

Technical

TAP DRILL SIZES

| TAP SIZE | DRILL SIZE | PROBABLE %THREAD | TAP SIZE | DRILL SIZE | PROBABLE %THREAD | TAP SIZE | DRILL SIZE | PROBABLE %THREAD |
|-----------|------------|------------------|----------|------------|------------------|-----------|------------|------------------|
| 0-80 | 3/64 | 71-81 | 10-32 | 21 | 68-76 | 5/8-18 | 37/64 | 58-65 |
| M1.6-.35 | 1.25MM | 69-77 | M5 x .8 | 4.2 MM | 69-77 | M16 x 2 | 35/64 | 76-81 |
| 1-64 | 53 | 59-67 | 12-24 | 16 | 66-72 | 3/4-10 | 21/32 | 68-72 |
| M2 x .4 | 1/16 | 72-79 | 12-28 | 15 | 70-78 | 3/4-16 | 11/16 | 71-77 |
| 1-72 | 53 | 67-75 | M6 x 1 | 10 | 76-84 | M20x2.5 | 11/16 | 74-78 |
| 2-56 | 50 | 62-69 | 1/4-20 | 7 | 70-75 | 7/8-9 | 49/64 | 72-76 |
| 2-64 | 50 | 70-79 | 1/4-28 | 3 | 72-80 | 7/8-14 | 13/16 | 62-67 |
| M2 x .45 | 2.05MM | 69-77 | 5/16-18 | F | 72-77 | M24 x 3 | 53/64 | 72-76 |
| 3-48 | 5/64 | 70-77 | 5/16-24 | 1 | 67-75 | 1" -8 | 7/8 | 73-77 |
| 3-56 | 46 | 69-78 | M8x1.25 | 6.7 MM | 74-80 | 1" - 12 | 59/64 | 67-72 |
| 4-40 | 43 | 65-71 | 3/8-16 | 5/16 | 72-77 | 1" - 14 | 15/16 | 61-67 |
| 4-48 | 42 | 61-68 | 3/8-24 | Q | 71-79 | 1-1/8"- 7 | 63/64 | 72-76 |
| M3 x .5 | 40 | 70-79 | M10x1.5 | 8.4 MM | 76-82 | 1-1/8-12 | 1-3/16 | 66-72 |
| 5-40 | 38 | 65-72 | 7/16-14 | U | 70-75 | M30x3.5 | 1-3/64 | 75 |
| 5-44 | 37 | 63-71 | 7/16-20 | 25/64 | 65-72 | 1-1/4 - 7 | 1-7/64 | 76 |
| M3.5 x .6 | 33 | 72-81 | M12x1.7 | 13/32 | 69-74 | 1-1/4-12 | 1-11/64 | 72 |
| 6-32 | 36 | 71-78 | 1/2-13 | 27/64 | 73-78 | 1-3/8 - 6 | 1-7/32 | 72 |
| 6-40 | 33 | 69-77 | 1/2-20 | 29/64 | 65-72 | 1-3/8-12 | 1-19/64 | 72 |
| M4 x .7 | 3.25MM | 74-82 | M14 x 2 | 15/32 | 76-81 | M36 x 4 | 1-1/4 | 82 |
| 8-32 | 29 | 62-69 | 9/16-12 | 31/64 | 68-72 | 1-1/2 - 6 | 1-11/32 | 72 |
| 8-36 | 29 | 70-78 | 9/16-18 | 33/64 | 58-65 | 1-1/2-12 | 1-27/64 | 72 |
| 10-24 | 25 | 69-75 | 5/8-11 | 17/32 | 75-79 | --- | --- | --- |

TAP DRILL SIZES

| TAP SIZE | TAPERPIPE NPF&NPTF | DECIMAL EQUIVALENT | STRAIGHT PIPENPS | DECIMAL EQUIVALENT |
|-----------------|--------------------|--------------------|------------------|--------------------|
| 1/8-27 | Q | .3320 | 11/32 | .3438 |
| 1/4-18 | 7/16 | .4375 | 7/16 | .7375 |
| 3/8-18 | 9/16 | .5625 | 37/64 | .5781 |
| 1/2-14 | 45/64 | .7031 | 23/32 | .7188 |
| 3/4-14 | 29/32 | .9062 | 59/64 | .9219 |
| 1" - 11-1/2 | 1-9/64 | 1.1406 | 1-5/32 | 1.1562 |
| 1-1/4" - 11-1/2 | 1-31/64 | 1.4844 | 1-1/2 | 1.5000 |
| 1-1/2" - 11-1/2 | 1-23/32 | 1.7188 | 1-3/4 | 1.7500 |
| 2" - 11-1/2 | 2-3/16 | 2.1875 | 2-7/32 | 2.2188 |
| 2-1/2" - 8 | 2-39/64 | 2.6094 | 2-21/32 | 2.6562 |
| 3" - 8 | 3-15/64 | 3.2344 | --- | --- |