

TAP DRILL SIZES

TAP SIZE	APPROX. TAP DRILL SIZE			TAP SIZE	APPROX. TAP DRILL SIZE			TAP SIZE	APPROX. TAP DRILL SIZE		
	75%	70%	60%		75%	70%	60%		75%	70%	60%
0-80	56	56	3/64	8-32	30	29	28	1/2-13	.425	.430	7/16
1-64	54	54	53	8-36	29	29	28	1/2-20	29/64	29/64	.467
1-72	54	54	53	10-24	25	24	22	9/16-12	31/64	31/64	1/2
2-56	51	51	50	10-32	21	20	19	9/16-18	33/64	33/64	.519
2-64	50	50	49	12-24	17	16	14	5/8-11	35/64	35/64	.554
3-48	48	47	46	12-28	15	14	12	5/8-18	.575	.575	37/64
3-56	47	46	45	1/4-20	7	6	4	11/16-16	.631	.631	41/64
4-40	44	44	43	1/4-28	3	3	2	3/4-10	21/32	21/32	43/64
4-48	43	42	3/32	5/16-18	F	G	H	3/4-16	11/16	.693	45/64
5-40	39	38	37	5/16-24	.272	.275	9/32	7/8-9	49/64	.774	.788
5-44	38	38	37	3/8-16	5/16	O	P	7/8-14	.805	13/16	.819
6-32	36	35	33	3/8-24	Q	R	11/32	1-8	7/8	.886	29/32
6-40	34	33	32	7/16-14	U	3/8	.382	1-12	29/32	59/64	15/16
				7/16-20	W	25/64	X				

PIPE TAP SIZES

NOMINAL PIPE TAP SIZE	TAP DRILL		NOMINAL PIPE TAP SIZE	TAP DRILL		NOMINAL PIPE TAP SIZE	TAP DRILL		NOMINAL PIPE TAP SIZE	TAP DRILL		NOMINAL PIPE TAP SIZE	TAP DRILL	
	TAPER NPT	STRAIGHT NPS		TAPER NPT	STRAIGHT NPS		TAPER NPT	STRAIGHT NPS		TAPER NPT	STRAIGHT NPS		TAPER NPT	STRAIGHT NPS
1/16-27	D	1/4	1/4-18	7/16	29/64	1/2-14	23/32	47/64	1-11-1/2	1-5/32	1-3/16	1-1/2-11-1/2	1-47/64	1-3/4
1/8-27	R	S	3/8-18	37/64	19/32	3/4-14	59/64	15/16	1-1/4-11-1/2	1-1/2	1-33/64	2-11-1/2	2-7/32	2-7/32

METRIC TAP DRILL SIZES

To achieve the theoretical 77% of thread

NOMINAL SIZE & PITCH M/M	TAP DRILL SIZE M/M	NOMINAL SIZE & PITCH M/M	TAP DRILL SIZE M/M	NOMINAL SIZE & PITCH M/M	TAP DRILL SIZE M/M	NOMINAL SIZE & PITCH M/M	TAP DRILL SIZE M/M
M1.6x0.35	1.25	M6x1	5	M16x2	14	M27x3	24
M1.8x0.35	1.45	M7x1	6	M16x1.5	14.5	M27x2	25
M2x0.4	1.60	M8x1.25	6.75	M18x2.5	15.5	M30x3.5	26.5
M2.2x0.45	1.75	M8x1	7	M18x1.5	16.5	M30x2	28
M2.5x0.45	2.05	M10x1.5	8.5	M20x2.5	17.5	M33x3.5	29.5
M3x0.5	2.5	M10x1.25	8.75	M20x1.5	18.5	M33x2	31
M3.5x0.6	2.9	M12x1.75	10.25	M22x2.5	19.5	M36x4	32
M4x0.7	3.3	M12x1.25	10.75	M22x1.5	20.5	M36x3	33
M4.5x0.75	3.75	M14x2	12	M24x3	21	M39x4	35
M5x0.8	4.2	M14x1.5	12.5	M24x2	22	M39x3	36