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Taping Knives	H3
Tapping Tools & Accessories	B26

Taps – Carbide:	
Hand	B13
Spiral Pointed	B13
Taper Pipe, NPT	B13

Taps – Carbon Steel:	
Hand	B19
Metric	B20
Spark Plug	B20
Taper Pipe, NPT	B20

Taps – High Performance:	
Spiral Fluted	B9
Spiral Pointed	B11

Taps – High Speed Steel:	
Acme	B11
Eight Pitch	B5
Hand	B2–7, B19–20
Metric Hand	B6–7
Oversize	B5
Pulley	B8
Screw Thread Insert (STI)	B7
Special Thread	B4
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Spiral Pointed	B10–11
Tap Bit – Monolock™ Quick Change	B5
Thread Forming	B–8

Tap Sets:	
Carbon Steel Hand Taps	B19, B35
High Speed Steel Hand Taps	B2–3, B35
Spark Plug	B20

Taps – Spiral Fluted:	
High Performance	B9
High Speed Steel	B9

Taps – Spiral Pointed:	
Carbide	B13
High Performance	B11
High Speed Steel	B10–11
Oversize	B10
Steam Oxide Treated	B11
Titanium (TiN) Coated	B10

Taps – Straight Pipe – NPS	B12
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Taps – Taper Pipe:	
BSPT (British Standard) – HSS	B12
Interrupted Thread – HSS	B12
NPT – Carbide	B13
NPT – Carbon Steel	B20
NPT – HSS	B12
NPTF (Dry Seal) – HSS	B12
Reamers – HSS	B12

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 3/64	1.20	.0465 .0469	74 72
1-64	54 53	1.40 1.50	.0550 .0595	81 59
1-72	53 1/16	1.50	.0595 .0625	67 50
2-56	51 50	1.75	.0670 .0700	75 62
2-64	50 49	1.80	.0700 .0730	71 56
3-48	48 5/64	2.00	.0760 .0781	79 71
3-56	46 45	2.10	.0810 .0820	71 66
4-40	44 43 42 3/32	2.25	.0860 .0890 .0935 .0938	75 66 51 50
4-48	42 3/32	2.35	.0935 .0938	62 60
5-40	39 38	2.60	.0995 .1015	73 67
5-44	38 37	2.60	.1015 .1040	74 65
6-32	36 7/64	2.70	.1065 .1095	73 66
6-40	33 32	2.90	.1130 .1160	72 62
8-32	29	3.40	.1360	64
8-36	29 9/64	3.50	.1360 .1406	72 60
10-24	25	3.80	.1495	71
10-32	5/32 21	4.00	.1563 .1590	78 72
12-24	11/64 17	4.50	.1719 .1730	78 76
12-28	16 15	4.60	.1770 .1800	80 73
1/4-20	9 7 13/64	5.10	.1960 .2010 .2031	80 72 69
1/4-28	3 7/32	5.50	.2130 .2188	75 59
5/16-18	F G	6.50	.2570 .2610	74 68
5/16-24	H I	6.90	.2660 .2720	78 70
3/8-16	5/16 O	8.00	.3125 .3160	74 69

Tap Size	Tap Drill Size	m/m	Decimal Equiv. of Tap Drill	Probable % of Thread
3/8-24	Q R	8.50	.3320 .3390	75 58
7/16-14	23/64 U	9.30	.3594 .3680	81 70
7/16-20	W 25/64	9.90	.3860 .3906	75 68
1/2-13	27/64 7/16	10.75	.4219 .4375	75 58
1/2-20	29/64	11.50	.4531	67
9/16-12	15/32 31/64	12.00	.4688 .4844	84 69
9/16-18	1/2 33/64	13.00	.5000 .5156	82 60
5/8-11	17/32 35/64	13.50	.5313 .5469	76 63
5/8-18	9/16 37/64	14.50	.5625 .5781	82 60
3/4-10	41/64 21/32	16.50	.6406 .6563	81 69
3/4-16	11/16	17.50	.6875	72
7/8-9	49/64 25/32	18.50	.7656 .7813	73 62
7/8-14	51/64 13/16	20.50	.7969 .8125	79 62
1-8	7/8 57/64	22.50	.8750 .8906	74 64
1-12	29/32 59/64	23.50	.9063 .9219	82 68
1-14	59/64 15/16	23.50	.9219 .9375	79 62
1-1/8-7	63/64 1	25.00	.9844 1.0000	73 65
1-1/8-12	1-1/32 1-3/64	26.50	1.0313 1.0469	82 67
1-1/4-7	1-3/32 1-7/64 1-1/8	28.00	1.0938 1.1094 1.1250	81 73 64
1-1/4-12	1-5/32 1-11/64	29.50	1.1563 1.1719	81 67
1-3/8-6	1-13/64 1-7/32 1-15/64	31.00	1.2031 1.2188 1.2344	77 69 62
1-3/8-12	1-9/32 1-19/64	33.00	1.2813 1.2969	81 66
1-1/2-6	1-11/32 1-23/64	34.00	1.3438 1.3594	69 62
1-1/2-12	1-13/32 1-27/64	36.00	1.4063 1.4219	80 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	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	19/64	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

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 2.50	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.