.4375	2.4375
UNC No. 1-2730	2730	1.3150	2.4500	2.4500
UNC No. 1-2760	2760	1.3150	2.4625	2.4625
UNC No. 1-2790	2790	1.3150	2.4750	2.4750
UNC No. 1-2820	2820	1.3150	2.4875	2.4875
UNC No. 1-2850	2850	1.3150	2.5000	2.5000
UNC No. 1-2880	2880	1.3150	2.5125	2.5125
UNC No. 1-2910	2910	1.3150	2.5250	2.5250
UNC No. 1-2940	2940	1.3150	2.5375	2.5375
UNC No. 1-2970	2970	1.3150	2.5500	2.5500
UNC No. 1-3000	3000	1.3150	2.5625	2.5625
UNC No. 1-3030	3030	1.3150	2.5750	2.5750
UNC No. 1-3060	3060	1.3150	2.5875	2.5875
UNC No. 1-3090	3090	1.3150	2.6000	2.6000
UNC No. 1-3120	3120	1.3150	2.6125	2.6125
UNC No. 1-3150	3150	1.3150	2.6250	2.6250
UNC No. 1-3180	3180	1.3150	2.6375	2.6375
UNC No. 1-3210	3210	1.3150	2.6500	2.6500
UNC No. 1-3240	3240	1.3150	2.6625	2.6625
UNC No. 1-3270	3270	1.3150	2.6750	2.6750
UNC No. 1-3300	3300	1.3150	2.6875	2.6875
UNC No. 1-3330	3330	1.3150	2.7000	2.7000
UNC No. 1-3360	3360	1.3150	2.7125	2.7125
UNC No. 1-3390	3390	1.3150	2.7250	2.7250
UNC No. 1-3420	3420	1.3150	2.7375	2.7375
UNC No. 1-3450	3450	1.3150	2.7500	2.7500
UNC No. 1-3480	3480	1.3150	2.7625	2.7625
UNC No. 1-3510	3510	1.3150	2.7750	2.7750
UNC No. 1-3540	3540	1.3150	2.7875	2.7875
UNC No. 1-3570	3570	1.3150	2.8000	2.8000
UNC No. 1-3600	3600	1.3150	2.8125	2.8125
UNC No. 1-3630	3630	1.3150	2.8250	2.8250
UNC No. 1-3660	3660	1.3150	2.8375	2.8375
UNC No. 1-3690	3690	1.3150	2.8500	2.8500
UNC No. 1-3720	3720	1.3150	2.8625	2.8625
UNC No. 1-3750	3750	1.3150	2.8750	2.8750
UNC No. 1-3780	3780	1.3150	2.8875	2.8875
UNC No. 1-3810	3810	1.3150	2.9000	2.9000
UNC No. 1-3840	3840	1.3150	2.9125	2.9125
UNC No. 1-3870	3870	1.3150	2.9250	2.9250
UNC No. 1-3900	3900	1.3150	2.9375	2.9375
UNC No. 1-3930	3930	1.3150	2.9500	2.9500
UNC No. 1-3960	3960	1.3150	2.9625	2.9625
UNC No. 1-3990	3990	1.3150	2.9750	2.9750
UNC No. 1-4020	4020	1.3150	2.9875	2.9875
UNC No. 1-4050	4050	1.3150	3.0000	3.0000
UNC No. 1-4080	4080	1.3150	3.0125	3.0125
UNC No. 1-4110	4110	1.3150	3.0250	3.0250
UNC No. 1-4140	4140	1.3150	3.0375	3.0375
UNC No. 1-4170	4170	1.3150	3.0500	3.0500
UNC No. 1-4200	4200	1.3150	3.0625	3.0625
UNC No. 1-4230	4230	1.3150	3.0750	3.0750
UNC No. 1-4260	4260	1.3150	3.0875	3.0875
UNC No. 1-4290	4290	1.3150	3.1000	3.1000
UNC No. 1-4320	4320	1.3150	3.1125	3.1125
UNC No. 1-4350	4350	1.3150	3.1250	3.1250
UNC No. 1-4380	4380	1.3150	3.1375	3.1375
UNC No. 1-4410	4410	1.3150	3.1500	3.1500
UNC No. 1-4440	4440	1.3150	3.1625	3.1625
UNC No. 1-4470	4470	1.3150	3.1750	3.1750
UNC No. 1-4500	4500	1.3150	3.1875	3.1875
UNC No. 1-4530	4530	1.3150	3.2000	3.2000
UNC No. 1-4560	4560	1.3150	3.2125	3.2125
UNC No. 1-4590	4590	1.3150	3.2250	3.2250
UNC No. 1-4620	4620	1.3150	3.2375	3.2375
UNC No. 1-4650				



