

DECIMAL EQUIVALENTS

STANDARD TAP & DRILL

Approx. 75% Thread

0-80	3/64
1-64	53
1-72	53
2-56	50
2-64	50
3-48	47
3-56	46
4-40	43
4-48	42
5-40	39
5-44	38
6-32	36
6-40	33
8-32	29
8-36	29
10-24	25
10-32	21
12-24	17
12-28	15
1/4-20	7
1/4-28	3
5/16-18	F
5/16-24	I
3/8-16	5/16
3/8-24	Q
7/16-14	U
7/16-20	W
1/2-12	27/64
1/2-13	27/64
1/2-20	29/64
9/16-12	31/64
9/16-18	33/64
5/8-11	17/32
5/8-18	37/64
3/4-10	21/32
3/4-16	11/16
7/8-9	49/64
7/8-14	13/16
1-8	7/8
1-12	59/64
1-14	15/16

TAPER PIPE TAP & DRILL

NPT

1/16-27	D
1/8-27	R
1/4-18	7/16
3/8-18	37/64
1/2-14	45/64
3/4-14	59/64
1-11 1/2	1 5/32
1 1/4-11 1/2	1 1/2
1 1/2-11 1/2	1 47/64
2-11 1/2	2 7/32

METRIC TAP & DRILL

Approx. 70-75% Thread

M1.6 x .35	1.25mm
M2.0 x .40	1.6
M2.5 x .45	2.05
M3.0 x .50	2.5
M3.5 x .60	2.9
M4.0 x .70	3.3
M4.5 x .75	3.75
M5.0 x .80	4.2
M6.0 x 1.0	5
M7.0 x 1.0	6
M8 x 1.25	6.75
M10 x 1.50	8.5
M12 x 1.75	Y
M14 x 2.0	12
M16 x 2.0	14
M18 x 2.5	15.5
M20 x 2.5	17.5

Conversion Formula: From Inches to Millimeters - multiply by 25.4
From Millimeters to Inches - multiply by 0.0394

Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal
0.1mm	.0039	41	.0960	15/64	.2344	33/64	.5156
0.2mm	.0079	40	.0980	6mm	.2362	17/32	.5313
0.3mm	.0118	2.5mm	.0984	B	.2380	13.5mm	.5315
80	.0135	39	.0995	C	.2420	35/64	.5469
79	.0145	38	.1015	D	.2460	14mm	.5512
1/64	.0156	37	.1040	1/4 & E	.2500	9/16	.5625
0.4mm	.0157	36	.1065	6.5mm	.2559	14.5mm	.5709
78	.0160	7/64	.1094	F	.2570	37/64	.5781
77	.0180	35	.1100	G	.2610	15mm	.5906
0.5mm	.0197	34	.1110	17/64	.2656	19/32	.5938
76	.0200	33	.1130	H	.2660	39/64	.6094
75	.0210	32	.1160	I	.2720	15.5mm	.6102
74	.0225	3mm	.1181	7mm	.2756	5/8	.6250
0.6mm	.0236	31	.1200	J	.2770	16mm	.6299
73	.0240	1/8	.1250	K	.2810	41/64	.6406
72	.0250	30	.1285	9/32	.2812	16.5mm	.6496
71	.0260	29	.1360	L	.2900	21/32	.6562
0.7mm	.0276	3.5mm	.1378	M	.2950	17mm	.6693
70	.0280	28	.1405	7.5mm	.2953	43/64	.6719
69	.0292	9/64	.1406	19/64	.2969	11/16	.6875
68	.0310	27	.1440	N	.3020	17.5mm	.6890
1/32	.0312	26	.1470	5/16	.3125	45/64	.7031
0.8mm	.0315	25	.1495	8mm	.3150	18mm	.7087
67	.0320	24	.1520	O	.3160	23/32	.7188
66	.0330	23	.1540	P	.3230	18.5mm	.7283
65	.0350	5/32	.1562	21/64	.3281	47/64	.7344
0.9mm	.0354	22	.1570	Q	.3320	19mm	.7480
64	.0360	4mm	.1575	8.5mm	.3346	3/4	.7500
63	.0370	21	.1590	R	.3390	49/64	.7656
62	.0380	20	.1610	11/32	.3438	19.5mm	.7677
61	.0390	19	.1660	S	.3480	25/32	.7812
1mm	.0394	18	.1695	9mm	.3543	20mm	.7874
60	.0400	11/64	.1719	T	.3580	51/64	.7969
59	.0410	17	.1730	23/64	.3594	20.5mm	.8071
58	.0420	16	.1770	U	.3680	13/16	.8125
57	.0430	4.5mm	.1772	9.5mm	.3740	21mm	.8268
56	.0465	15	.1800	3/8	.3750	53/64	.8281
3/64	.0469	14	.1820	V	.3770	27/32	.8438
55	.0520	13	.1850	W	.3860	21.5mm	.8465
54	.0550	3/16	.1875	25/64	.3906	55/64	.8594
1.5mm	.0591	12	.1890	10mm	.3937	22mm	.8661
53	.0595	11	.1910	X	.3970	7/8	.8750
1/16	.0625	10	.1935	Y	.4040	22.5mm	.8858
52	.0635	9	.1960	13/32	.4062	57/64	.8906
51	.0670	5mm	.1969	Z	.4130	23mm	.9055
50	.0700	8	.1990	10.5mm	.4134	29/32	.9062
49	.0730	7	.2010	27/64	.4219	59/64	.9219
48	.0760	13/64	.2031	11mm	.4331	23.5mm	.9252
5/64	.0781	6	.2040	7/16	.4375	15/16	.9375
47	.0785	5	.2055	11.5mm	.4528	24mm	.9449
2mm	.0787	4	.2090	29/64	.4531	61/64	.9531
46	.0810	3	.2130	15/32	.4688	24.5mm	.9646
45	.0820	5.5mm	.2165	12mm	.4724	31/32	.9688
44	.0860	7/32	.2188	31/64	.4844	25mm	.9843
43	.0890	2	.2210	12.5mm	.4921	63/64	.9844
42	.0935	1	.2280	1/2	.5000	1	1.000
3/32	.0938	A	.2340	13mm	.5118		

