

Auxiliary Systems Tap / Drill Chart

ANSI Standard Machinist American Screw Thread Tap / Drill Size Chart

Screw Size National Course		Screw Size National Fine	
TAP SIZE	DRILL SIZE	TAP SIZE	DRILL SIZE
#0-80	3/64"	#1-72	#53
#1-64	#53	#2-64	#50
#2-56	#51	#3-56	#46
#3-48	5/64"	#4-48	#42
#4-40	#43	#5-44	#37
#5-40	#39	#6-40	#33
#6-32	#36	#8-36	#29
#8-32	#29	#10-32	#21
#10-24	#25	#12-28	#15
#12-24	#17	1/4-28	#3
1/4-20	#7	5/16-24	I
5/16-18	F	3/8-24	Q
3/8-16	5/16	7/16-20	W
7/16-14	U	1/2-20	29/64
1/2-13	27/64	9/16-18	33/64
9/16-12	31/64	5/8-18	37/64
5/8-11	17/32	3/4-16	11/16
3/4-10	21/32	7/8-14	13/16
7/8-9	49/64	1"-12	15/16
1"-8	7/8	1-1/8-12	1-3/64
1-1/8-7	63/64	1-1/4-12	1-11/64
1-1/4-7	1-7/64	1-1/2-12	1-27/64
1-1/2-6	1-11/32	1-3/4-12	1-43/64
1-3/4-5	1-35/64	2"-12	1-59/64
2"-4-1/2	1-25/32		

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Machinist Metric Screw Thread Tap / Drill Size Chart

METRIC SCREW COARSE SIZES		METRIC SCREW FINE SIZES	
TAP SIZE	DRILL SIZE	TAP SIZE	DRILL SIZE
1mm x .25	75mm	4 mm x .35	3.6mm
1.1 x .25	0.85	4 x .5	3.5
1.2 x .25	0.95	5 x .5	4.5
1.4 x .3	1.1	6 x .5	5.5
1.6 x .35	1.25	6 x .75	5.25
1.7 x .35	1.3	7 x .75	6.25
1.8 x .35	1.45	8 x .5	7.5
2 x .4	1.6	8 x .75	7.25
2.2 x .45	1.75	8 x 1	7
2.5 x .45	2.05	9 x 1	8
3 x .5	2.5	10 x .75	9.25
3.5 x .6	2.9	10 x 1	9
4 x .7	3.3	10 x 1.25	8.8
4.5 x .75	3.7	11 x 1	10
5 x .8	4.2	12 x .75	11.25
6 x 1	5	12 x 1	11
7 x 1	6	12 x 1.5	10.5
8 x 1.25	6.8	14 x 1	13
9 x 1.25	7.8	14 x 1.25	12.8
10 x 1.5	8.5	14 x 1.5	12.5
11 x 1.5	9.5	16 x 1	15
12 x 1.75	10.2	16 x 1.5	14.5
14 x 2	12	18 x 1	17
16 x 2	14	18 x 2	16
18 x 2.5	15.5	20 x 1	19
20 x 2.5	17.5	20 x 1.5	18.5
22 x 2.5	19.5	20 x 2	18
24 x 3	21	22 x 1	21
27 x 3	24	22 x 1.5	20.5
30 x 3.5	26.5	22 x 2	20
33 x 3.5	29.5	24 x 1.5	22.5
36 x 4	32	24 x 2	22
39 x 4	35	26 x 1.5	24.5
		27 x 1.5	25.5
		27 x 2	25
		28 x 1.5	26.5
		30 x 1.5	28.5
		30 x 2	28
		33 x 2	31
		36 x 3	33
		39 x 3	36

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Machinist Pipe Thread Tap / Drill Size Chart

TAPER PIPE SIZES - NPT		STRAIGHT PIPE SIZES - NPS	
TAP SIZE	DRILL SIZE	TAP SIZE	DRILL SIZE
1/8-27	R	1/8-27	S
1/4-18	7/16	1/4-18	29/64
3/8-18	37/64	3/8-18	19/32
1/2-14	23/32	1/2-14	47/64
3/4-14	59/64	3/4-14	15/16
1"-11-1/2	1-5/32	1"-11-1/2	1-3/16
1-1/4-11-1/2	1-1/2	1-1/4-11-1/2	1-33/64
1-1/2-11-1/2	1-47/64	1-1/2-11-1/2	1-3/4
2"-11-1/2	2-7/32	2"-11-1/2	2-7/32
2-1/2-8	2-5/8	2-1/2-8	2-21/32
3"-8	3-1/4	3"-8	3-9/32
3-1/2-8	3-3/4	3-1/2-8	3-25/32
4"-8	4-1/4	4"-8	4-9/32