# Standardized Thread Profiles



## Threads according to international standards

## Threads according to DIN or ISO standards

Description	Profile	Thread designation (table)	Short description example	Nominal sizes	Standard	Application
ISO Metric coarse thread (one- and multi-start)		M 0.8 - 0.5 BH		0.3 mm to 0.9 mm	DIN 14-1 to DIN 14-4	for watches and fine mechanics
		M 8 - 04		1 mm to 68 mm	DIN 13-1, DIN ISO 965-1	general use (coarse thread)
		M 24 x 4 P 3 - 04		1 mm to 1000 mm	DIN 13-52 (multi-start)	general use (fine thread)
		M 24 x 4 P 2 - 04		1 mm to 1000 mm	DIN 13-52 (multi-start)	general use (fine thread)
Metric thread		M 3 - 4H 04		1.6 mm to 200 mm	ISO 9163	for oil- and spacecraft industry
		M 43 x 1.5 - 7H		6 mm to 110 mm	DIN EN 62423 or DIN EN 62562	electrical insulation pipes
ISO Metric coarse thread with transition tolerance zone (formerly: threads for light fit)		M 10 S4 4		1 mm to 150 mm	DIN 13-24 (DN 13-1), DIN ISO 965-1	non-sealing for the thread and on warm connections
		M 10 S4 4 sealing		1 mm to 150 mm	DIN 13-51	sealing
Metric thread with extra large pitch		M 30 DN 2510		12 mm to 100 mm	DIN 2510	screw connections with expansion shank
		ES M	ES M 20 - 6H rod	2 mm to 52 mm	DIN 8140	nut threads (coarse and fine threads) for steel thread inserts of wire
ISO Metric thread for steel thread inserts		MFS	MFS 1.2 x 1.5	5 mm to 16 mm	DIN 8141	for light fit in aluminum cast alloys (coarse and fine threads)
Metric tapered external thread		M 30 x 2 kg (tapered)		4 mm to 60 mm	DIN 158	for stopper screws and lubricating nipples
		M 30 x 1 - 4H04		1.6 mm to 38 mm	DIN ISO 5855	for oil- and spacecraft industry
Al thread (enlarged root radius or minor dia. in comparison with normal Metric threads)		MJ 6 x 1 - 4H04		1.6 mm to 38 mm	DIN ISO 5855	for oil- and spacecraft industry
		MJ 6 x 1 - 4H04		1.6 mm to 38 mm	DIN ISO 5855	for oil- and spacecraft industry
Straight pipe thread where pressure-tight joints are not made on the threads		G 1 1/2 A		1/8 to 6	DIN EN ISO 228	external threads for pipes, pipe connections and fittings
		Rp 1/2		1/8 to 6	DIN EN ISO 228	internal threads for pipes, pipe connections and fittings
Straight pipe thread where pressure-tight joints are made on the threads		Rp 1/2		1/8 to 6	DIN EN ISO 228	external threads for pipe screw connections (log identical with DIN EN ISO 228)
		R 1/2		1/8 to 6	DIN EN ISO 228	internal threads for pipe screw connections (log identical with DIN EN ISO 228)
Tapered pipe thread where pressure-tight joints are not made on the threads		Rp 1/2		1/8 to 6	DIN EN ISO 228	external threads for pipe screw connections (log identical with DIN EN ISO 228)
		R 1/2		1/8 to 6	DIN EN ISO 228	internal threads for pipe screw connections (log identical with DIN EN ISO 228)
