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TAP DRILL SIZES

(Drill sizes based on approximate 72% - 77% full thread)

Tap Size	Pitch Form	Tap Drill Size	Alt Tap Drill
UNIFIED TAPS			
0	80 (U)NF	3/64"	1.25 mm
1	64 (U)NC	53	1.55 mm
	72 (U)NF	53	1.55 mm
2	56 (U)NC	50	1.85 mm
	64 (U)NF	50	1.90 mm
3	48 (U)NC	47	2.10 mm
	56 (U)NF	45	2.15 mm
4	40 (U)NC	43	2.35 mm
	48 (U)NF	42	2.40 mm
5	40 (U)NC	38	2.65 mm
	44 (U)NF	37	2.70 mm
6	32 (U)NC	36	2.75 mm
	40 (U)NF	33	2.90 mm
8	32 (U)NC	29	3.50 mm
	36 (U)NF	29	3.50 mm
10	24 (U)NC	25	3.90 mm
	32 (U)NF	21	4.10 mm
12	24 (U)NC	16	4.50 mm
	28 (U)NF	14	4.70 mm
1/4"	20 (U)NC	7	5.10 mm
	28 (U)NF	3	5.50 mm
5/16"	18 (U)NC	F	6.60 mm
	24 (U)NF	I	6.90 mm
3/8"	16 (U)NC	5/16"	8.00 mm
	24 (U)NF	Q	8.50 mm
7/16"	14 (U)NC	U	9.40 mm
	20 (U)NF	25/64"	9.90 mm
1/2"	13 (U)NC	27/64"	10.80 mm
	20 (U)NF	29/64"	11.50 mm
9/16"	12 (U)NC	31/64"	12.20 mm
	18 (U)NF	33/64"	12.90 mm
5/8"	11 (U)NC	17/32"	13.50 mm
	18 (U)NF	37/64"	14.50 mm
3/4"	10 (U)NC	21/32"	16.50 mm
	16 (U)NF	11/16"	17.50 mm
7/8"	9 (U)NC	49/64"	19.50 mm
	14 (U)NF	13/16"	20.40 mm
1"	8 (U)NC	7/8"	22.25 mm
	12 (U)NF	59/64"	23.25 mm
1-1/8"	14 (U)NS	15/16"	23.50 mm
	7 (U)NC	63/64"	25.00 mm
1-1/4"	12 (U)NF	1-3/64"	26.50 mm
	7 (U)NC	1-7/64"	28.00 mm
1-3/8"	12 (U)NF	1-11/64"	29.50 mm
	6 (U)NC	1-7/32"	30.75 mm
1-1/2"	12 (U)NF	1-19/64"	32.75 mm
	6 (U)NC	1-11/32"	34.00 mm
1-3/4"	12 (U)NF	1-27/64"	36.00 mm
	5 (U)NC	1-9/16"	39.50 mm
2"	4-12 (U)NC	1-25/32"	45.00 mm
TAPER PIPE TAPS (NPT)			
1/16"	27 NPT	D	6.30 mm
1/8"	27 NPT	R	8.70 mm
1/4"	18 NPT	7/16"	11.10 mm
3/8"	18 NPT	37/64"	14.50 mm
1/2"	14 NPT	23/32"	18.25 mm
3/4"	14 NPT	59/64"	23.25 mm
1"	11-1/2 NPT	1-5/32"	29.00 mm
1-1/4"	11-1/2 NPT	1-1/2"	38.00 mm
1-1/2"	11-1/2 NPT	1-47/64"	44.00 mm
2"	11-1/2 NPT	2-7/32"	56.00 mm
2-1/2"	8 NPT	2-5/8"	67.00 mm
3"	8 NPT	3-1/4"	82.50 mm
STRAIGHT PIPE TAPS (NPS)			
1/8"	27 NPS	S	8.80 mm
1/4"	18 NPS	29/64"	11.50 mm
3/8"	18 NPS	19/32"	15.00 mm
1/2"	14 NPS	47/64"	18.50 mm
3/4"	14 NPS	15/16"	23.75 mm
1"	11-1/2 NPS	1-3/16"	30.25 mm
1-1/4"	11-1/2 NPS	1-33/64"	38.50 mm
1-1/2"	11-1/2 NPS	1-3/4"	44.50 mm
2"	11-1/2 NPS	2-7/32"	56.00 mm

