

FRACTION & MACHINE SCREW TAP DRILL SIZES

BASED ON APPROXIMATELY 75% FULL THREAD

NATIONAL COARSE & FINE THREADS				TAPER PIPE		STRAIGHT PIPE	
THREAD	DRILL	THREAD	DRILL	THREAD	DRILL	THREAD	DRILL
#0-80	3/64	1/2-13	27/64	1/8-27	R	1/8-27	S
#1-64	NO. 53	1/2-20	39/64	1/4-18	7/16	1/4-18	29/64
#1-72	NO. 53	9/16-12	31/64	3/8-18	37/64	3/8-18	19/32
#2-56	NO. 51	9/16-18	33/64	1/2-14	23/32	1/2-14	47/64
#2-64	NO. 50	5/8-11	17/32	3/4-14	59/64	3/4-14	15/16
#3-48	5/64	5/8-18	37/64	1-11-1/2	1-5/32	1-11-1/2	1-3/16
#3-56	NO. 46	3/4-10	21/32	1-1/4-11-1/2	1-1/2	1-1/4-11-1/2	1-33/64
#4-40	NO. 43	3/4-16	11/16	1-1/2-11-1/2	1-47/64	1-1/2-11-1/2	1-3/4
#4-48	NO. 42	7/8-9	49/64	2-11-1/2	2-7/32	2-11-1/2	2-7/32
#5-40	NO. 39	7/8-14	13/16	2-1/2-8	2-5/8	2-1/2-8	2-21/32
#5-44	NO. 37	1-8	7/8	3-8	3-1/4	3-8	3-9/32
#6-32	NO. 36	1-12	29/32	3-1/2-8	3-3/4	3-1/2-8	3-25/32
#6-40	NO. 33	1-1/8-7	63/64	4-8	4-1/4	4-8	4-9/32
#8-32	NO. 29	1-1/8-12	1-3/64	4-1/2-8	4-3/4	4-1/2-8	4-25/32
#8-36	NO. 29	1-1/4-7	1-7/64	5-8	5-9/32	5-8	5-11/32
#10-24	NO. 25	1-1/4-12	1-11/64	6-8	6-11/32	6-8	6-13/32
#10-32	NO. 21	1-1/2-6	1-11/32				
#12-24	NO. 17	1-1/2-12	1-27/64				
#12-28	NO. 15	1-3/4-5	1-35/64				
1/4-20	NO. 7	1-3/4-12	1-43/64				
1/4-28	NO. 3	2-4-1/2	1-25/32				
5/16-18	F	2-12	1-59/64				
5/16-24	I	2-1/4-1-1/2	2-1/32				
3/8-16	5/16	2-1/2-4	2-1/4				
3/8-24	Q	2-3/4-4	2-1/2				
7/16-14	U	3-4	2-3/4				
7/16-20	W						



CALL 800-923-6255

METRIC TAP DRILL SIZES

Metric Nominal Size & Pitch (mm)	Tap Limit No.	Recommended Tap Drills			
		Inch Series		Metric Series	
		Nom. Size	Inch Dia.	Size (mm)	Inch Dia.
M 1.6 x 0.35	D3	—	—	1.25	.0492
M 2 x 0.4	D3	#52	.0635	1.60	.0630
M 2.5 x 0.45	D3	#45	.0820	2.05	.0807
M 3 x 0.5	D3	#39	.0995	2.50	.0984
M 3.5 x 0.6	D4	#32	.1160	2.90	.1142
M 4 x 0.7	D4	#30	.1285	3.30	.1299
M 5 x 0.8	D4	#19	.1660	4.20	.1654
M 6 x 1	D5	#8	.1990	5.00	.1968
M 8 x 1.25	D5	"H"	.2660	6.80	.2677
M 10 x 1.5	D6	"Q"	.3320	8.50	.3346
M 12 x 1.75	D6	13/32	.4062	10.25	.4035
M 14 x 2	D7	15/32	.4688	12.00	.4724
M 16 x 2	D7	35/64	.5469	14.00	.5512
M 20 x 2.5	D7	11/16	.6875	17.50	.6890
M 24 x 3	D8	53/64	.8281	21.00	.8268
M 30 x 3.5	D9	1-3/64	1.0469	26.50	1.0433
M 36 x 4	D9	1-1/4	1.2500	32.00	1.2598