Tapered pipe thread where pressure-tight joints are made on the threads		Rp 1/2		1/8 to 6	DIN EN ISO 228	external threads for pipe screw connections (log identical with DIN EN ISO 228)
		R 1/2		1/8 to 6	DIN EN ISO 228	internal threads for pipe screw connections (log identical with DIN EN ISO 228)
ISO Metric tapered thread (one- and multi-start)		T 40 x 7 - 7H		5 mm to 300 mm	DIN 103	general use
		T 40 x 14 P 7 - 7H		5 mm to 300 mm	DIN 380	general use
Flat Metric tapered thread (one- and multi-start)		T 40 x 7 DN 380		5 mm to 300 mm	DIN 380	general use
		T 40 x 14 P 7 DN 380		5 mm to 300 mm	DIN 380	general use
Tapered thread (one- and multi-start) with play		T 48 x 12 DN 263		48 mm	DIN 263	for rail vehicles
		T 40 x 16 P 8 DN 263		40 mm	DIN 263	for rail vehicles
Tapered thread with rounded corners		T 32 x 1.5 - 7H DN 0341		12 mm to 32 mm	DIN 0341	for precision collets
		T 40 x 5 DN 30295		26 mm to 80 mm	DIN 30295	for rail vehicles
Tapered thread		KT 22 DN 6063		10 mm to 50 mm	DIN 6063-2	for plastic containers in the packaging industry
		S	S 48 x 6 - 7H	10 mm to 640 mm	DIN 013	general use
Butress thread 45°		S 630 x 20 DN 2761		100 mm to 1300 mm	DIN 2761	for hydraulic presses
		S	S 8 x 1 DN 71412	6 mm to 10 mm	DIN 71412	for central lubricating nipples

Description	Profile	Thread designation (table)	Short description example	Nominal sizes	Standard	Application
Butress thread		S	S 25 x 1.5 DN 20401	6 mm to 40 mm	DIN 20401	mining industry
		S	S 22 (inverted)	10 mm to 50 mm	DIN 5525	for plastic and glass containers in the packaging industry
Straight round thread		ES	ES 22 (self-tapping for glass containers)	10 mm to 50 mm	DIN 5525	for plastic and glass containers in the packaging industry
		ES	ES 22 (self-tapping for plastic containers)	10 mm to 50 mm	DIN 5525	for plastic and glass containers in the packaging industry
Straight round thread		ES	ES 22 DN 6063	10 mm to 60 mm	DIN 6063-1	for plastic containers in the packaging industry
		ES	ES 22 DN 15463	50 mm to 300 mm	DIN 15463	for lifting hooks
Straight round thread with play and steel flanks, with pitch 7 mm		Rd	Rd 40 x 16 - 7H	8 mm to 200 mm	DIN 405	general use
		Rd	Rd 40 x 16 P 16 - 7H	8 mm to 200 mm	DIN 405	general use
Straight round thread with play and low flanks, with pitch 7 mm		Rd	Rd 40 x 5 DN 20400	10 mm to 300 mm	DIN 20400	for extra high stress resistance in the mining industry
		Rd	Rd 80 x 10 DN 15460	50 mm to 300 mm	DIN 15460	for lifting hooks
Straight round thread with play and steel flanks, with pitch 7 mm		Rd	Rd 70 DN 2273	20 mm to 100 mm	DIN 2273-1	for sheet-metal components and corresponding screw connections
		Rd	Rd 50 x 7 DN 262	34 mm to 79 mm, with pitch 7 mm	DIN 262	for rail vehicles
