

## TAP-DRILL CHART

Recommended tap drill to use for 75% depth of thread

DECIMAL INCHES		SIZES		DECIMAL INCHES		SIZES		DECIMAL INCHES		SIZES	
0135	80	1299	3.30mm	3160	0						
0138	35mm	1339	3.40mm	3189	8.10mm						
0145	79	1360	29	3228	8.10mm						
0156	1/64	1378	3.50mm	3230	P						
0157	40mm	1405	28	3248	8.25mm						
0160	78	1406	9/64	3268	8.30mm						
0177	45mm	1417	3.60mm	3281	21/64						
0180	77	1440	27	3307	8.40mm						
0197	50mm	1457	3.70mm	3320	0						
0200	76	1470	26	3346	8.50mm						
0210	75	1476	3.75mm	3386	8.60mm						
0217	55mm	1495	25	3390	R						
0225	74	1496	3.80mm	3425	8.70mm						
0236	60mm	1520	24	3438	11/32						
0240	73	1535	3.90mm	3445	8.75mm						
0250	72	1540	23	3465	8.80mm						
0256	65mm	1562	5/32	3480	S						
0260	71	1570	22	3504	8.90mm						
0276	70mm	1575	4.00mm	3543	9.00mm						
0280	70	1590	21	3580	T						
0292	69	1610	20	3583	9.10mm						
0295	75mm	1614	4.10mm	3594	23/64						
0310	68	1654	4.20mm	3622	9.20mm						
0312	1/32	1660	19	3642	9.25mm						
0315	80mm	1673	4.25mm	3661	9.30mm						
0320	67	1693	4.30mm	3680	U						
0330	66	1695	18	3701	9.40mm						
0335	85mm	1719	11/64	3740	9.50mm						
0350	65	1730	17	3750	3/8						
0354	90mm	1732	4.40mm	3770	V						
0360	64	1770	16	3780	9.60mm						
0370	63	1772	4.50mm	3819	9.70mm						
0374	95mm	1800	15	3839	9.75mm						
0380	62	1811	4.60mm	3858	9.80mm						
0390	61	1820	14	3860	W						
0394	1.00mm	1850	13	3898	9.90mm						
0400	60	1850	4.70mm	3906	25/64						
0410	59	1870	4.75mm	3937	10.00mm						
0413	1.05mm	1875	3/16	3970	X						
0420	58	1890	12	4016	10.20mm						
0430	57	1890	4.80mm	4040	Y						
0433	1.10mm	1910	11	4062	13/32						
0453	1.15mm	1929	4.90mm	4130	Z						
0465	56	1935	10	4134	10.50mm						
0469	3/64	1960	9	4219	27/64						
0472	1.20mm	1969	5.00mm	4232	10.75mm						
0492	1.25mm	1990	8	4331	11.00mm						
0512	1.30mm	2008	5.10mm	4375	7/16						
0520	55	2010	7	4528	11.50mm						
0531	1.35mm	2031	13/64	4531	29/64						
0550	54	2040	6	4688	15/32						
0551	1.40mm	2047	5.20mm	4724	12.00mm						
0571	1.45mm	2055	5	4844	31/64						
0591	1.50mm	2067	5.25mm	4921	12.50mm						
0595	53	2087	5.30mm	5000	1/2						
0610	1.55mm	2090	4	5118	13.00mm						
0625	1/16	2126	5.40mm	5156	33/64						
0630	1.60mm	2130	3	5312	17/32						
0635	52	2165	5.50mm	5315	13.50mm						
0650	1.65mm	2188	7/32	5469	35/64						
0669	1.70mm	2205	5.60mm	5512	14.00mm						
0670	51	2210	2	5625	9/16						
0689	1.75mm	2244	5.70mm	5709	14.50mm						
0700	50	2264	5.75mm	5781	37/64						
0709	1.80mm	2280	1	5906	15.00mm						
0728	1.85mm	2283	5.80mm	5938	19/32						
0730	49	2323	5.90mm	6094	39/64						
0748	1.90mm	2340	A	6102	15.50mm						
0760	48	2344	15/64	6250	5/8						
0768	1.95mm	2362	6.00mm	6299	16.00mm						
0781	5/64	2380	B	6406	41/64						
0785	47	2402	6.10mm	6496	16.50mm						
0787	2.00mm	2420	C	6562	21/32						
0807	2.05mm	2441	6.20mm	6693	17.00mm						
0810	46	2460	D	6719	43/64						
0820	45	2461	6.25mm	6875	11/16						
0827	2.10mm	2480	6.30mm	6890	17.50mm						
0846	2.15mm	2500	E	7031	45/64						
0860	44	2500	1/4	7087	18.00mm						
0866	2.20mm	2520	6.40mm	7188	23/32						
0886	22.5mm	2559	6.50mm	7283	18.50mm						
0890	43	2570	F	7344	47/64						
0906	2.30mm	2598	6.60mm	7480	19.00mm						
0925	2.35mm	2610	G	7500	3/4						
0935	42	2638	6.70mm	7656	49/64						
0938	3.32	2656	17/64	7677	19.50mm						
0945	2.40mm	2657	6.76mm	7812	25/32						
0960	41	2660	H	7874	20.00mm						
0965	2.45mm	2677	6.80mm	7969	51/64						
0980	40	2717	6.90mm	8071	20.50mm						
0984	2.50mm	2720	I	8125	13/16						
0995	39	2756	7.00mm	8268	21.00mm						
1015	38	2770	J	8281	53/64						
1024	2.60mm	2795	7.10mm	8438	27/32						
1040	37	2810	K	8465	21.50mm						
1063	2.70mm	2812	9/32	8594	55/64						
1065	36	2835	7.20mm	8661	22.00mm						
1083	2.75mm	2854	7.25mm	8750	7/8						
1094	7/64	2874	7.30mm	8858	22.50mm						
1100	35	2900	L	8906	57/64						
1102	2.80mm	2913	7.40mm	9055	23.00mm						
1110	34	2950	M	9062	29/32						
1130	33	2953	7.50mm	9219	59/64						
1142	2.90mm	2969	19/64	9252	23.50mm						
1160	32	2992	7.60mm	9375	15/16						
1181	3.00mm	3020	N	9449	24.00mm						
1200	31	3031	7.70mm	9531	61/64						
1220	3.10mm	3051	7.75mm	9646	24.50mm						
1250	1/8	3071	7.80mm	9688	31/32						
1260	3.20mm	3110	7.90mm	9843	25.00mm						
1280	3.25mm	3125	5/16	9844	63/64						
1285	30	3150	8.00mm	1.0000	25.00mm						

