



APPLIED

Maintenance Supplies & Solutions®

Tap & Drill Chart

Fractional • Wire • Letter • Metric Sizes

DECIMAL EQUIVALENTS

Drill Size	m/m	Decimal Equiv.	Drill Size	m/m	Decimal Equiv.	Drill Size	m/m	Decimal Equiv.	Drill Size	m/m	Decimal Equiv.
	0.10	.0039	46	2.06	.0810	5	5.22	.2055	7/16	11.11	.4375
	0.20	.0079	45	2.08	.0820	4	5.31	.2090	29/64	11.51	.4531
	0.25	.0098	44	2.18	.0860	3	5.41	.2130	15/32	11.91	.4688
	0.30	.0118	43	2.26	.0890	7/32	5.56	.2188		12.00	.4724
80	0.34	.0135	42	2.37	.0935	2	5.61	.2210	31/64	12.30	.4844
79	0.37	.0145	3/32	2.38	.0938	1	5.79	.2280	1/2	12.70	.5000
1/64	0.40	.0156	41	2.44	.0960	A	5.94	.2340		13.00	.5118
	0.40	.0157	40	2.50	.0980	15/64	5.95	.2344	33/64	13.10	.5156
78	0.41	.0160	39	2.53	.0995		6.00	.2362	17/32	13.49	.5312
77	0.46	.0180	38	2.58	.1015	B	6.05	.2380	35/64	13.89	.5469
	0.50	.0197	37	2.64	.1040	C	6.15	.2420		14.00	.5512
76	0.51	.0200	36	2.71	.1065	D	6.25	.2460	9/16	14.29	.5625
75	0.53	.0210	7/64	2.78	.1094	1/4	6.35	.2500	37/64	14.68	.5781
74	0.57	.0225	35	2.79	.1100	E	6.35	.2500		15.00	.5906
	0.60	.0236	34	2.82	.1110	F	6.53	.2570	19/32	15.08	.5938
73	0.61	.0240	33	2.87	.1130	G	6.63	.2610	39/64	15.48	.6094
72	0.64	.0250	32	2.95	.1160	17/64	6.75	.2656	5/8	15.88	.6250
71	0.66	.0260		3.00	.1181	H	6.76	.2660		16.00	.6299
	0.70	.0276	31	3.05	.1200	I	6.91	.2720	41/64	16.27	.6406
70	0.71	.0280	1/8	3.18	.1250		7.00	.2756	21/32	16.67	.6562
69	0.74	.0292	30	3.26	.1285	J	7.04	.2770		17.00	.6693
	0.75	.0295	29	3.45	.1360	K	7.14	.2810	43/64	17.07	.6719
68	0.77	.0310	28	3.57	.1405	9/32	7.14	.2812	11/16	17.46	.6875
1/32	0.79	.0312	9/64	3.57	.1406	L	7.37	.2900	45/64	17.86	.7031
	0.80	.0315	27	3.66	.1440	M	7.49	.2950		18.00	.7087
67	0.81	.0320	26	3.73	.1470	19/64	7.54	.2969	23/32	18.26	.7188
66	0.84	.0330	25	3.80	.1495	N	7.67	.3020	47/64	18.65	.7344
65	0.89	.0350	24	3.86	.1520	5/16	7.94	.3125		19.00	.7480
	0.90	.0354	23	3.91	.1540		8.00	.3150	3/4	19.05	.7500
64	0.91	.0360	5/32	3.97	.1562	O	8.03	.3160	49/64	19.45	.7656
63	0.94	.0370	22	3.99	.1570	P	8.20	.3230	25/32	19.84	.7812
62	0.97	.0380		4.00	.1575	21/64	8.33	.3281		20.00	.7874
61	0.99	.0390	21	4.04	.1590	Q	8.43	.3320	51/64	20.24	.7969
	1.00	.0394	20	4.09	.1610	R	8.61	.3390	13/16	20.64	.8125
60	1.02	.0400	19	4.22	.1660	11/32	8.73	.3438		21.00	.8268
59	1.04	.0410	18	4.31	.1695	S	8.84	.3480	53/64	21.03	.8281
58	1.07	.0420	11/64	4.37	.1719		9.00	.3543	27/32	21.43	.8438
57	1.09	.0430	17	4.39	.1730	T	9.09	.3580	55/64	21.84	.8594
56	1.18	.0465	16	4.50	.1770	23/64	9.13	.3594		22.00	.8661
3/64	1.19	.0469	15	4.57	.1800	U	9.35	.3680	7/8	22.23	.8750
55	1.32	.0520	14	4.62	.1820	3/8	9.53	.3750	57/64	22.62	.8906
54	1.40	.0550	13	4.70	.1850	V	9.56	.3770		23.00	.9055
53	1.51	.0595	3/16	4.76	.1875	W	9.80	.3860	29/32	23.02	.9062
1/16	1.59	.0625	12	4.80	.1890	25/64	9.92	.3906	59/64	23.42	.9219
52	1.61	.0635	11	4.85	.1910		10.00	.3937	15/16	23.81	.9375
51	1.70	.0670	10	4.91	.1935	X	10.08	.3970		24.00	.9449
50	1.78	.0700	9	4.98	.1960	Y	10.26	.4040	61/64	24.21	.9531
49	1.85	.0730		5.00	.1969	13/32	10.32	.4062	31/32	24.61	.9688
48	1.93	.0760	8	5.05	.1990	Z	10.49	.4130		25.00	.9843
5/64	1.98	.0781	7	5.11	.2010	27/64	10.72	.4219	63/64	25.00	.9844
47	1.99	.0785	13/64	5.16	.2031		11.00	.4331	1	25.40	1.0000
	2.00	.0787	6	5.18	.2040						

