

Tap and Drill Guide

MACHINE SCREW, FRACTIONAL AND METRIC SIZES											
Inch Tap Size & Pitch	Metric	Cutting Taps		Forming Taps		Inch Tap Size & Pitch	Metric	Cutting Taps		Forming Taps	
		Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.			Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
0-80		3/64	.0469	54	.0550	5/8-11		17/32	.5312	14.75	.5807
	M1.6 x 0.35	1.25	.0492	1.45	.0571	5/8-18		37/64	.5781	15.25	.6004
	M1.8 x 0.35	1.45	.0571	1.65	.0650		M16 x 2.00	14.00	.5512	19/32	.5938
1-64		53	.0595	51	.0670		M16 x 1.50	14.50	.5209	15.25	.6004
1-72		53	.0595	51	.0670		M18 x 2.50	15.50	.6102	39/64	.6094
	M2 x 0.40	1.60	.0630	1.80	.0709		M18 x 1.50	16.50	.6496	17.25	.6791
2-56		50	.0700	5/64	.0781	3/4-10		21/32	.6562	45/64	.7031
2-64		50	.0700	47	.0785	3/4-16		11/16	.6875	23/32	.7188
	M2.2 x 0.45	1.75	.0689	2.00	.0787		M20 x 2.50	17.50	.6890		
	M2.5 x 0.45	2.05	.0807	2.30	.0906		M20 x 1.50	18.50	.7283		
3-48		47	.0785	43	.0890		M22 x 2.50	19.50	.7677		
3-56		46	.0810	2.30	.0905		M22 x 1.50	20.50	.8071		
4-40		43	.0890	38	.1015	7/8-9		49/64	.7656		
4-48		42	.0935	2.60	.1024	7/8-14		13/16	.8125		
	M3 x 0.50	2.50	.0984	7/64	.1094		M24 x 3.00	21.00	.8268		
5-40		38	.1015	33	.1130		M24 x 2.00	22.00	.8661		
5-44		37	.1040	2.90	.1142	1-8		7/8	.8750		
	M3.5 x 0.60	2.90	.1142	3.20	.1260	1-12		59/64	.9219		
6-32		36	.1065	1/8	.1250		M27 x 3.00	24.00	.9449		
6-40		33	.1130	3.25	.1280		M27 x 2.00	25.00	.9843		
	M4 x 0.70	3.30	.1299	3.70	.1476	1-1/8-7		63/64	.9844		
8-32		29	.1360	25	.1495	1-1/8-12		1-3/64	1.0469		
8-36		29	.1360	24	.1520		M30 x 3.50	26.50	1.0433		
	M4.5 x 0.75	3.70	.1476	4.10	.1614		M30 x 2.00	28.00	1.1024		
10-24		26	.1470	11/64	.1719	1-1/4-7		1-7/64	1.1094		
10-32		21	.1590	16	.1770	1-1/4-12		1-11/64	1.1719		
	M5 x 0.80	4.20	.1654	14	.1820		M33 x 3.50	29.50	1.1614		
12-24		16	.1770	8	.1990		M33 x 2.00	31.00	1.2205		
12-28		15	.1800	7	.2010	1-3/8-6		1-7/32	1.2188		
	M6 x 1.00	5.00	.1969	7/32	.2188	1-3/8-12		1-19/64	1.2969		
1/4-20		7	.2010	1	.2280		M36 x 4.00	32.00	1.2598		
1/4-28		3	.2130	15/64	.2340		M36 x 3.00	33.00	1.2992		
	M7 x 1.00	6.00	.2362	F	.2570	1-1/2-6		1-11/32	1.3438		
5/16-18		F	.2570	L	.2900	1-1/2-12		1-27/64	1.4219		
5/16-24		I	.2720	M	.2950		M39 x 4.00	35.00	1.3780		
	M8 x 1.25	6.70	.2638	7.40	.2913		M39 x 3.00	36.00	1.4173		
	M8 x 1.00	7.00	.2756	19/64	.2969						
3/8-16		5/16	.3125	S	.3480						
3/8-24		Q	.3320	T	.3580						
	M10 x 1.50	8.50	.3346	U	.3680						
	M10 x 1.25	8.70	.3425	9.40	.3701						
7/16-14		U	.3680	Y	.4040						
7/16-20		25/64	.3906	Z	.4130						
	M12 x 1.75	10.20	.4016	11.20	.4409						
	M12 x 1.25	10.80	.4252	11.50	.4528						
1/2-13		27/64	.4219	15/32	.4682						
1/2-20		29/64	.4531	12.25	.4823						
	M14 x 2.00	12.00	.4224	33/64	.5156						
9/16-12		31/64	.4844	17/32	.5312						
9/16-18		33/64	.5156	13.50	.5315						



FORM TAPS NOT AVAILABLE IN THESE SIZES

PIPE TAPS — NPT, NPTF, NPSM, NPSC, NPSF					
Nominal Pipe Tap Size	NPT & NPTF		NPSM	NPSC	NPSF
	W/O Reamer	W/Reamer			
1/16-27	C (.242)	A (.234)	—	—	D (.246)
1/8-27	Q (.332)	21/64	T (.358)	T (.358)	R (.339)
1/4-18	7/16	27/64	15/32	15/32	7/16
3/8-18	9/16	9/16	.603*	.577*	37/64
1/2-14	45/64	11/16	19.0mm	19.0mm	.714*
3/4-14	29/32	57/64	61/64	61/64	59/64
1-11-1/2	1-9/64	1-1/8	1-13/64	1-13/64	1-5/32
1-1/4-11-1/2	1-31/64	1-15/32	1.546*	1.506*	—
1-1/2-11-1/2	1-23/32	1-45/64	1-25/32	1-25/32	—
2-11-1/2	2-3/16	2-11/64	2-1/4	2-1/4	—

METRIC - GREEN FRACTIONAL - RED WIRE GAGE - PURPLE LETTER SIZE - BLUE

*special