

Recommended tap drill sizes for approximately 75% depth of thread

Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes
97	0.0059		58	0.0420		27	0.1440		H	0.2660		17/32	0.5312	5/8-11
.15mm	0.0059		57	0.0430		3.7mm	0.1457		6.8mm	0.2677		13.5mm	0.5315	
96	0.0063		1.1mm	0.0433		26	0.1470	3/16-24NS	6.9mm	0.2717		35/64	0.5469	
.16mm	0.0063		1.15mm	0.0453		3.75mm	0.1476	m4.5x0.75	I	0.2720	5/-16-24NF	14mm	0.5512	m16x2
95	0.0067		56	0.0465		25	0.1495	#10-24	7mm	0.2756	m8x1	9/16	0.5625	
.17mm	0.0067		3/64	0.0469	#0-80	3.8mm	0.1496		J	0.2770		14.5mm	0.5709	m16x1.50
94	0.0071		1.2mm	0.0472		24	0.1520		7.1mm	0.2795		37/64	0.5781	3/8-18NPT PIPE
.18mm	0.0071		1.25mm	0.0492	m1.6x.35	3.9mm	0.1535		K	0.2810	5/16-32NS	15mm	0.5906	
93	0.0075		1.3mm	0.0512		23	0.1540		9/32	0.2812		19/32	0.5938	3/8-18NPS PIPE
.19mm	0.0075		55	0.0520		5/32	0.1562		7.2mm	0.2835		39/64	0.6094	
92	0.0079		1.35mm	0.0531		22	0.1570	3/16-32NS	7.25mm	0.2854		15.5mm	0.6102	m18x2.5
.2mm	0.0079		54	0.0550		4mm	0.1575		7.3mm	0.2874		5/8	0.6250	11/16-16NS
91	0.0083		1.4mm	0.0551		21	0.1590	#10-32	L	0.2900		16mm	0.6299	m18x2.0
.21mm	0.0083		1.45mm	0.0571	m1.8x0.35	20	0.1610		7.4mm	0.2913		41/64	0.6406	
90	0.0087		1.5mm	0.0591		4.1mm	0.1614		M	0.2950		16.5mm	0.6496	
.22mm	0.0087		53	0.0595	#1-64,72	4.2mm	0.1654	m5x0.8	7.5mm	0.2953		21/32	0.6562	3/4-10NC
89	0.0091		1.55mm	0.0610		19	0.1660		19/64	0.2969		17mm	0.6693	
.23mm	0.0091		1/16	0.0625		4.25mm	0.1673		7.6mm	0.2992		43/64	0.6719	
.24mm	0.0094		1.6mm	0.0630	m2x0.4	4.3mm	0.1693		N	0.3020		11/16	0.6875	3/4-16NF
88	0.0095		52	0.0635		18	0.1695		7.7mm	0.3031	m9x1.25	17.5mm	0.6890	m20x2.5
.25mm	0.0098		1.65mm	0.0650		11/64	0.1719		7.75mm	0.3051		45/64	0.7031	
87	0.0100		1.7mm	0.0669		17	0.1730		7.8mm	0.3071		18mm	0.7087	m20x2.0
.26mm	0.0102		51	0.0670	#2-56	4.4mm	0.1732		7.9mm	0.3110		23/32	0.7188	1/2-14NPT PIPE
86	0.0105		1.75mm	0.0689	m2.2x0.45	16	0.1770	#12-24	5/16	0.3125	3/8-16NC	18.5mm	0.7283	m20x1.5
.27mm	0.0106		50	0.0700	#2-64	4.5mm	0.1772		8mm	0.3150		47/64	0.7344	1/2-14NPS PIPE
85	0.1100		1.8mm	0.0709		15	0.1800		O	0.3160		19mm	0.7480	
.28mm	0.1100		1.85mm	0.0728		4.6mm	0.1811		8.1mm	0.3189		3/4	0.7500	
.29mm	0.0114		49	0.0730		14	0.1820	#12-28	8.2mm	0.3228		49/64	0.7656	7/8-9NC
84	0.0115		1.9mm	0.0748	m2.3x0.4	13	0.1850		P	0.3230		19.5mm	0.7677	m22x2.5
.3mm	0.0118		48	0.0760		4.7mm	0.1850		8.25mm	0.3248		25/32	0.7812	
83	0.0120		1.95mm	0.0768		4.75mm	0.1870		8.3mm	0.3268		20mm	0.7874	m22x2.0
82	0.0125		5/64	0.0781		3/16	0.1875		21/64	0.3281		51/64	0.7969	
.32mm	0.0126		47	0.0785	#3-48	4.8mm	0.1890		8.4mm	0.3307		20.5mm	0.8071	m22x1.5
81	0.0130		2mm	0.0787		12	0.1890	7-32-32NS	Q	0.3320	3/8-24NF	13/16	0.8125	7/8-14NF
.34mm	0.0134		2.05mm	0.0807	m2.5x0.45	11	0.1910		8.5mm	0.3346	m10x1.5	21mm	0.8268	m24x3
80	0.0135		46	0.0810		4.9mm	0.1929		8.6mm	0.3386		53/64	0.8281	
.35mm	0.0138		45	0.0820	#3-56	10	0.1935		R	0.3390	1/8-27NPS PIPE	27/32	0.8438	
.36mm	0.0142		2.1mm	0.0827		9	0.1960		8.7mm	0.3425		21.5mm	0.8465	
79	0.1045		2.15mm	0.0846	m2.6x0.45	5mm	0.1969	m6x1	11/32	0.3438		55/64	0.8594	
.38mm	0.0150		44	0.0860	#4-36	8	0.1990		8.75mm	0.3445	m10x1.25	22mm	0.8661	m24x2