SCREW THREAD INSERT (STI) TAP & DRILL

2-56	3/32	8-32	17	5/16-24	21/64
3-48	36	8-36	17	3/8-16	X
3-56	37	10-24	13/64	3/8-24	25/64
4-40	31	10-32	7	7/16-14	29/64
4-48	3mm	12-24	1	7/16-20	29/64
5-40	3.4mm	1/4-20	H	1/2-13	33/64
6-32	26	1/4-28	G	1/2-20	33/64
6-40	26	5/16-18	Q	—	—

THREAD FORM TAP & DRILL

Approx. 65% Thread

0-80	54
1-64	1.65mm
1-72	1.7mm
2-56	5/64
2-64	2mm
3-48	43
3-56	2.3mm
4-40	39
4-48	2.6mm
5-40	33
5-44	2.9mm
6-32	1/8
6-40	3.2mm
8-32	25
8-36	24
10-24	11/64
10-32	16
12-24	5mm
12-28	8
1/4-20	1
1/4-28	A
5/16-18	7.3mm
5/16-24	M
3/8-16	S
3/8-24	T
7/16-14	13/32
7/16-20	10.5mm
1/2-13	15/32
1/2-20	31/64
9/16-12	17/32
9/16-18	13.5mm
5/8-11	15mm
5/8-18	19/32
3/4-10	45/64
3/4-16	23/32
7/8-9	.823
7/8-14	27/32
1-8	15/16
1-12	.963

STRAIGHT PIPE TAP & DRILL

NPS

1/16-27	1/4
1/8-27	11/32
1/4-18	7/16
3/8-18	37/64
1/2-14	23/32
3/4-14	59/64
1-11 1/2	1 5/32
1 1/4-11 1/2	1 1/2
1 1/2-11 1/2	1 3/4
2-11 1/2	2 7/32

METRIC THREAD FORM TAP & DRILL

Approx. 65% Thread

M1.6 x .35	1.45mm
M2.0 x .40	1.85mm
M2.5 x .45	2.30mm
M3.0 x .50	35
M3.5 x .60	30
M4.0 x .70	3.7mm
M5.0 x .80	14
M6.0 x 1.0	5.5mm
M8 x 1.25	7.4mm
M10 x 1.50	9.3mm
M12 x 1.75	7/16
M14 x 2.0	13mm
M16 x 2.0	15mm
M20 x 2.5	18.75mm