

Model Engineer

40 Series

Size	T.P.I.	Recommended Tapping Drill Size		Low engagement Drill Size		Clearance Drill Size		Core Diam.	Core Area
		Imperial	Metric	Imperial	Metric	Imperial	Metric		
1/8	40	39	2.55	37	2.65	30	3.3	0.093	0.0068
5/32	40	30	3.25	29	3.4	22	4	0.125	0.0123
3/16	40	21	4	19	4.2	12	4.8	0.155	0.0189
7/32	40	11	4.8	9	5	2	5.7	0.187	0.0275
1/4	40	2	5.5	1	5.8	F	6.5	0.218	0.0373
5/16	40	9/32	7.2	L	7.4	O	8.1	0.282	0.0625
3/8	40	S	8.9	T	9	V	9.6	0.343	0.0924
7/16	40	Z	10.5	27/64	10.6	29/64	11.5	0.405	0.1288
1/2	40	31/64	12	31/64	12.15	33/64	12.6	0.468	0.1720

Model Engineer

32 Series

Size	T.P.I.	Recommended Tapping Drill Size		Low engagement Drill Size		Clearance Drill Size		Core Diam.	Core Area
		Imperial	Metric	Imperial	Metric	Imperial	Metric		
1/4	32	7/32	5.5	2	5.7	F	6.5	0.210	0.0346
9/32	32	E (=1/4)	6.35	F	6.5	L	7.3	0.241	0.0456
5/16	32	J	7	K	7.25	O	8.1	0.273	0.0585
3/8	32	11/32	8.7	S	8.8	V	9.6	0.335	0.0881
1/2	32	15/32	11.9	Z	12	33/64	12.6	0.460	0.1662

Model Engineer

26 Series

Size	T.P.I.	Recommended Tapping Drill Size		Low engagement Drill Size		Clearance Drill Size		Core Diam.	Core Area
		Imperial	Metric	Imperial	Metric	Imperial	Metric		
7/16	26	X	10	3	5.5	29/64	11.5	0.201	0.0317
1/2	26	15/32	11.9			33/64	12.6	0.451	0.1598

For other 26 tpi, see British Standard Brass.

Metric threads for Model Engineer's

Size	Pitch	Approx TPI	Recommended Tapping Drill Size		Approx BA.
			Imperial	Metric	
0.80	0.2	127.0	70	0.68	16
1	0.25	101.6	67	0.82	14
1.2	0.25	101.6	61	1.00	13
1.4	0.3	84.7	3/64	1.20	12
1.6	0.35	72.6	54	1.35	10
1.8	0.35	72.6	1/16	1.55	9
2	0.4	63.4	51	1.70	9
2.2	0.45	56.4	48	1.90	8
2.5	0.5	50.8	44	2.20	7
3	0.5	50.8	37	2.65	6
3.5	0.6	42.3	31	3.10	5
4	0.7	36.3	28	3.50	4
4.5	0.75	33.9	21	4.00	3
5	0.8	31.8	15	4.50	2
6	1	25.4	4	5.30	0
8	1.25	20.3	K	7.10	
10	1.5	16.9	S	8.80	
12	1.75	14.5	27/64	10.70	