

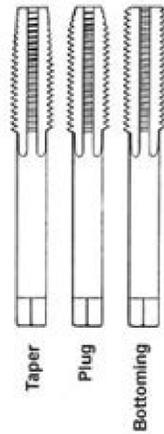
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Tap/Drill Recommendations Chart

Workshop Poster

Tap Size and Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
0-80		3/64	0.0489	54	0.0590
	M1.6 X 0.35	1.25	0.0482	1.45	0.0571
	M1.8 X 0.35	1.45	0.0571	1.65	0.0650
1-64		53	0.0595	51	0.0670
1-72		53	0.0595	51	0.0670
	M2 x 0.40	1.60	0.0630	1.80	0.0709
2-56		50	0.0700	5/64	0.0781
2-64		50	0.0700	47	0.0785
	M2.2 x 0.045	1.75	0.0689	2.00	0.0787
	M2.5 x 0.045	2.05	0.0807	2.30	0.0906
3-48		47	0.0785	43	0.0890
3-56		46	0.0810	2.30	0.0905
4-40		43	0.0890	36	0.1015
4-48		42	0.0935	2.60	0.1024
	M3 x 0.50	2.50	0.0984	7/64	0.1094
5-40		38	0.1015	33	0.1130
5-44		37	0.1040	2.90	0.1142
	M3.5 x 0.60	2.90	0.1142	3.20	0.1260
6-32		36	0.1085	1.8	0.1250
6-40		33	0.1130	3.25	0.1280
	M4 x 0.70	3.30	0.1299	3.70	0.1476
8-32		29	0.1360	25	0.1495
8-36		29	0.1360	24	0.1520
	M4.5 x 0.75	3.70	0.1476	4.10	0.1614
10-24		26	0.1470	11/64	0.1719
10-32		21	0.1590	1.6	0.1770
	M5 x 0.80	4.20	0.1654	14	0.1820
12-24		18	0.1770	8	0.1990
12-28		15	0.1800	7	0.2010
	M6 x 1.00	5.00	0.1989	7/32	0.2188
1/4-20		7	0.2010	1	0.2280
1/4-28		3	0.2130	15/64	0.2340
	M7 x 1.00	6.00	0.2362	F	0.2570
5/16-18		I	0.2570	L	0.2900
5/16-24		J	0.2720	M	0.2990
	M8 x 1.25	6.70	0.2638	7.40	0.2913
	M8 x 1.00	7.00	0.2796	19/64	0.2989
3/8-16		5/16	0.3125	S	0.3480
3/8-24		Q	0.3320	T	0.3580
	M10 x 1.50	8.50	0.3348	U	0.3680
	M10 x 1.25	8.70	0.3425	9.40	0.3701
7/16-14		U	0.3680	Y	0.4040
7/16-20		25/64	0.3905	Z	0.4130
	M12 x 1.75	10.20	0.4016	11.20	0.4409
	M12 x 1.25	10.80	0.4252	11.50	0.4528
1/2-13		27/64	0.4219	15/32	0.4682
1/2-20		29/64	0.4531	12.25	0.4823
	M14 x 2.00	12.00	0.4224	33/64	0.5156
9/16-12		31/64	0.4844	17/32	0.5312
9/16-18		33/64	0.5156	13.00	0.5315



PIPE TAPS - NPT, NPTF, NPSM, NPSC, NPSF

Nominal Pipe Tap Size	NPT & NPTF W/O Reamer	NPTF W/Reamer	NPSM	NPSC	NPSF
1/16-27	C (242)	A (234)	-	-	D (246)
1/8-27	Q (332)	21/64	T (356)	T (356)	R (336)
1/4-18	7/16	27/64	15/32	15/32	7/16
3/8-18	9/16	9/16	803"	577"	37/64
1/2-14	45/64	11/16	19.0mm	19.0mm	7/14"
3/4-14	29/32	57/64	61/64	61/64	59/64
1-11-12	1-9/64	1-1/8	1-13/64	1-13/64	1-5/32
1-1/4-11-12	1-31/64	1-15/32	1-54/64	1-50/64	-
1-1/2-11-12	1-23/32	1-45/64	1-25/32	1-25/32	-
2-11-12	2-3/16	2-11/64	2-1/4	2-1/4	-

METRIC TAP DRILL CHART

RECOMMENDED TAPPING DRILL SIZES

Tap Size	Pitch	Drill Size
M2	0.25	1.75
M3	0.35	2.65
M4	0.35	3.65
M4	0.5	3.5
M5	0.35	4.65
M5	0.5	4.5
M5	0.75	4.25
M6	0.5	5.5
M6	0.75	5.25
M7	0.75	6.25
M8	0.5	7.5
M8	0.75	7.25
M8	1	7
M9	0.75	8.25
M9	1	8
M10	0.5	9.5
M10	0.75	9.25
M10	1	9
M10	1.25	8.75
M11	0.75	10.25
M11	1	10
M11	1.25	9.75
M12	0.5	11.5
M12	0.75	11.25
M12	1	11
M12	1.25	10.75
M12	1.5	10.5
M14	1	13
M14	1.25	12.75

NOTE

1. Base of an over diameter chamfer does not fit fully, possibly apply additional chamfer in particular in deep holes.

2. Hole sizes are in millimeters.

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100. Hole sizes are in millimeters.