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Part #MSS TDC1

AMERICAN THREADS

Tap Size	Tap Drill Size	m/m	Decimal Equiv. of Tap Drill Inches	Probable % of Thread	Tap Size	Tap Drill Size	m/m	Decimal Equiv. of Tap Drill Inches	Probable % of Thread
0-80	56		.0465	74	3/8-24	Q	8.50	.3320	75
	3/64	1.20	.0469	72		R		.3390	58
1-64	54	1.40	.0550	81	7/16-14	23/64	9.30	.3594	81
	53	1.50	.0595	59		U		.3680	70
1-72	53	1.50	.0595	67	7/16-20	W		.3860	75
	1/16		.0625	50		25/64	9.90	.3906	68
2-56	51		.0670	75	1/2-13	27/64	10.75	.4219	75
	50	1.75	.0700	62		7/16		.4375	58
2-64	50	1.80	.0700	71	1/2-20	29/64	11.50	.4531	67
	49		.0730	56	9/16-12	15/32		.4688	84
3-48	48	2.00	.0760	79		31/64	12.00	.4844	69
	5/64		.0781	71	9/16-18	1/2		.5000	82
3-56	46	2.10	.0810	71		33/64	13.00	.5156	60
	45		.0820	66	5/8-11	17/32	13.50	.5313	76
4-40	44		.0860	75		35/64		.5469	63
	43	2.25	.0890	66	5/8-18	9/16		.5625	82
	42		.0935	51		37/64	14.50	.5781	60
4-48	3/32		.0938	50	3/4-10	41/64		.6406	81
	42	2.35	.0935	62		21/32	16.50	.6563	69
	3/32		.0938	60	3/4-16	11/16	17.50	.6875	72
5-40	39		.0995	73	7/8-9	49/64	18.50	.7656	73
	38	2.60	.1015	67		25/32		.7813	62
5-44	38		.1015	74	7/8-14	51/64		.7969	79
	37	2.60	.1040	65		13/16	20.50	.8125	62
6-32	36	2.70	.1065	73	1-8	7/8	22.50	.8750	74
	7/64		.1095	66		57/64		.8906	64
6-40	33	2.90	.1130	72	1-12	29/32		.9063	82
	32		.1160	62		59/64	23.50	.9219	68
8-32	29	3.40	.1360	64	1-14	59/64		.9219	79
8-36	29	3.50	.1360	72		15/16	23.50	.9375	62
	9/64		.1406	60	1-1/8-7	63/64	25.00	.9844	73
10-24	25	3.80	.1495	71		1		1.0000	65
10-32	5/32		.1563	78	1-1/8-12	1-1/32		1.0313	82
	21	4.00	.1590	72		1-3/64	26.50	1.0469	67
12-24	11/64		.1719	78	1-1/4-7	1-3/32		1.0938	81
	17	4.50	.1730	76		1-7/64	28.00	1.1094	73
12-28	16		.1770	80		1-1/8		1.1250	64
	15	4.60	.1800	73	1-1/4-12	1-5/32		1.1563	81
1/4-20	9		.1960	80		1-11/64	29.50	1.1719	67
	7	5.10	.2010	72	1-3/8-6	1-13/64		1.2031	77
	13/64		.2031	69		1-7/32	31.00	1.2188	69
1/4-28	3		.2130	75		1-15/64		1.2344	62
	7/32	5.50	.2188	59	1-3/8-12	1-9/32		1.2813	81
5/16-18	F	6.50	.2570	74		1-19/64	33.00	1.2969	66
	G		.2610	68	1-1/2-6	1-11/32	34.00	1.3438	69
5/16-24	H		.2660	78		1-23/64		1.3594	62
	I	6.90	.2720	70	1-1/2-12	1-13/32		1.4063	80
3/8-16	5/16	8.00	.3125	74		1-27/64	36.00	1.4219	66
	O		.3160	69					

