



# Drill Tap Chart

| INCH - COARSE |            | INCH - FINE  |            | METRIC - COARSE |            | METRIC - FINE |            | PIPE - TAPER   |            | PIPE - STRAIGHT |            |
|---------------|------------|--------------|------------|-----------------|------------|---------------|------------|----------------|------------|-----------------|------------|
| Thread Pitch  | Drill Size | Thread Pitch | Drill Size | Thread Pitch    | Drill Size | Thread Pitch  | Drill Size | Thread Pitch   | Drill Size | Thread Pitch    | Drill Size |
|               | 7/8        | #0 - 80      | 3/64       | M1.6 x 0.35     | 1.25mm     |               |            | 1/8 - 27       | R          | 1/8 - 27        | S          |
| #1 - 64       | 53         | #1 - 72      | 53         | M1.8 x 0.35     | 1.45mm     |               |            | 1/4 - 18       | 7/16       | 1/4 - 18        | 29/64      |
| #2 - 56       | 50         | #2 - 64      | 50         | M2 x 0.40       | 1.60mm     |               |            | 3/8 - 18       | 37/64      | 3/8 - 18        | 19/32      |
| #3 - 48       | 47         | #3 - 56      | 46         | M2.2 x 0.45     | 1.75mm     |               |            | 1/2 - 14       | 23/32      | 1/2 - 14        | 47/64      |
| #4 - 40       | 43         | #4 - 48      | 42         | M2.5 x .045     | 2.05mm     |               |            | 3/4 - 14       | 59/64      | 3/4 - 14        | 15/16      |
| #5 - 40       | 38         | #5 - 44      | 37         | M3.0 x 0.50     | 2.50mm     |               |            | 1 - 11-1/2     | 1-5/32     | 1 - 11-1/2      | 1-3/16     |
| #6 - 32       | 36         | #6 - 40      | 33         | M3.5 x 0.60     | 2.90mm     |               |            | 1-1/4 - 11-1/2 | 1-1/2      | 1-1/4 - 11-1/2  | 1-33/64    |
| #8 - 32       | 29         | #8 - 36      | 29         | M4.0 x 0.70     | 3.30mm     |               |            | 1-1/2 - 11-1/2 | 1-47/64    | 1-1/2 - 11-1/2  | 1-3/4      |
| #10 - 24      | 26         | #10 - 32     | 21         | M4.5 x 0.75     | 3.70mm     |               |            | 2 - 11-1/2     | 2-7/32     | 2 - 11-1/2      | 2-7/32     |
| #12 - 24      | 16         | #12 - 28     | 15         | M5.0 x 0.80     | 4.20mm     |               |            | 2-1/2 - 8      | 2-3/8      | 2-1/2 - 8       | 2-21/32    |
| 1/4 - 20      | 7          | 1/4 - 28     | 3          | M6.0 x 1.00     | 5.00mm     | M6 x 0.75     | 5.25mm     | 3 - 8          | 3-1/4      | 3 - 8           | 3-9/32     |
| 5/16 - 18     | F          | 5/16 - 24    | I          | M7 x 1.00       | 6.00mm     | M7 x 0.75     | 6.25mm     | 3-1/2 - 8      | 3-3/4      | 3-1/2 - 8       | 3-25/32    |
| 3/8 - 16      | 5/16       | 3/8 - 24     | Q          | M8 x 1.25       | 6.70mm     | M8 x 1.00     | 7.00mm     | 4 - 8          | 4-1/4      | 4 - 8           | 4-9/32     |
| 7/16 - 14     | U          | 7/16 - 20    | 25/64      | M10 x 1.50      | 8.50mm     | M10 x 1.25    | 8.70mm     |                |            |                 |            |
| 1/2 - 13      | 27/64      | 1/2 - 20     | 29/64      | M12 x 1.75      | 10.20mm    | M12 x 1.25    | 10.80mm    |                |            |                 |            |
| 9/16 - 12     | 31/64      | 9/16 - 18    | 33/64      | M14 x 2.00      | 12.00mm    | M14 x 1.50    | 12.50mm    |                |            |                 |            |
| 5/8 - 11      | 17/64      | 5/8 - 18     | 37/64      | M16 x 2.00      | 14.00mm    | M16 x 1.50    | 14.50mm    |                |            |                 |            |
| 3/4 - 10      | 21/64      | 3/4 - 16     | 11/16      | M18 x 2.50      | 15.50mm    | M18 x 1.50    | 16.50mm    |                |            |                 |            |
| 7/8 - 9       | 49/64      | 7/8 - 14     | 13/16      | M20 x 2.50      | 17.50mm    | M20 x 1.50    | 18.50mm    |                |            |                 |            |
| 1 - 8         | 7/8        | 1 - 14       | 59/64      | M22 x 2.50      | 19.50mm    | M22 x 1.50    | 20.50mm    |                |            |                 |            |
| 1-1/8 - 7     | 63/64      | 1-1/8 - 12   | 1-3/64     | M24 x 3.00      | 21.00mm    | M24 x 2.00    | 22.00mm    |                |            |                 |            |
| 1-1/4 - 7     | 1-7/64     | 1-1/4 - 12   | 1-11/64    | M27 x 3.00      | 24.00mm    | M27 x 2.00    | 25.00mm    |                |            |                 |            |
| 1-3/8 - 6     | 1-7/32     | 1-3/8 - 12   | 1-19/64    | M30 x 3.50      | 26.50mm    | M30 x 2.00    | 28.00mm    |                |            |                 |            |
| 1-1/2 - 6     | 1-11/32    | 1-1/2 - 12   | 1-27/64    | M33 x 3.50      | 29.50mm    | M33 x 2.00    | 31.00mm    |                |            |                 |            |
|               |            |              |            | M36 x 4.00      | 32.00mm    | M36 x 3.00    | 33.00mm    |                |            |                 |            |
|               |            |              |            | M39 x 4.00      | 35.00mm    | M39 x 3.00    | 36.00mm    |                |            |                 |            |