  

DRILL THIS SIZE HOLE			TO TAP FOR THIS	DRILL THIS SIZE HOLE			TO TAP FOR THIS
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	SIZE BOLT OR SCREW	DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	SIZE BOLT OR SCREW
.0469"	3/64"	3/64"	0-80 NF	.3583"	9.1mm	none	*10mm-1.00mm
.0595	No. 53	none	1-64-NC	.3680	Ltr. U	23/64"	7/16-14 NC
.0595	No. 53	1/16	1-72-NF	.3818	9.7mm	none	11mm-1.50mm
.0700	No. 50	none	2-56-NC	.3906	25/64"	25/64	7/16-20 NF
.0700	No. 50	none	2-64 NF	.4133	10.5mm	none	12mm-1.75mm
.0785	No. 47	5/64	3-48 NC	.4212	10.7mm	27/64	12mm-1.50mm
.0820	No. 45	none	3-56 NF	.4219	27/64"	27/64	1/2-13 NC
.0860	No. 44	none	4-36 NS	.4291	10.9mm	27/64	*12mm-1.25mm
.0890	No. 43	3/32	4-40 NC	.4531	29/64"	29/64	1/2-20 NF
.0935	No. 42	3/32	4-48 NF	.4531	29/64"	29/64	1/2-24 NS
.0984	2.5mm	none	3mm-0.60mm	.4803	12.2mm	none	14mm-2.00mm
.1015	No. 38	none	1/8-40 NS	.4844	31/64"	31/64	9/16-12 NC
.1015	No. 38	none	5-40 NC	.4999	12.7mm	none	14mm-1.50mm
.1040	No. 37	none	5-44 NF	.5039	12.8mm	none	*14mm-1.25mm
.1100	No. 35	7/64	6-32 NC	.5156	33/64"	33/64	9/16-18 NF
.1110	No. 34	none	6-36 NS	.5312	17/32"	17/32	5/8-11 NC
.1130	No. 33	none	6-40 NF	.5590	14.2mm	35/64	16mm-2.00mm
.1200	No. 31	none	6-48 NS	.5781	37/64"	37/64	5/8-18 NF
.1338	3.4mm	none	4mm-0.70mm	.5787	14.7mm	none	16mm-1.50mm
.1338	3.4mm	none	4mm-0.75mm	.5938	19/32"	19/32	11/16-11 NS
.1360	No. 29	none	8-32 NC	.6220	15.8mm	39/64	18mm-2.50mm
.1360	No. 29	9/64	8-36 NF	.6250	5/8"	5/8	11/16-16 NS
.1405	No. 28	none	8-40 NS	.6562	21/32"	21/32	3/4-10 NC
.1470	No. 26	none	3/16-24 NS	.6614	1		