

DRILL TAP CHART



DRILL SIZES								
SIZE	DECIMAL	FRACTION	SIZE	DECIMAL	FRACTION	SIZE	DECIMAL	FRACTION
80	.0135		28	.1405		T	.3580	
79	.0145			.1406	9/64		.3594	23/64
	.0156	1/64	27	.1440		U	.3680	
78	.0160		26	.1470			.3750	3/8
77	.0180		25	.1495		V	.3770	
76	.0200		24	.1520		W	.3860	
75	.0210		23	.1540			.3906	25/64
74	.0225			.1563	5/32	X	.3970	
73	.0240		22	.1570		Y	.4040	
72	.0250		21	.1590			.4063	13/32
71	.0260		20	.1610		Z	.4130	
70	.0280		19	.1660			.4219	27/64
69	.0292		18	.1695			.4375	7/16
68	.0310			.1719	11/64		.4531	29/64
	.0313	1/32	17	.1730			.4688	15/32
67	.0320		16	.1770			.4844	31/64
66	.0330		15	.1800			.5000	1/2
65	.0350		14	.1820			.5156	33/64
64	.0360		13	.1850			.5313	17/32
63	.0370			.1875	3/16		.5469	35/64
62	.0380		12	.1890			.5625	9/16
61	.0390		11	.1910			.5781	37/64
60	.0400		10	.1935			.5938	19/32
59	.0410		9	.1960			.6094	39/64
58	.0420		8	.1990			.6250	5/8
57	.0430		7	.2010			.6406	41/64
56	.0465			.2031	13/64		.6563	21/32
	.0469	3/64	6	.2040			.6719	43/64
55	.0520		5	.2050			.6875	11/16
54	.0550		4	.2090			.7031	45/64
53	.0595		3	.2130			.7188	23/32
	.0625	1/16		.2188	7/32		.7344	47/64
52	.0635		2	.2210			.7500	3/4
51	.0670		1	.2280			.7656	49/64
50	.0700		A	.2340			.7813	25/32
49	.0730			.2344	15/64		.7969	51/64
48	.0760		B	.2380			.8125	13/16
	.0781	5/64	C	.2420			.8281	53/64
47	.0785		D	.2460			.8438	27/32
46	.0810		E	.2500	1/4		.8594	55/64
45	.0820		F	.2570			.8750	7/8
44	.0860		G	.2610			.8906	57/64
43	.0890			.2656	17/64		.9063	29/32
42	.0935		H	.2660			.9219	59/64
	.0938	3/32	I	.2720			.9375	15/16
41	.0960		J	.2770			.9531	61/64
40	.0980		K	.2810			.9688	31/32
39	.0995			.2813	9/32		.9844	63/64
38	.1015		L	.2900			1.000	1
37	.1040		M	.2950			1.0469	1-3/64
36	.1065			.2969	19/64		1.1094	1-7/64
	.1094	7/64	N	.3020			1.1250	1-1/8
35	.1100			.3125	5/16		1.1719	1-11/64
34	.1110		O	.3160			1.2188	1-7/32
33	.1130		P	.3230	21/64		1.2500	1-1/4
32	.1160			.3281			1.2969	1-19/64
31	.1200		Q	.3320			1.3438	1-11/32
	.1250	1/8	R	.3390			1.3750	1-3/8
30	.1285			.3438	11/32		1.4219	1-27/64
29	.1360		S	.3480			1.5000	1-1/2

INCH TAP DRILL SIZES		
DIAMETER	TPI	TAP DRILL
# 0	80	3/64
# 1	64	#53
# 1	72	#53
# 2	56	#50
# 2	64	#50
# 3	48	#47
# 3	56	#45
# 4	40	#43
# 4	48	#42
# 5	40	#38
# 5	44	#37
# 6	32	#36
# 6	40	#33
# 8	32	#29
# 8	36	#29
# 10	24	#25
# 10	32	#21
# 12	24	#16
# 12	28	#14
1/4	20	#7
1/4	28	#3
5/16	18	F
5/16	24	I
3/8	16	5/16
3/8	24	Q
7/16	14	U
7/16	20	25/64
1/2	13	27/64
1/2	20	29/64
9/16	12	31/64
9/16	18	33/64
5/8	11	17/32
5/8	18	37/64
3/4	10	21/32
3/4	16	11/16
7/8	9	49/64
7/8	14	13/16
1	8	7/8
1	12	59/64
1-1/8	7	63/64
1-1/8	12	1-3/64
1-1/4	7	1-7/64
1-1/4	12	1-11/64
1-3/8	6	1-7/32
1-3/8	12	1-19/64
1-1/2	6	1-11/32
1-1/2	12	1-27/64

METRIC TAP DRILL SIZES		
DIAMETER & PITCH	TAP DRILL	INCH
M1.6 x 0.35	1.25	.0492
M1.8 x 0.35	1.45	.0571
M2 x 0.4	1.60	.0630
M2.2 x 0.45	1.75	.0689
M2.5 x 0.45	2.05	.0807
M3 x 0.5	2.50	.0984
M3.5 x 0.6	2.90	.1142
M4 x 0.7	3.30	.1299
M4.5 x 0.75	3.70	.1457
M5 x 0.8	4.20	.1654
M6 x 1	5.00	.1968
M7 x 1	6.00	.2362
M8 x 1.25	6.70	.2638
M8 x 1	7.00	.2756
M10 x 1.5	8.50	.3346
M10 x 1.25	8.70	.3425
M12 x 1.75	10.20	.4016
M12 x 1.25	10.80	.4252
M14 x 2	12.00	.4724
M14 x 1.5	12.50	.4921
M16 x 2	14.00	.5512
M16 x 1.5	14.50	.5709
M18 x 2.5	15.50	.6102
M18 x 1.5	16.50	.6496
M20 x 2.5	17.50	.6890
M20 x 1.5	18.50	.7283
M22 x 2.5	19.50	.7677
M22 x 1.5	20.50	.8071
M24 x 3	21.00	.8268
M24 x 2	22.00	.8661
M27 x 3	24.00	.9449
M27 x 2	25.00	.9843
M30 x 3.5	26.50	1.0433
M30 x 2	28.00	1.1024
M33 x 3.5	29.50	1.1614
M33 x 2	31.00	1.2205
M36 x 4	32.00	1.2598
M36 x 3	33.00	1.2992
M39 x 4	35.00	1.3780
M39 x 3	36.00	1.4173

PIPE THREADS (NPT)		
PIPE SIZE	TPI	DRILL SIZE
1/16	27	C
1/8	27	Q
1/4	18	7/16
3/8	18	9/16
1/2	14	45/64
3/4	11-1/2	29/32
1	11-1/2	1-9/64
1-1/4	11-1/2	1-31/64
1-1/2	11-1/2	1-23/32
2	8	2-3/16
2-1/2	8	2-39/64
3	20	3-15/16

PRINT READING
+ TOLERANCES



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