Tap Size	Pitch Form	Tap Drill Size	Alt Tap Drill
I.S.O. METRIC COARSE			
1.6	0.35 mm	1.25 mm	3/64"
1.7	0.35 mm	1.35 mm	55
1.8	0.35 mm	1.45 mm	54
2	0.40 mm	1.60 mm	1/16"
2.2	0.45 mm	1.75 mm	51
2.3	0.40 mm	1.90 mm	49
2.5	0.45 mm	2.05 mm	46
2.6	0.45 mm	2.15 mm	44
3	0.50 mm	2.50 mm	40
3.5	0.60 mm	2.90 mm	33
4	0.70 mm	3.30 mm	30
4.5	0.75 mm	3.70 mm	27
5	0.80 mm	4.20 mm	19
5.5	0.90 mm	4.60 mm	15
6	1.00 mm	5.00 mm	9
7	1.00 mm	6.00 mm	15/64"
8	1.25 mm	6.80 mm	H
9	1.25 mm	7.80 mm	5/16"
10	1.50 mm	8.50 mm	Q
11	1.50 mm	9.50 mm	3/8"
12	1.75 mm	10.20 mm	Y
14	2.00 mm	12.00 mm	15/32"
16	2.00 mm	14.00 mm	35/64"
18	2.50 mm	15.50 mm	39/64"
20	2.50 mm	17.50 mm	11/16"
22	2.50 mm	19.50 mm	49/64"
24	3.00 mm	21.00 mm	53/64"
27	3.00 mm	24.00 mm	61/64"
30	3.50 mm	26.50 mm	1-3/64"
33	3.50 mm	29.50 mm	1-5/32"
36	4.00 mm	32.00 mm	1-1/4"
39	4.00 mm	35.00 mm	1-3/8"
I.S.O. METRIC FINE			
3	0.35 mm	2.65 mm	37
4	0.35 mm	3.65 mm	27
4	0.50 mm	3.50 mm	29
4.5	0.45 mm	4.06 mm	21
5	0.50 mm	4.50 mm	16
5	0.70 mm	4.30 mm	18
5	0.75 mm	4.25 mm	18
5.5	0.50 mm	5.00 mm	9
6	0.50 mm	5.50 mm	7/32"
6	0.75 mm	5.25 mm	5
7	0.75 mm	6.25 mm	D
8	0.50 mm	7.50 mm	M
8	1.00 mm	7.00 mm	J
9	0.50 mm	8.50 mm	Q
9	1.00 mm	8.00 mm	O
10	0.50 mm	9.50 mm	3/8"
10	0.75 mm	9.25 mm	U
10	1.00 mm	9.00 mm	T
10	1.25 mm	8.75 mm	11/32"
11	1.00 mm	10.00 mm	X
12	1.00 mm	11.00 mm	7/16"
12	1.25 mm	10.75 mm	27/64"
12	1.50 mm	10.50 mm	Z
13	1.50 mm	11.50 mm	29/64"
13	1.75 mm	11.25 mm	7/16"
14	1.25 mm	12.75 mm	1/2"
14	1.50 mm	12.50 mm	31/64"
15	1.50 mm	13.50 mm	17/32"
16	1.00 mm	15.00 mm	19/32"
16	1.25 mm	14.75 mm	37/64"
16	1.50 mm	14.50 mm	9/16"
18	1.00 mm	17.00 mm	43/64"
18	1.25 mm	16.75 mm	21/32"
18	1.50 mm	16.50 mm	41/64"
18	2.00 mm	16.00 mm	5/8"
20	1.00 mm	19.00 mm	3/4"
20	1.50 mm	18.50 mm	47/64"
20	2.00 mm	18.00 mm	45/64"
22	1.00 mm	21.00 mm	53/64"
22	1.50 mm	20.50 mm	13/16"
22	2.00 mm	20.00 mm	25/32"
24	1.00 mm	23.00 mm	29/32"
24	1.50 mm	22.50 mm	7/8"
24	2.00 mm	22.00 mm	55/64"
24	2.50 mm	21.50 mm	27/32"

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DECIMAL EQUIVALENTS

For **FRACTIONAL**, WIRE GAGE, LETTER
& **METRIC (MM)** size drills.