METRIC THREADS

Tap Size	Tap Drill Size
1.50 x .35	1.10
2.00 x .40	1.60
2.00 x .45	1.50
2.00 x .50	1.50
2.30 x .40	1.90
2.50 x .45	2.00
2.60 x .45	2.10
3.00 x .50	2.50
3.00 x .60	2.40
3.00 x .75	2.25
3.50 x .60	2.90
4.00 x .70	3.30
4.00 x .75	3.25
4.50 x .75	3.75
5.00 x .75	4.25
5.00 x .80	4.20
5.00 x .90	4.10
5.00 x 1.00	4.00
5.50 x .75	4.75
5.50 x .90	4.60
6.00 x 1.00	5.00
6.00 x 1.25	4.80
7.00 x 1.00	6.00
7.00 x 1.25	5.80
8.00 x 1.00	7.00
8.00 x 1.25	6.80
9.00 x 1.00	8.00
9.00 x 1.25	7.80
10.00 x 1.25	8.80
10.00 x 1.50	8.60
11.00 x 1.50	9.60
12.00 x 1.25	11.00
12.00 x 1.50	10.50
12.00 x 1.75	10.50
13.00 x 1.50	11.50
13.00 x 1.75	11.50
13.00 x 2.00	11.00
14.00 x 1.25	13.00
14.00 x 1.75	12.50
14.00 x 2.00	12.00
15.00 x 1.75	13.50
15.00 x 2.00	13.00
16.00 x 2.00	14.00
17.00 x 2.00	15.00
18.00 x 1.50	16.50
18.00 x 2.00	16.00
18.00 x 2.50	15.50
19.00 x 2.50	16.50
20.00 x 2.00	18.00
20.00 x 2.50	17.50
22.00 x 2.50	19.50
24.00 x 3.00	21.00
26.00 x 3.00	23.00
27.00 x 3.00	24.00
28.00 x 3.00	25.00
30.00 x 3.50	26.50
32.00 x 3.50	28.50
33.00 x 3.50	29.50
34.00 x 3.50	30.50
36.00 x 4.00	32.00
38.00 x 4.00	34.00

Recommended tap drill sizes for approximately 75% depth of thread.

PIPE TAP DRILL SIZES

Tap Size	NPT Tap Drill		NPS Tap Drill	
	Inch	m/m	Inch	m/m
1/16 - 27	D	6.25	1/4	6.35
1/8 - 27	Q	8.50	11/32	8.75
1/4 - 18	7/16	11.00	7/16	11.50
3/8 - 18	9/16	14.50	37/64	15.00
1/2 - 14	45/64	18.00	23/32	18.50
3/4 - 14	29/32	23.00	59/64	23.50
1 - 11-1/2	1-9/64	29.00	1-5/32	29.50
1-1/4 - 11-1/2	1-31/64	38.00	1-1/2	38.50
1-1/2 - 11-1/2	1-47/64	44.00	1-3/4	44.50
2 - 11-1/2	2-13/64	56.00	2-7/32	57.00
2-1/2 - 8	2-5/8	66.68	2-21/32	67.47

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