

METRIC TAP DRILL SIZES

TAP	TAP DRILL	DECI. EQUIV.	THEOR. % OF THREAD	TAP	TAP DRILL	DECI. EQUIV.	THEOR. % OF THREAD	TAP	TAP DRILL	DECI. EQUIV.	THEOR. % OF THREAD
M1.6 x 0.35	1.25mm	0.0492	77		I	0.2720	67	M22 x 1.5	20.5mm	0.8071	77
	1.3mm	0.0512	66	M8 x 1	7mm	0.2756	77		13/16	0.8125	70
	#55	0.0520	61		J	0.2770	74	M24 x 3	21mm	0.8268	77
M1.8 x 0.35	1.45mm	0.0571	77	M10 x 1.5	8.5mm	0.3346	77		27/32	0.8438	66
	1.5mm	0.0591	66		R	0.3390	71	M24 x 2	22mm	0.8661	77
	#53	0.0595	64	M10 x 1.25	8.75mm	0.3445	77		7/8	0.8750	68
M2 x 0.4	1.6mm	0.0630	77		S	0.3480	71	M27 x 3	24mm	0.9449	77
	#52	0.0635	74	M12 x 1.75	13/32	0.4062	74		61/64	0.9531	72
M2.2 x 0.45	1.75mm	0.0689	77		Z	0.4130	66	M27 x 2	25mm	0.9843	77
	#50	0.0700	72	M12 x 1.25	27/64	0.4219	79		63/64	0.9844	77
M2.5 x 0.45	2.05mm	0.0807	77			0.4331	62	M30 x 3.5	26.5mm	1.0433	77
	#45	0.0820	71	M14 x2	12mm	0.4724	77		1-1/16	1.0625	66
M3 x 0.5	2.5mm	0.0984	77			0.4844	65	M30 x 2	28mm	1.1024	77
	#39	0.0995	73	M14 x 1.5	12.5mm	0.4921	77		1-7/64	1.1094	70
M3.5 x 0.6	2.9mm	0.1142	77		1/2	0.5000	67	M33 x 3.5	29.5mm	1.1614	77
	#32	0.1160	71	M16 x 2	14mm	0.5512	77		1-11/64	1.1719	71
M4 x 0.7	3.3mm	0.1299	77			0.5625	66	M33 x 2	31mm	1.2205	77
	3.4mm	0.1339	66	M16 x 1.5	14.5mm	0.5709	77		1-15/64	1.2344	63
	#29	0.1360	60			0.5781	68	M36 x 4	32mm	1.2598	77
M4.5 x 0.75	3.75mm	0.1476	77	M18 x 2.5	15.5mm	0.6102	77		1-17/64	1.2656	74
	#25	0.1495	72		5/8	0.6250	65	M36 x 3	1-19/64	1.2969	78
M5 x 0.8	4.2mm	0.1654	77	M18 x 1.5	16.5mm	0.6496	77		33mm	1.2992	77
	#18	0.1695	67			0.6562	68		1-5/16	1.3125	68
M6 x 1	5mm	0.1969	77	M20 x 2.5	17.5mm	0.6890	77	M39 x 4	1-3/8	1.3750	78
	#8	0.1990	73			0.7031	66		35mm	1.3780	77
M7 x 1	6mm	0.2362	77	M20 x 1.5	18.5mm	0.7283	77		1-25/64	1.3906	71
	B	0.2380	74			0.7344	69	M39 x 3	36mm	1.4173	77
M8 x 1.25	6.75mm	0.2657	77	M22 x 2.5	19.5mm	0.7677	77		1-27/64	1.4219	74
	6.8mm	0.2677	74			0.7812	66				

PIPE TAP DRILL SIZES

TAP SIZE	*NPT		* NPTF		* STRAIGHT	
	TAP DRILL	DECIM. EQUIV.	TAP DRILL	DECIM. EQUIV.	TAP DRILL	DECIM. EQUIV.
1/16	D	0.2460	D	0.2460	1/4	0.2500
1/8	Q	0.3320	R	0.3390	11/32	0.3438
1/4	7/16	0.4375	7/16	0.4375	7/16	0.4375
3/8	9/16	0.5625	37/64	0.5781	37/64	0.5781
1/2	45/64	0.7031	45/64	0.7031	23/32	0.7188
3/4	29/32	0.9062	59/64	0.9219	59/64	0.9219
1	1-9/64	1.1406	1-5/32	1.1562	1-5/32	1.1562
1-1/4	1-31/64	1.4844	1-1/2	1.5000	1-1/2	1.5000
1-1/2	1-47/64	1.7344	1-47/64	1.7344	1-3/4	1.7500
2	2-13/64	2.2031	2-7/32	2.2188	2-7/32	2.2188
2-1/2	2-5/8	2.6250	2-41/64	2.6406	2-21/32	2.6562
3			3-17/64	3.2656		

* FOR TAPPING WITHOUT REAMING