Drill Size	Decimal Inches	Drill Size	Decimal Inches	Drill Size	Decimal Inches	Drill Size	Decimal Inches	Drill Size	Decimal Inches
0.25	.0098	2.00	.0787	#14	.1820	21/64"	.3281	35/64"	.5469
0.30	.0118	2.05	.0807	4.70	.1850	8.40	.3307	14.00	.5512
#80	.0135	#46	.0810	#13	.1850	Q	.3320	14.25	.5610
0.35	.0138	#45	.0820	3/16"	.1875	8.50	.3346	9/16"	.5625
#79	.0145	2.10	.0827	4.80	.1890	8.60	.3386	14.50	.5709
1/64"	.0156	2.15	.0846	#12	.1890	R	.3390	37/64"	.5781
0.40	.0157	#44	.0860	#11	.1910	8.70	.3425	14.75	.5807
#78	.0160	2.20	.0866	4.90	.1929	11/32"	.3437	15.00	.5906
0.45	.0177	2.25	.0886	#10	.1935	8.80	.3465	19/32"	.5937
#77	.0180	#43	.0890	#9	.1960	S	.3480	15.25	.6004
0.50	.0197	2.30	.0905	5.00	.1968	8.90	.3504	39/64"	.6094
#76	.0200	2.35	.0925	#8	.1990	9.00	.3543	15.50	.6102
#75	.0210	#42	.0935	5.10	.2008	T	.3580	15.75	.6201
0.55	.0217	3/32"	.0937	#7	.2010	9.10	.3583	5/8"	.6250
#74	.0225	2.40	.0945	13/64"	.2031	23/64"	.3594	16.00	.6299
0.60	.0236	#41	.0960	#6	.2040	9.20	.3622	16.25	.6398
#73	.0240	2.45	.0965	5.20	.2047	9.30	.3661	41/64"	.6406
#72	.0250	#40	.0980	#5	.2055	U	.3680	16.50	.6496
0.65	.0256	2.50	.0984	5.30	.2087	9.40	.3701	21/32"	.6562
#71	.0260	#39	.0995	#4	.2090	9.50	.3740	16.75	.6594
0.70	.0276	2.55	.1004	5.40	.2126	3/8"	.3750	17.00	.6693
#70	.0280	#38	.1015	#3	.2130	V	.3770	43/64"	.6719
#69	.0292	2.60	.1024	5.50	.2165	9.60	.3780	17.25	.6791
0.75	.0295	#37	.1040	7/32"	.2187	9.70	.3819	11/16"	.6875
#68	.0310	2.65	.1043	5.60	.2205	9.80	.3858	17.50	.6890
1/32"	.0313	2.70	.1063	#2	.2210	W	.3860	17.75	.6988
0.80	.0315	#36	.1065	5.70	.2244	9.90	.3898	45/64"	.7031
#67	.0320	2.75	.1083	#1	.2280	25/64"	.3906	18.00	.7087
#66	.0330	7/64"	.1093	5.80	.2283	10.00	.3937	18.25	.7185
0.85	.0335	#35	.1100	5.90	.2323	X	.3970	23/32"	.7187
#65	.0350	2.80	.1102	A	.2340	10.10	.3976	18.50	.7283
0.90	.0354	#34	.1110	15/64"	.2344	10.20	.4016	47/64"	.7344
#64	.0360	2.85	.1122	6.00	.2362	Y	.4040	18.75	.7382
#63	.0370	#33	.1130	B	.2380	10.30	.4055	19.00	.7480
0.95	.0374	2.90	.1142	6.10	.2401	13/32"	.4062	3/4"	.7500
#62	.0380	#32	.1160	C	.2420	10.40	.4094	19.25	.7579
#61	.0390	2.95	.1161	6.20	.2441	Z	.4130	49/64"	.7656
