

Tap Drill Sizes

Cutting Taps & Thread Forming Taps

TAP DRILL SIZES			METRIC TAP DRILL SIZES		
TAP SIZE	Cutting Taps based on approx. 75% thread	Forming Taps based on approx. 65% thread	TAP SIZE	Cutting Taps based on approx. 75% thread	Forming Taps based on approx. 65% thread
	CUTTING TAP DRILL SIZE	FORMING TAP DRILL SIZE		CUTTING TAP DRILL SIZE	FORMING TAP DRILL SIZE
0-80	3/64	No. 54	M1.6 x 0.35	1.25mm	1.45mm
1-64	No. 53	1.65mm	M1.8 x 0.35	1.45mm	1/16
1-72	No. 53	1.7mm	M2 x 0.4	1.60mm	No. 49
2-56	No. 50	5/64	M2.2 x 0.45	1.75mm	No. 42
2-64	No. 50	2.0mm	M2.5 x 0.45	2.05mm	No. 41
3-48	No. 47	No. 43	M3 x 0.5	2.5mm	No. 34
3-56	No. 46	2.3mm	M3.5 x 0.6	2.9mm	3.3mm
4-40	No. 43	No. 39	M4 x 0.7	3.3mm	3.7mm
4-48	No. 42	2.6mm	M4.5 x 0.75	3.75mm	4.2mm
5-40	No. 39	No. 33	M5 x 0.8	No. 19	No. 13
5-44	No. 38	2.9mm	M6 x 1	5mm	No. 2
6-32	No. 36	1/8	M7 x 1	6mm	6.5mm
6-40	No. 33	3.2mm	M8 x 1.25	H	M
8-32	No. 29	No. 25	M8 x 1	J	19/64
8-36	No. 29	No. 24	M10 x 1.5	8.5mm	U
10-24	No. 25	11/64	M10 x 1.25	8.75mm	9.5mm
10-32	No. 21	No. 16	M12 x 1.75	13/32	7/16
12-24	No. 17	5mm	M12 x 1.25	10.75mm	11.5mm
12-28	No. 15	No. 8	M14 x 2	12mm	33/64
1/4-20	No. 7	No. 1	M14 x 1.5	12.5mm	17/32
1/4-28	No. 3	A	M16 x 2	14mm	19/32
5/16-18	F	7.3mm	M16 x 1.5	14.5mm	39/64
5/16-24	I	M	M18 x 2.5	15.5mm	17mm
3/8-16	5/16	S	M18 x 1.5	16.5mm	11/16
3/8-24	Q	T	M20 x 2.5	17.5mm	18.75mm
7/16-14	U	13/32	M20 x 1.5	18.5mm	49/64
7/16-20	W	10.5mm	M22 x 2.5	19.5mm	21mm
1/2-13	27/64	11.8mm	M22 x 1.5	20.5mm	27/32
1/2-20	29/64	12mm	M24 x 3	53/64	57/64
9/16-12	31/64	17/32	M24 x 2	22mm	* Reaming Recommended
9/16-18	33/64	13.5mm	M27 x 3	24mm	
5/8-11	17/32	14.75mm	M27 x 2	63/64	
5/8-18	37/64	15.25mm	M30 x 3.5	1-3/64*	
3/4-10	21/32	45/64	M30 x 2	1-7/64*	
3/4-16	11/16	23/32	M33 x 3.5	1-11/64*	
7/8-9	49/64		M33 x 2	31mm*	
7/8-14	13/16		M36 x 4	32mm*	
1-8	7/8		M36 x 3	33mm*	
1-12	59/64		M39 x 4	35mm*	
1-14	15/16		M39 x 3	36mm*	

PIPE TAP DRILL SIZES				
TAP SIZE	NPT** TAP DRILL SIZE	NPTF** TAP DRILL SIZE	NPS TAP DRILL SIZE	NPSF TAP DRILL SIZE
1/16	D	C	1/4	D
1/8	R	Q	S	R
1/4	7/16	7/16	29/64	7/16
3/8	37/64	9/16	19/32	37/64
1/2	23/32	45/64	47/64	45/64
3/4	59/64	29/32	15/16	59/64
1	1-5/32	1-9/64	1-3/16	1-5/32
1-1/4	1-1/2	1-31/64	1-33/64	**For tapping without reaming
1-1/2	1-47/64	1-23/32	1-3/4	
2	2-7/32	2-3/16	2-7/32	
2-1/2	2-5/8	2-39/64	2-21/32	
3	3-1/4	3-15/64		