

CONVERSION CHARTS

FRACTIONAL • WIRE • LETTER • METRIC

TAP DRILL SIZES

| Tap Size | Tap Drill Size | m/m | Decimal Equiv. of Tap Drill | Probable % of Thread |
|----------------|----------------|------|-----------------------------|----------------------|
| 0-80 | 56 | | .0465 | 74 |
| | 3/64 | 1.20 | .0469 | 72 |
| 1-64 | 54 | 1.40 | .0550 | 81 |
| | 53 | 1.50 | .0595 | 59 |
| 1-72 | 53 | 1.50 | .0595 | 67 |
| | 1/16 | | .0625 | 50 |
| 2-56 | 51 | | .0670 | 75 |
| | 50 | 1.75 | .0700 | 62 |
| 2-64 | 50 | 1.80 | .0700 | 71 |
| | 49 | | .0730 | 56 |
| 3-48 | 48 | 2.00 | .0760 | 79 |
| | 5/64 | | .0781 | 71 |
| 3-56 | 46 | 2.10 | .0810 | 71 |
| | 45 | | .0820 | 66 |
| 4-40 | 44 | | .0860 | 75 |
| | 43 | 2.25 | .0890 | 66 |
| | 42 | | .0935 | 51 |
| 4-48 | 42 | 2.35 | .0935 | 62 |
| | 3/32 | | .0938 | 50 |
| 5-40 | 39 | | .0995 | 73 |
| | 38 | 2.60 | .1015 | 67 |
| 5-44 | 38 | | .1015 | 74 |
| | 37 | 2.60 | .1040 | 65 |
| 6-32 | 36 | 2.70 | .1065 | 73 |
| | 7/64 | | .1095 | 66 |
| 6-40 | 33 | 2.90 | .1130 | 72 |
| | 32 | | .1160 | 62 |
| 8-32 | 29 | 3.40 | .1360 | 64 |
| | 8-36 | 29 | 3.50 | .1360 |
| 9/64 | | | .1406 | 60 |
| 10-24 | 25 | 3.80 | .1495 | 71 |
| 10-32 | 5/32 | | .1563 | 78 |
| | 21 | 4.00 | .1590 | 72 |
| 12-24 | 11/64 | | .1719 | 78 |
| | 17 | 4.50 | .1730 | 76 |
| 12-28 | 16 | | .1770 | 80 |
| | 15 | 4.60 | .1800 | 73 |
| 1/4-20 | 9 | | .1960 | 80 |
| | 7 | 5.10 | .2010 | 72 |
| | 13/64 | | .2031 | 69 |
| 1/4-28 | 3 | | .2130 | 75 |
| | 7/32 | 5.50 | .2188 | 59 |
| 5/16-18 | F | 6.50 | .2570 | 74 |
| | G | | .2610 | 68 |
| 5/16-24 | H | | .2660 | 78 |
| | I | 6.90 | .2720 | 70 |
| | O | | .3160 | 69 |

| Tap Size | Tap Drill Size | m/m | Decimal Equiv. of Tap Drill | Probable % of Thread |
|-----------------|----------------|-------|-----------------------------|----------------------|
| 3/8-24 | Q | 8.50 | .3320 | 75 |
| | R | | .3390 | 58 |
| 7/16-14 | 23/64 | 9.30 | .3594 | 81 |
| | U | | .3680 | 70 |
| 7/16-20 | W | | .3680 | 75 |
| | 25/64 | 9.90 | .3906 | 68 |
| 1/2-13 | 27/64 | 10.75 | .4219 | 75 |
| | 7/16 | | .4375 | 58 |
| 1/2-20 | 29/64 | 11.50 | .4531 | 67 |
| 9/16-12 | 15/32 | | .4688 | 84 |
| | 31/64 | 12.00 | .4844 | 69 |
| 9/16-18 | 1/2 | | .5000 | 82 |
| | 33/64 | 13.00 | .5156 | 60 |
| 5/8-11 | 17/32 | 13.50 | .5313 | 76 |
| | 37/64 | | .5469 | 63 |
| 5/8-18 | 9/16 | | .5625 | 82 |
| | 37/64 | 14.50 | .5781 | 60 |
| 3/4-10 | 41/64 | | .6406 | 81 |
| 3/4-16 | 21/32 | 16.50 | .6563 | 69 |
| | 11/16 | 17.50 | .6875 | 72 |
| 7/8-9 | 49/64 | 18.50 | .7656 | 73 |
| | 25/32 | | .7813 | 62 |
| 7/8-14 | 51/64 | | .7969 | 79 |
| | 13/16 | 20.50 | .8125 | 62 |
| 1-8 | 7/8 | 22.50 | .8750 | 74 |
| | 57/64 | | .8906 | 64 |
| 1-12 | 29/32 | | .9063 | 82 |
| | 59/64 | 23.50 | .9219 | 68 |
| 1-14 | 59/64 | | .9219 | 79 |
| | 15/16 | 23.50 | .9375 | 62 |
| 1-1/8-7 | 63/64 | 25.00 | .9844 | 73 |
| | 1 | | 1.0000 | 65 |
| 1-1/8-12 | 1-1/32 | | 1.0313 | 82 |
| | 1-3/64 | 26.50 | 1.0469 | 67 |
| 1-1/4-7 | 1-3/32 | | 1.0938 | 81 |
| | 1-7/64 | 28.00 | 1.1094 | 73 |
| 1-1/4-12 | 1-1/8 | | 1.1250 | 64 |
| | 1-5/32 | | 1.1563 | 81 |
| 1-3/8-6 | 1-11/64 | 29.50 | 1.1719 | 67 |
| | 1-13/64 | | 1.2031 | 77 |
| 1-3/8-12 | 1-7/32 | 31.00 | 1.2188 | 69 |
| | 1-15/64 | | 1.2344 | 62 |
| 1-3/8-18 | 1-9/32 | | 1.2813 | 81 |
| | 1-19/64 | 33.00 | 1.2969 | 66 |
| 1-1/2-6 | 1-11/32 | 34.00 | 1.3438 | 69 |
| | 1-23/64 | | 1.3594 | 62 |
| 1-1/2-12 | 1-13/32 | | 1.4063 | 80 |
| | 1-27/64 | 36.00 | 1.4219 | 66 |

PIPE TAP DRILL SIZES

| Tap Size | NPT Tap Drill | | NPS Tap Drill | |
|-----------------------|---------------|-------|---------------|-------|
| | Inches | m/m | Inches | m/m |
| 1/16 - 27 | D | 6.25 | 1/4 | 6.35 |
| 1/8 - 27 | Q | 8.50 | 13/32 | 8.70 |
| 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 3/64 | 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 | 66.28 | 2 21/32 | 67.47 |

METRIC TAP, DRILL SIZES

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

Recommended tap drill sizes for approximately 75% depth of thread