1.00	.0394	3.00	.1181	D	.2460	10.50	.4134	19.50	.7677
#60	.0400	#31	.1200	6.30	.2480	10.60	.4173	19.75	.7776
#59	.0410	3.10	.1220	E-1/4"	.2500	10.70	.4213	25/32"	.7812
1.05	.0413	1/8"	.1250	6.40	.2520	27/64"	.4219	20.00	.7874
#58	.0420	3.20	.1260	6.50	.2559	10.80	.4252	51/64"	.7969
#57	.0430	#30	.1285	F	.2570	10.90	.4291	20.25	.7972
1.10	.0433	3.30	.1299	6.60	.2598	11.00	.4330	20.50	.8071
1.15	.0453	3.40	.1339	G	.2610	11.10	.4370	13/16"	.8125
#56	.0465	#29	.1360	6.70	.2638	7/16"	.4375	20.75	.8169
3/64"	.0469	3.50	.1378	17/64"	.2656	11.20	.4409	21.00	.8268
1.20	.0472	#28	.1405	H	.2660	11.30	.4449	53/64"	.8281
1.25	.0492	9/64"	.1406	6.80	.2677	11.40	.4488	21.25	.8366
1.30	.0512	3.60	.1417	6.90	.2716	11.50	.4528	27/32"	.8437
#55	.0520	#27	.1440	I	.2720	29/64"	.4531	21.50	.8465
1.35	.0531	3.70	.1457	7.00	.2756	11.60	.4567	21.75	.8563
1.40	.0550	#26	.1470	J	.2770	11.70	.4606	55/64"	.8594
#54	.0550	#25	.1495	7.10	.2795	11.80	.4646	22.00	.8661
1.45	.0571	3.80	.1496	K	.2810	11.90	.4685	7/8"	.8750
1.50	.0591	#24	.1520	9/32"	.2813	15/32"	.4687	22.25	.8760
#53	.0595	3.90	.1535	7.20	.2835	12.00	.4724	22.50	.8858
1.55	.0610	#23	.1540	7.30	.2874	12.10	.4764	57/64"	.8906
1/16"	.0625	5/32"	.1562	L	.2900	12.20	.4803	22.75	.8957
1.60	.0629	#22	.1570	7.40	.2913	12.30	.4843	23.00	.9055
#52	.0635	4.00	.1575	M	.2950	31/64"	.4843	29/32"	.9062
1.65	.0650	#21	.1590	7.50	.2953	12.40	.4882	23.25	.9154
1.70	.0669	#20	.1610	19/64"	.2968	12.50	.4921	59/64"	.9219
#51	.0670	4.10	.1614	7.60	.2992	12.60	.4961	23.50	.9252
1.75	.0689	4.20	.1654	N	.3020	12.70	.5000	23.75	.9350
#50	.0700	#19	.1660	7.70	.3031	1/2"	.5000	15/16"	.9375
1.80	.0709	4.30	.1693	7.80	.3071	12.80	.5039	24.00	.9449
1.85	.0730	#18	.1695	7.90	.3110	12.90	.5079	61/64"	.9531
#49	.0730	11/64"	.1719	8.00	.3125	13.00	.5118	24.25	.9541
1.90	.0748	#17	.1730	O	.3150	33/64"	.5156	24.50	.9646
#48	.0760	4.40	.1732	8.10	.3160	13.20	.5197	31/32"	.9688
1.95	.0768	#16	.1770	8.20	.3189	17/32"	.5313	24.75	.9744
5/64"	.0781	4.50	.1771	8.20	.3228	13.50	.5315	25.00	.9843
#47	.0785	#15	.1800	P	.3230	13.80	.5433	63/64"	.9844
		4.60	.1811	8.30	.3268			1"	1.0000

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