

TAP DRILL SIZES

THREAD SIZE		CUTTING TAPS			FORM TAPS			METRIC TAPS			
SIZE	PITCH	DRILL	DECIMAL	THREAD %	DRILL	DECIMAL	THREAD %	SIZE	PITCH	DRILL	THREAD %
0	80	3/64	0.0469	81	54	0.0550	60	M1.6	.35	1.25MM	77
1	64	53	0.0595	67	51	0.0670	55	M1.8	.35	1.45MM	77
1	72	53	0.0595	75	51	0.0670	60	M2	.4	1.60MM	77
2	56	50	0.0700	69	47	0.0785	60	M2.2	.45	1.75MM	77
2	64	49	0.0730	64	47	0.0785	70	M2.5	.45	2.05MM	77
3	48	46	0.0810	67	43	0.0890	65	M3	.5	2.50MM	77
3	56	45	0.8200	73	43	0.0890	75	M3.5	.6	2.90MM	77
4	40	43	0.0890	71	39	0.0995	65	M4	.7	3.30MM	77
4	48	42	0.0935	68	38	0.1015	70	M4.5	.75	3.75MM	77
5	40	38	0.1015	72	33	0.1130	65	M5	.8	4.20MM	77
5	44	37	0.1040	71	32	0.1160	55	M6	1	5.00MM	77
6	32	7/64	0.1094	70	1/8	0.1250	60	M6.3	1	5.30MM	77
6	40	32	0.1160	68	30	0.1285	55	M7	1	6.00MM	77
8	32	29	0.1360	69	25	0.1495	65	M8	1.25	6.75MM	77
8	36	28	0.1405	68	24	0.1520	65	M8	1	7.00MM	77
10	24	24	0.1520	70	18	0.1695	70	M10	1.5	8.50MM	77
10	32	20	0.1610	71	16	0.1770	60	M10	1.25	8.75MM	77
12	24	16	0.1770	72	9	0.1960	70	M12	1.75	10.20MM	79
12	28	14	0.1820	73	8	0.1990	70	M12	1.25	11.00MM	62
1/4	20	6	0.2040	71	1	0.2280	65	M14	2	12.00MM	77
1/4	28	2	0.2210	63	A	0.2340	65	M14	1.5	12.50MM	77
5/16	18	G	0.2610	71	L	0.2900	60	M16	2	14.00MM	77
5/16	24	J	0.2770	66	M	0.2950	65	M16	1.5	14.50MM	77
3/8	16	O	0.3160	73	S	0.3480	65	M18	2	15.50MM	77
3/8	24	R	0.3390	67	T	0.5800	60	M18	5	16.50MM	77
7/16	14	V	0.3770	65	Y	0.4040	70	M20	1.5	17.50MM	77
7/16	20	25/64	0.3906	72	Z	0.4130	75	M20	2.5	18.50MM	77
1/2	13	7/16	0.4375	63	15/32	0.4688	60	M22	2.5	19.50MM	77
1/2	20	29/64	0.4531	72		0.4779	65	M22	1.5	20.50MM	77
9/16	12	31/64	0.4844	72	17/32	0.5312	55	M24	3	21.00MM	77
9/16	18	33/64	0.5156	65		0.5380	65	M24	2	22.00MM	77
5/8	11	35/64	0.5469	66	37/64	0.5781	70	M27	3	24.00MM	77
5/8	18	37/64	0.5781	65		0.6004	65	M27	2	25.00MM	77
3/4	10	21/32	0.6562	72	45/64	0.7031	65	M30	3.5	26.50MM	77
3/4	16	11/16	0.6875	77	23/32	0.7188	70	M30	2	28.00MM	77
7/8	9	25/32	0.7812	65		0.8230	65	M33	3.5	29.50MM	77
7/8	14	13/16	0.8125	67	27/32	0.8438	65	M33	2	31.00MM	77
1	8	57/64	0.8906	67	15/16	0.9375	65	M36	4	32.00MM	77
1	12	59/64	0.9219	72		0.9630	65	M36	3	33.00MM	77
1	14	15/16	0.9375	67				M39	4	35.00MM	77
1-1/8	7	1	1.0000	67				M39	3	36.00MM	77
1-1/8	12	1-3/64	1.0469	72	PIPE						
1-1/4	7	1-1/8	1.1250	67	WITHOUT REAMER		WITH REAMER		STRAIGHT		
1-1/4	12	1-11/64	1.1719	72	SIZE	DRILL	DECIMAL	DRILL	DECIMAL	DRILL	DECIMAL
1-3/8	6	1-7/32	1.2188	72	1/16	D	0.2460	D	0.2460	1/4	0.2500
1-3/8	12	1-19/64	1.2969	72	1/8	Q	0.3320	21/64	0.3281	11/32	0.3438
1-1/2	6	1-11/32	1.3438	72	1/4	7/16	0.4375	27/64	0.4219	7/16	0.4375
1-1/2	12	1-27/64	1.4219	72	3/8	9/16	0.5625	9/16	0.5625	37/64	0.5781
					1/2	45/64	0.7031	11/16	0.6875	23/32	0.7187
					3/4	29/32	0.9062	57/64	0.8906	59/64	0.9220
					1	1-9/64	1.141	1-1/8	1.125	1-5/32	1.156
					1-1/4	1-31/64	1.484	1-15/32	1.469	1-1/2	1.500
					1-1/2	1-47/64	1.734	1-23/32	1.719	1-3/4	1.750
					2	2-13/64	2.203	2-3/16	2.188	2-7/32	2.219
					2-1/2	2-5/8	2.625	2-19/32	2.594	2-21/32	2.656
					3	3-1/4	3.250	3-7/32	3.219		
					3-1/2	3-3/4	3.750				
					4	4-1/4	4.250				



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