

TECHNICAL INFO
DRILLING & CUTTING PRODUCTS

TAP-DRILL REFERENCE CHART

Recommended Tap Drill to Use For 75% Depth of Thread.

DRILL THIS SIZE HOLE			TO TAP FOR THIS BOLT OR SCREW	
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION		
.0469"	3/64"	3/64"	0-80	NF
.0595"	No. 53	none	1-64	NC
.0595"	No. 53	1/16"	1-72	NF
.0700"	No. 50	none	2-56	NC
.0700"	No. 50	none	2-64	NF
.0785"	No. 47	5/64"	3-48	NC
.0820"	No. 45	none	3-56	NF
.0860"	No. 44	none	4-36	NS
.0890"	No. 43	3/32"	4-40	NC
.0935"	No. 42	3/32"	4-48	NF
.0984"	2.5mm	none	3mm-0.60mm	
.1015"	No. 38	none	1/8-40 NS	
.1015"	No. 38	none	5-40	NC
.1040"	No. 37	none	5-44	NF
.1100"	No. 35	7/64"	6-32	NC
.1110"	No. 34	none	6-36	NS
.1130"	No. 33	none	6-40	NF
.1200"	No. 31	none	6-48	NS
.1338"	3.4mm	none	4mm-0.70mm	
.1338"	3.4mm	none	4mm-0.75mm	
.1360"	No. 29	none	8-32 NC	
.1360"	No. 29	9/64"	8-36	NF
.1405"	No. 28	none	8-40	NS
.1470"	No. 26	none	3/16-24 NS	
.1495"	No. 25	5/32"	10-24 NC	
.1570"	No. 22	none	3/16-32 NS	
.1590"	No. 21	5/32"	10-32 NF	
.1653"	4.2mm	none	5mm-0.90mm	
.1693"	4.3mm	none	5mm-0.80mm	
.1770"	No. 16	11/64"	12-24 NC	
.1820"	No. 14	3/16"	12-28 NF	
.1850"	No. 13	none	12-32 NEF	
.1935"	No. 10	none	14-20 NS	
.2010"	No. 7	13/64"	1/4-20 NC	
.2010"	No. 7	none	14-24 NS	
.2047"	5.2mm	none	6mm-1.00mm	
.2090"	No. 4	none	1/4-24 NS	
.2130"	No. 3	7/32"	1/4-28 NF	
.2188"	7/32"	7/32"	1/4-32 NEF	
.2280"	No. 1	none	1/4-40 NS	
.2401"	6.1mm	15/64"	7mm-1.00mm	
.2570"	Ltr. F	17/64"	5/16-18 NC	
.2716"	6.9mm	17/64"	8mm-1.25mm	
.2720"	Ltr. I	none	5/16-24 NF	
.2795"	7.1mm	none	8mm-1.00mm	
.2812"	9/32"	9/32"	5/16-32 NEF	
.3110"	7.9mm	none	9mm-1.25mm	
.3125"	5/16"	5/16"	3/8-16 NC	
.3189"	8.1mm	none	9mm-1.00mm	
.3268"	8.3mm	none	9mm-0.75mm	
.3320"	Ltr. Q	21/64"	3/8-24 NF	
.3425"	8.7mm	none	10mm-1.50mm	
.3503"	8.9mm	11/32"	10mm-1.25mm	

DRILL THIS SIZE HOLE			TO TAP FOR THIS BOLT OR SCREW	
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION		
.3583"	9.1mm	none	*10mm-1.00mm	
.3680"	Ltr. U	23/64"	7/16"-14 NC	
.3818"	9.7mm	none	11mm-1.50mm	
.3906"	25/64"	25/64"	7/16-20 NF	
.4133"	10.5mm	none	12mm-1.75mm	
.4212"	10.7mm	27/64"	12mm-1.50mm	
.4219"	27/64"	27/64"	1/2-13 NC	
.4291"	10.9mm	27/64"	*12mm-1.25mm	
.4531"	29/64"	29/64"	1/2-20 NF	
.4531"	29/64"	29/64"	1/2-24 NS	
.4803"	12.2mm	none	14mm-2.00mm	
.4844"	31/64"	31/64"	9/16-12 NC	
.4999"	12.7mm	none	14mm-1.50mm	
.5039"	12.8mm	none	*14mm-1.25mm	
.5156"	33/64"	33/64"	9/16-18 NF	
.5312"	17/32"	17/32"	5/8-11 NC	
.5590"	14.2mm	35/64"	16mm-2.00mm	
.5781"	37/64"	37/64"	5/8-18 NF	
.5787"	14.7mm	none	16mm-1.50mm	
.5938"	19/32"	19/32"	11/16-11 NS	
.6220"	15.8mm	39/64"	18mm-2.50mm	
.6250"	5/8"	5/8"	11/16-16 NS	
.6562"	21/32"	21/32"	3/4-10 NC	
.6614"	16.8mm	none	*18mm-1.50mm	
.6875"	11/16"	11/16"	3/4-16 NF	
.7008"	17.8mm	11/16"	20mm-2.50mm	
.7656"	49/64"	49/64"	7/8-9 NC	
.8125"	13/16"	13/16"	7/8-14 NF	
.8228"	20.9mm	none	22mm-1.50mm	
.8281"	53/64"	53/64"	*7/8-18 NS	
.8425"	21.4mm	53/64"	24mm-3.00mm	
.8750"	7/8"	7/8"	1-8 NC	
.8779"	22.3mm	none	24mm-2.00mm	
.9219"	59/64"	59/64"	1-12 NF	
.9375"	15/16"	15/16"	1-14 NS	
.9844"	63/64"	63/64"	1-1/8 - 7 NC	
1.0469"	1-3/64"	1-3/64"	1-1/8 - 12 NF	
1.1094"	1-7/64"	1-7/64"	1-1/4 - 7 NC	
1.1719"	1-11/64"	1-11/64"	1-1/4 - 12 NF	
1.2188"	1-7/32"	1-7/32"	1-3/8 - 6 NC	
1.2969"	1-19/64"	1-19/64"	1-3/8 - 12 NF	
1.3468"	1-11/32"	1-11/32"	1-1/2 - 6 NC	
1.4219"	1-27/64"	1-27/64"	1-1/2 - 12 NF	

* Spark Plug Taps.

⊙ For All HSS & Carbon NPT Taps.

**NPT
TAP-DRILL CHART**


DRILL THIS SIZE HOLE			TO TAP FOR THIS BOLT OR SCREW
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.3390"	Ltr. R	none	1/8-27 NPT
.4375"	7/16"	7/16"	1/4-18 NPT
.5781"	37/64"	37/64"	3/8- 8 NPT
.7031"	45/64"	45/64"	1/2-14 NPT
.9219"	59/64"	59/64"	3/4-14 NPT
1.1562"	1-5/32"	1-5/32"	1 - 11-1/2 NPT
1.5000"	1-1/2"	1-1/2"	1-1/4 - 11-1/2 NPT
1.7344"	1-47/64"	1-47/64"	1-1/2 - 11-1/2 NPT
2.2188"	2-7/32"	2-7/32"	2 - 11-1/2 NPT