Metric Fine Tapping Drill Sizes

Size	Pitch	Drill
M2	0.25	1.75
M3	0.35	2.65
M4	0.35	3.65
M4	0.5	3.5
M5	0.35	4.65
M5	0.5	4.5
M5	0.75	4.25
M6	0.5	5.5
M6	0.75	5.25
M7	0.75	6.25
M8	0.5	7.5
M8	0.75	7.25
M8	1	7
M9	0.75	8.25
M9	1	8
M10	0.5	9.5
M10	0.75	9.25
M10	1	9
M10	1.25	8.75
M11	0.75	10.25
M11	1	10
M11	1.25	9.75
M12	0.5	11.5
M12	0.75	11.25
M12	1	11
M12	1.25	10.75
M12	1.5	10.5
M14	1	13
M14	1.25	12.75
M14	1.5	12.5
M14	1.75	12.25
M14	2	12
M14	2.5	11.5
M14	3	11
M14	3.5	10.5
M14	4	10
M14	4.5	9.5
M14	5	9
M14	5.5	8.5
M14	6	8
M14	6.5	7.5
M14	7	7
M14	7.5	6.5
M14	8	6
M14	8.5	5.5
M14	9	5
M14	9.5	4.5
M14	10	4
M14	10.5	3.5
M14	11	3
M14	11.5	2.5
M14	12	2
M14	12.5	1.5
M14	13	1
M14	13.5	0.5
M14	14	0
M14	14.5	-0.5
M14	15	-1
M14	15.5	-1.5
M14	16	-2
M14	16.5	-2.5
M14	17	-3
M14	17.5	-3.5
M14	18	-4
M14	18.5	-4.5
M14	19	-5
M14	19.5	-5.5
M14	20	-6
M14	20.5	-6.5
M14	21	-7
M14	21.5	-7.5
M14	22	-8
M14	22.5	-8.5
M14	23	-9
M14	23.5	-9.5
M14	24	-10
M14	24.5	-10.5
M14	25	-11
M14	25.5	-11.5
M14	26	-12
M14	26.5	-12.5
M14	27	-13
M14	27.5	-13.5
M14	28	-14
M14	28.5	-14.5
M14	29	-15
M14	29.5	-15.5
M14	30	-16
M14	30.5	-16.5
M14	31	-17
M14	31.5	-17.5
M14	32	-18
M14	32.5	-18.5
M14	33	-19
M14	33.5	-19.5
M14	34	-20
M14	34.5	-20.5
M14	35	-21
M14	35.5	-21.5
M14	36	-22
M14	36.5	-22.5
M14	37	-23
M14	37.5	-23.5
M14	38	-24
M14	38.5	-24.5
M14	39	-25
M14	39.5	-25.5
M14	40	-26
M14	40.5	-26.5
M14	41	-27
M14	41.5	-27.5
M14	42	-28
M14	42.5	-28.5
M14	43	-29
M14	43.5	-29.5
M14	44	-30
M14	44.5	-30.5
M14	45	-31
M14	45.5	-31.5
M14	46	-32
M14	46.5	-32.5
M14	47	-33
M14	47.5	-33.5
M14	48	-34
M14	48.5	-34.5
M14	49	-35
M14	49.5	-35.5
M14	50	-36
M14	50.5	-36.5
M14	51	-37
M14	51.5	-37.5
M14	52	-38
M14	52.5	-38.5
M14	53	-39
M14	53.5	-39.5
M14	54	-40
M14	54.5	-40.5
M14	55	-41
M14	55.5	-41.5
M14	56	-42
M14	56.5	-42.5
M14	57	-43
M14	57.5	-43.5
M14	58	-44
M14	58.5	-44.5
M14	59	-45
M14	59.5	-45.5
M14	60	-46
M14	60.5	-46.5
M14	61	-47
M14	61.5	-47.5
M14	62	-48
M14	62.5	-48.5
M14	63	-49
M14	63.5	-49.5
M14	64	-50
M14	64.5	-50.5
M14	65	-51
M14	65.5	-51.5
M14	66	-52
M14	66.5	-52.5
M14	67	-53
M14	67.5	-53.5
M14	68	-54
M14	68.5	-54.5
M14	69	-55
M14	69.5	-55.5
M14	70	-56
M14	70.5	-56.5
M14	71	-57
M14	71.5	-57.5
M14	72	-58
M14	72.5	-58.5
M14	73	-59
M14	73.5	-59.5
M14	74	-60
M14	74.5	-60.5
M14	75	-61
M14	75.5	-61.5
M14	76	-62
M14	76.5	-62.5
M14	77	-63
M14	77.5	-63.5
M14	78	-64
M14	78.5	-64.5
M14	79	-65
M14	79.5	-65.5
M14	80	-66
M14	80.5	-66.5

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