

Tap & Drill Chart

| Tap/Drill Sizes | | | | | |
|-----------------|----------------|------------------|----------|----------------|------------------|
| Tap Size | Tap Drill Size | Prob % of Thread | Tap Size | Tap Drill Size | Prob % of Thread |
| 0-80 | 56 | 74 | 3/8-24 | Q | 75 |
| | 3/64" | 71 | | 8.5mm | 70 |
| 1-64 | 54 | 81 | 7/16-14 | U | 75 |
| | 53 | 59 | 7/16-20 | W | 75 |
| 1-72 | 1.50mm | 68 | | 25/64" | 68 |
| | 53 | 67 | 1/2-13 | 27/64" | 75 |
| 2-56 | 51 | 74 | | 11.0mm | 64 |
| | 50 | 62 | 1/2-20 | 11.4mm | 74 |
| 2-64 | 50 | 70 | | 29/64" | 67 |
| | 49 | 56 | 9/16-12 | 15/32" | 84 |
| 3-48 | 48 | 78 | | 31/64" | 69 |
| | 5/64" | 70 | 9/16-18 | 1/2" | 82 |
| 3-56 | 46 | 69 | | 33/64" | 60 |
| | 45 | 56 5 | 5/8-11 | 17/32" | 76 |
| 4-40 | 44 | 74 | | 35/64" | 63 |
| | 43 | 65 | 5/8-18 | 9/16" | 82 |
| 4-48 | 2.35mm | 72 | | 37/64 " | 60 |
| | 42 | 61 | 11/16-11 | 19/32" | 75 |
| 5-40 | 39 | 71 | 11/16-16 | 5/8" | 75 |
| | 38 | 65 | 3/4-10 | 41/64" | 81 |
| 5-44 | 38 | 72 | | 21/32" | 69 |
| | 37 | 63 | 3/4-16 | 11/16" | 72 |
| 6-32 | 36 | 72 | | 17.5mm | 70 |
| | 7/64" | 64 | 7/8-9 | 49/64" | 73 |
| 6-40 | 33 | 69 | | 25/32" | 62 |
| | 32 | 60 | 7/8-14 | 51/64" | 79 |
| 8-32 | 3.40mm | 74 | | 13/16" | 62 |
| | 29 | 62 | 1-8 | 7/8" | 74 |
| 8-36 | 29 | 70 | | 57/64" | 64 |
| | 9/64" | 60 | 1-12 | 29/32" | 82 |
| 10-24 | 3.70mm | 76 | | 59/64" | 68 |
| | 25 | 69 | 1-14 | 59/64" | 79 |
| 10-32 | 5/32" | 75 | | 15/16" | 62 |
| | 21 | 68 | 1-1/8-7 | 63/64" | 73 |
| 12-24 | 11/64" | 75 | | 1" | 65 |
| | 17 | 73 | 1-1/8-12 | 1-1/32" | 82 |
| 12-28 | 16 | 77 | | 1-3/64" | 67 |
| | 15 | 70 | 1-1/4-7 | 1-3/32" | 81 |
| 1/4-20 | 9 | 77 | | 1-7/64" | 73 |
| | 7 | 70 | | 1-1/8" | 64 |
| 1/4-28 | 13/64" | 66 | 1-1/4-12 | 1-5/32" | 81 |
| | 3 | 70 | | 1-11/64" | 67 |
| 5/16-18 | 5.50mm | 67 | 1-3/8-6 | 1-13/64" | 81 |
| | F | 72 | | 1-19/64" | 66 |
| 5/16-24 | G | 66 | 1-3/8-12 | 1-9/32" | 81 |
| | 6.80mm | 78 | | 1-19/64" | 66 |
| | I | 70 | 1-1/2-6 | 1-11/32" | 69 |
| 3/8-16 | 5/16" | 74 | | 1-23/64" | 62 |
| | O | 69 | 1-1/2-12 | 1-13/32" | 80 |
| | | | | 1-27/64" | 66 |

| Tap/Drill Sizes | | | | | |
|-----------------|----------------|------------------|----------|----------------|------------------|
| Tap Size | Tap Drill Size | Prob % of Thread | Tap Size | Tap Drill Size | Prob % of Thread |
| 1.6x.35 | 1.25mm | 69 | 9.0x1.25 | 7.75mm | 73 |
| 1.8x.35 | 1.45mm | 69 | 10x1.5 | 8.50mm | 71 |
| 2.0x.4 | 1.60mm | 69 | | Q | 75 |
| | 52 | 66 | 10x1.25 | 8.70mm | 73 |
| 2.2x.45 | 1.75mm | 70 | | 11/32" | 71 |
| 2.5x.45 | 2.05mm | 69 | 11x1.5 | 9.50mm | 70 |
| | 46 | 67 | | 3/8" | 71 |
| 3.0x2.5 | 2.50mm | 68 | 12x1.75 | 10.20mm | 74 |
| | 40 | 70 | | Y | 71 |
| 3.5x6 | 2.90mm | 68 | 12x1.25 | 10.80mm | 67 |
| | 33 | 72 | | 27/64" | 72 |
| 4.0x.7 | 3.30mm | 69 | 14x2.0 | 12.00mm | 72 |
| | 30 | 73 | | 15/32" | 76 |
| 4.5x.75 | 3.70mm | 74 | 14x1.5 | 12.50mm | 71 |
| | 26 | 70 | 16x2.0 | 14.00mm | 72 |
| 5.0x.8 | 4.20mm | 69 | | 35/64" | 76 |
| | 19 | 68 | 16x1.5 | 14.50mm | 71 |
| 5.5x.9 | 4.60mm | 68 | 18x2.5 | 15.50mm | 73 |
| | 14 | 67 | | 39/64" | 74 |
| 6.0x.75 | 5.30mm | 74 | 18x1.5 | 16.50mm | 70 |
| | 4 | 73 | 20x2.5 | 17.50mm | 73 |
| 6.0x1.0 | 5.00mm | 70 | | 11/16" | 74 |
| | 9 | 71 | 22x2.5 | 19.50mm | 73 |
| 7.0x.75 | 6.30mm | 74 | | 49/64" | 75 |
| | D | 72 | 24x3.0 | 21.00mm | 73 |
| 7.0x1.0 | 6.00mm | 70 | | 53/64" | 72 |
| | 15/64" | 73 | 27x3.0 | 24.00mm | 73 |
| 8.0x1.25 | 6.70mm | 74 | | 15/16" | 78 |
| | 17/64" | 71 | 30x3.5 | 26.50mm | 74 |
| 8.0x1.0 | 7.00mm | 69 | | 1-3/64" | 73 |
| | J | 66 | 33x3.5 | 29.50mm | 74 |
| | | | | 1-11/64" | 72 |

| Pipe Tap Drill Sizes | | |
|----------------------|---------------|---------------|
| Tap Size | NPT Tap Drill | NPS Tap Drill |
| 1/16-27 | D | 1/4" |
| 1/8-27 | Q | 11/32" |
| 1/4-18 | 7/16" | 7/16" |
| 3/8-18 | 9/16" | 37/64" |
| 1/2-14 | 45/64" | 23/32" |
| 3/4-14 | 29/32" | 59/64" |
| 1-11-1/2 | 1-9/64" | 1-5/32" |
| 1-1/4-11-1/2 | 1-31/64" | 1-1/2" |
| 1-1/2-11-1/2 | 1-47/64" | 1-3/4" |
| 2-11-1/2 | 2-13/64" | 2-7/32" |
| 2-1/2-8 | 2-5/8" | 2-21/32" |