Straight round thread with play and low flanks, with pitch 7 mm		Rd	Rd 50 x 7 DN 264	34 mm to 79 mm, with pitch 7 mm	DIN 264	for rail vehicles
		Rd	Rd 50 x 7 left-hand DN 264	34 mm to 79 mm, with pitch 7 mm	DIN 264	for rail vehicles
Straight round thread		Rd	Rd 110 x 1/2 DN 3182	110 mm	DIN 3182	for branching apparatuses and drilling equipment
		Rd	Rd 40 x 7 DN EN 148	40 mm	DIN EN 148	for branching apparatuses
Straight round thread		GL	GL 25 x 3 DN 168	6 mm to 125 mm	DIN 168	for glass containers
		E	E 27 DN 40400	14 mm to 33 mm	DIN 40400	for D-type safety fuses, lamp fixtures and lamp sockets
Electrical thread		E 5	E 5	5 mm to 40 mm	DIN EN 60081-1	for lamp fixtures and lamp sockets
		E	E 5	5 mm to 40 mm	DIN EN 60081-1	for lamp fixtures and lamp sockets
Straight Whitworth thread		W	W 1/8 x 1/16 DN 40399	20.5 mm to 45 mm	DIN EN 40399	special threads for lamp sockets and shaft carrier rings
		W	W 1/8 x 1/16 DN 40391	7 mm	DIN 40391 (y46)	for D-type safety fuses
Sheet cordal thread		Pg	Pg 21 DN 40430	7 mm to 48 mm	DIN 40430	for the electrical industry
		ST	ST 3.5 ISO 1478	1.5 mm to 9.5 mm	DIN EN ISO 1478	for sheet metal screws
Sheet metal screw thread		ST	ST 3.5 ISO 1478	1.5 mm to 9.5 mm	DIN EN ISO 1478	for sheet metal screws
		ST	ST 3.5 ISO 1478	1.5 mm to 9.5 mm	DIN EN ISO 1478	for sheet metal screws
Wood screw thread		FG	FG 5.5 DN 79012	2 mm to 34.8 mm	DIN 79012	for wood screws
		FG	FG 5.5 DN 79012	2 mm to 34.8 mm	DIN 79012	for wood screws
Bicycle thread		FG	FG 5.5 DN 79012	2 mm to 34.8 mm	DIN 79012	for bicycles and mopeds
		FG	FG 5.5 DN 79012	2 mm to 34.8 mm	DIN 79012	for bicycles and mopeds
Valve thread		V	V 12 DN 7756	6 mm to 12 mm	DIN 7756	for fine-adjusting gear wheels (and hubs of bicycles)
		V	V 12 DN 7756	6 mm to 12 mm	DIN 7756	for fine-adjusting gear wheels (and hubs of bicycles)
Tapered Whitworth thread		17E	17E (formerly: W19.5 x 1/16 kg)	19.5 mm	DIN EN ISO 11963 (DIN EN 144-1) (DIN EN ISO 11116-1)	for side connections of gas cylinder valves
		20E	20E (formerly: W28.8 x 1/16 kg)	28.8 mm	(DIN EN 629-1) (ISO 10020)	for screened sockets of gas cylinders
Straight Whitworth thread		W	W 21.8 x 1/16 kg DN 477 (tapered)	21.8 mm	DIN 477-1	for side connections of gas cylinder valves
		W	W 21.8 x 1/16 kg DN 477 (tapered)	21.8 mm	DIN 477-1	for side connections of gas cylinder valves
RMS thread		RMS	RMS 8 x 1/16 DN EN 962	80 mm	DIN EN 962	for protection caps of gas cylinders
		RMS	RMS 8 x 1/16 DN ISO 8038	20.32 mm	DIN ISO 8038	for microscope lenses
Tapered drill pipe thread		Gg	Gg 4 1/2 DN 20314	2 1/2 to 4 1/2 to 9 5/8	DIN 20314	for the mining industry
		Gg	Gg 4 1/2 DN 20314	2 1/2 to 4 1/2 to 9 5/8	DIN 20314	for the mining industry