1/64	0.0156		2.2mm	0.0866		5.1mm	0.2008		8.8mm	0.3465		7/8	0.8750	1-8NC
.4mm	0.0157		2.25mm	0.0886		7	0.2010	1/4-20	S	0.3480	1/8-27NPS PIPE	22.25mm	0.8760	
78	0.0160		43	0.0890	#4-40	13/64	0.2031		8.9mm	0.3504		22.5mm	0.8858	m24x1.50
.42mm	0.0165		2.3mm	0.0906		6	0.2040		9mm	0.3543	m10x1.00	57/64	0.8906	
.44mm	0.0173		2.35mm	0.0925		5.2mm	0.2047		T	0.3580		23mm	0.9055	
.45mm	0.0177		42	0.0935	#4-48	5	0.2055		9.1mm	0.3583		29/32	0.9062	
77	0.0180		3/32	0.0938		5.25mm	0.2067	m6x0.75	23/64	0.3594		59/64	0.9219	3/4-14NPT PIPE
.46mm	0.0181		2.4mm	0.0945		5.3mm	0.2087		9.2mm	0.3622		23.5mm	0.9252	
.48mm	0.0189		41	0.0960		4	0.2090	1/4-24	9.25mm	0.3642		15/16	0.9375	3/4-14NPS PIPE
.5mm	0.0197		2.45mm	0.0965		5.4mm	0.2126		9.3mm	0.3661		24mm	0.9449	m27x3
76	0.0200		40	0.0980		3	0.2130	1/4-28	U	0.3680	7/16-14NC	61/64	0.9531	
75	0.0210		2.5mm	0.0984	m3x0.5	5.5mm	0.2165		9.4mm	0.3701		24.5mm	0.9646	
.55mm	0.0217		39	0.0995		7/32	0.2188		9.5mm	0.3740	m11x1.50	31/32	0.9688	
74	0.0225		38	0.1015	#5-40	5.6mm	0.2205		3/8	0.3750		25mm	0.9843	m27x2
.6mm	0.0236		2.6mm	0.1024		2	0.2210		V	0.3770		63/64	0.9844	1-1/8-7NC
73	0.0240		37	0.1040	#5-44	5.7mm	0.2244		9.6mm	0.3780		1	1.0000	
72	0.0250		2.7mm	0.1063		5.75mm	0.2264		9.7mm	0.3819		25.5mm	1.0039	
.65mm	0.0256		36	0.1065	#6-32	1	0.2280		9.75mm	0.3839		1-1/64	1.0156	
71	0.0260		2.75mm	0.1083		5.8mm	0.2283		9.8mm	0.3858		26mm	1.0236	
.7mm	0.0276		7/64	0.1094		5.9mm	0.2323		W	0.3860		1-1/32	1.0312	
70	0.0280		35	0.1100		A	0.2340		9.9mm	0.3898		26.5mm	1.0433	
69	0.0292		2.8mm	0.1102		15/64	0.2344		25/64	0.3906	7/16-20	1-3/64	1.0469	1-1/8-12NF
.75mm	0.0295		34	0.1110		6mm	0.2362	m7x1	10mm	0.3937	m12x1.75	1-1/16	1.0625	
68	0.0310		33	0.1130	#6-40	B	0.2380		X	0.3970		27mm	1.0630	
1/32	0.0312		2.9mm	0.1142	m3.5x0.6	6.1mm	0.2402		Y	0.4040		1-5/64	1.0781	
.8mm	0.0315		32	0.1160		C	0.2420		13/32	0.4062		27.5mm	1.0827	
67	0.0320		3mm	0.1181		6.2mm	0.2441		Z	0.4130		1-3/32	1.0938	
66	0.0330		31	0.1200		D	0.2460	1/16-27NPT PIPE	10.5mm	0.4134	m12x1.25	28mm	1.1024	m30x2.0
.85mm	0.0335		3.1mm	0.1220		6.25mm	0.2461		27/64	0.4219	1/2-13	1-7/64	1.1094	1-1/4-7NC
65	0.0350		1/8	0.1250	5/32-32NS	6.3mm	0.2480		11mm	0.4331		28.5mm	1.1220	
.9mm	0.0354		3.2mm	0.1260		E	0.2500		7/16	0.4375	1/4-18NPT PIPE	1-1/8	1.1250	
64	0.0360		3.25mm	0.1280		1/4	0.2500	1/16-27NPT PIPE	11.5mm	0.4528		1-9/64	1.1406	
63	0.0370		30	0.1285	5/32-36NS	6.4mm	0.2520		29/64	0.4531	1/4-18NPT PIPE	29mm	1.1417	
.95mm	0.0374		3.3mm	0.1299	m4x0.7	6.5mm	0.2559		15/32	0.4688		1-5/32	1.1562	1-11/2 NPT PIPE
62	0.0380		3.4mm	0.1339		F	0.2570	5/16-18NC	12mm	0.4724	m14x2	29.5mm	1.1614	
61	0.0390		29	0.1360	#8-32	6.6mm	0.2598		31/64	0.4844	9/16-12	1-11/64	1.1719	1-1/4-12NF
1.0mm	0.0394		3.5mm	0.1378		G	0.2610		12.5mm	0.4921	m14-1.5	Formula for Obtaining Tap Drill Sizes for Cutting Tap:		
60	0.0400		28	0.1405		6.7mm	0.2638		1/2	0.5000		Major Diam. .01259 X Amt. of percentage of full thread = Drill Size		
59	0.0410		9/64	0.1406		17/64	0.2656		13mm	0.5118	m14x1.25			
1.05mm	0.0413		3.6mm	0.1417		6.75mm	0.2657	m8x1.25	33/64	0.5156		Note: Select nearest commercial stock drill		