Description	Profile	Thread designation (table)	Short description example	Standard	Country
Unified small screw threads		UNM	0.80 UNM	ASME B1.10M	USA
Unified screw threads		UN	UN 1/4 - 20 UNC - 2A	ASME B1.1 (BS 1000)	USA / United Kingdom
		UNF	UN 1/4 - 28 UNF - 2A	ASME B1.1 (BS 1000)	USA / United Kingdom
American screw threads (tapered)		UNC	UNC 1/4 - 20 UNC - 2A	ASME B1.1 (SAE ASB19)	USA
		UNF	UNF 1/4 - 28 UNF - 2A	ASME B1.1 (SAE ASB19)	USA
Metric thread		M	M 12 - 32 NEF	ASA B1.1 (outdated)	USA
		M	M 12 - 32 NEF	ASA B1.1 (outdated)	USA
Metric thread (enlarged root radius or minor dia. in comparison with normal Metric threads)		MJ	MJ 6 x 1 - 04	ASME B1.21M	USA
		MJ	MJ 6 x 1 - 04	ASME B1.21M	USA
Whitworth thread		BSW	1/4 x 20 BS.W	BS 84	United Kingdom
		BSF	1/4 x 20 BS.F	BS 84	United Kingdom
B.S. threads		B.S.	11 B.S.	BS 93	United Kingdom
		B.S.	11 B.S.	BS 93	United Kingdom
Straight pipe thread		NPS	1/2 - 27 NPS	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Straight pipe thread		NPS	1/2 - 27 NPS	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Straight pipe thread		NPS	1/2 - 27 NPS	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Tapered pipe thread		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Tapered pipe thread		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Tapered pipe thread		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI/ASME B1.20.1	USA
Thread for steel thread inserts		UNF-276	1/4 - 20 UNC - 28 - 6T or 1/4 - 20 UNC - 28 - 6T	ASME B18.28.1	USA
		UNF-276	1/4 - 20 UNC - 28 - 6T or 1/4 - 20 UNC - 28 - 6T	ASME B18.28.1	USA
Thread for light fit		UNC-276	1/4 - 20 UNC - 28 - 6T or 1/4 - 20 UNC - 28 - 6T	ASME/ANSI B1.12	USA
		UNC-276	1/4 - 20 UNC - 28 - 6T or 1/4 - 20 UNC - 28 - 6T	ASME/ANSI B1.12	USA
Microscope thread		AMO	0.800 - 36 AMO	ASA B1.11	USA
		AMO	0.800 - 36 AMO	ASA B1.11	USA
Tapered thread		ACME	1/4 - 4 ACME - 2S	ASME B1.5	USA
		ACME	1/4 - 4 ACME - 2S	ASME B1.5	USA
Butress thread		BUT-ACME	0.500 - 20 BUT-ACME	ANSI B1.8	USA
		BUT-ACME	0.500 - 20 BUT-ACME	ANSI B1.8	USA
Bicycle thread		BSC	1/4 - 28 BSC - Mod.	BS 811	United Kingdom
		BSC	1/4 - 28 BSC - Mod.	BS 811	United Kingdom
NPT thread (thread of the American Petroleum Institute for the oil industry)		NPT	1/2 - 27 NPT	ANSI B1.20.1	USA
		NPT	1/2 - 27 NPT	ANSI B1.20.1	USA
Bucker Rods		BR	BR 1/4 - 28	ANSI Spec 11.8	USA
		BR	BR 1/4 - 28	ANSI Spec 11.8	USA

1) External thread with rounded thread root.  
 2) For thread diameters smaller than 1/4 inch.  
 3) 1/4 - 28 is the NPTF thread class. It is a pipe system without checking of the flattening on root and crests.  
 4) It is a pipe system that includes the checking of the flattening on root and crests (see page system according to ANSI B1.20.1).