

DRILL TAP CHARTS



Tap Size Pitch Form Tap Drill Size Alt. Tap Size

I.S.O. Metric Fine

3	0.35mm	2.65mm	37
4	0.35mm	3.65mm	27
4	0.50mm	3.50mm	29
4.5	0.45mm	4.05mm	21
5	0.50mm	4.50mm	16
5	0.70mm	4.30mm	18
5	0.75mm	4.25mm	18
5.5	0.50mm	5.00mm	9
6	0.50mm	5.50mm	7/32
6	0.75mm	5.25mm	5
7	0.75mm	6.25mm	D
8	0.50mm	7.50mm	M
8	1.00mm	7.00mm	J
9	0.50mm	8.50mm	Q
9	1.00mm	8.00mm	O
10	0.50mm	9.50mm	3/8
10	0.75mm	9.25mm	U
10	1.00mm	9.00mm	T
10	1.25mm	8.75mm	11/32
11	1.00mm	10.00mm	X
12	1.00mm	11.00mm	7/16
12	1.25mm	10.75mm	27/64
12	1.50mm	10.50mm	Z
13	1.50mm	11.50mm	29/64
13	1.75mm	11.25mm	7/16
14	1.25mm	12.75mm	1/2
14	1.50mm	12.50mm	31/64
15	1.50mm	13.50mm	17/32
16	1.00mm	15.00mm	19/32
16	1.25mm	14.75mm	37/64
16	1.50mm	14.50mm	9/16
18	1.00mm	17.00mm	43/64
18	1.25mm	16.75mm	21/32
18	1.50mm	16.50mm	41/64
18	2.00mm	16.00mm	5/8
20	1.00mm	19.00mm	3/4
20	1.50mm	18.50mm	47/64
20	2.00mm	18.00mm	45/64
22	1.00mm	21.00mm	53/64
22	1.50mm	20.50mm	13/16
22	2.00mm	20.00mm	25/32
24	1.00mm	23.00mm	29/32
24	1.50mm	22.50mm	7/8
24	2.00mm	22.00mm	55/64
24	2.50mm	21.50mm	57/32

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Straight Pipe Taps NPS

1/8	27NPS	S	8.80
1/4	18NPS	29/64	11.50
3/8	18NPS	19/32	15.00
1/2	14NPS	47/64	18.50
3/4	14NPS	15/16	23.75
1	11-1/2NPS	1 3/16	30.25
1 1/4	11-1/2NPS	1 33/64	38.50
1 1/2	11-1/2NPS	1 3/4	44.50
2	11-1/2NPS	2 7/32	56.00

Taper Pipe Taps NPT

1/16	27NPT	D	6.30
1/8	27NPT	R	8.70
1/4	18NPT	7/16	11.10
3/8	18NPT	37/64	14.50
1/2	14NPT	23/32	18.00
3/4	14NPT	59/64	23.25
1	11-1/2NPT	1 5/32	29.00
1 1/4	11-1/2NPT	1 1/2	38.00
1 1/2	11-1/2NPT	1 47/64	44.00
2	11-1/2NPT	2 7/32	56.00
2 1/2	8NPT	2 5/8	67.00
3	8NPT	3 1/4	82.50

I.S.O. Metric Coarse

1.6	0.35mm	1.25mm	3/64
1.7	0.35mm	1.35mm	55
1.8	0.35mm	1.45mm	54
2	0.40mm	1.60mm	1/16
2.2	0.45mm	1.75mm	50
2.3	0.40mm	1.90mm	49
2.5	0.45mm	2.05mm	46
2.6	0.45mm	2.15mm	44
3	0.50mm	2.50mm	40
3.5	0.60mm	2.90mm	33
4	0.70mm	3.30mm	30
4.5	0.75mm	3.70mm	27
5	0.80mm	4.20mm	19
5.5	0.90mm	4.60mm	15
6	1.00mm	5.00mm	9
7	1.00mm	6.00mm	15/64
8	1.25mm	6.80mm	H
9	1.25mm	7.80mm	5/16
10	1.50mm	8.50mm	Q
11	1.50mm	9.50mm	3/8
12	1.75mm	10.20mm	Y
14	2.00mm	12.00mm	15/32
16	2.00mm	14.00mm	35/64
18	2.50mm	15.50mm	39/64
20	2.50mm	17.50mm	11/16
22	2.50mm	19.50mm	49/64
24	3.00mm	21.00mm	53/64
27	3.00mm	24.00mm	61/64
30	3.50mm	26.50mm	1 3/64
33	3.50mm	29.50mm	1 5/32
36	4.00mm	32.00mm	1 1/4
39	4.00mm	35.00mm	1 3/8

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Unified Taps

0	80(U)NF	3/64	1.25
1	64(U)NF	53	1.55
	72(U)NF	53	1.55
2	56(U)NC	50	1.85
	64(U)NF	50	1.90
3	48(U)NC	47	2.10
	56(U)NF	45	2.15
4	40(U)NC	43	2.35
	48(U)NF	42	2.40
5	40(U)NC	38	2.65
	44(U)NF	37	2.70
6	32(U)NC	36	2.85
	40(U)NF	33	2.95
8	32(U)NC	29	3.50
	36(U)NF	29	3.50
10	24(U)NC	25	3.90
	32(U)NF	21	4.10
12	(U)NC	16	4.50
	28(U)NF	14	4.70
1/4	20(U)NC	7	5.10
	28(U)NF	3	5.50
5/16	18(U)NC	F	6.60
	24(U)NF	1	6.90
3/8	16(U)NC	5/16	8.00
	24(U)NF	Q	8.50
7/16	14(U)NC	U	9.40
	20(U)NF	25/64	9.90
1/2	13(U)NC	27/64	10.80
	20(U)NF	29/64	11.50
9/16	12(U)NC	31/64	12.20
	18(U)NF	33/64	12.90
5/8	11(U)NC	17/32	13.50
	18(U)NF	37/64	14.50
3/4	10(U)NC	21/32	16.50
	16(U)NF	11/16	17.50
7/8	9(U)NC	49/64	19.50
	14(U)NF	13/16	20.40
1	8(U)NC	7/8	22.25
1	12(U)NF	59/64	23.25
	14(U)NF	15/16	23.50
1 1/8	7(U)NC	63/64	25.00
	12(U)NF	1 3/64	26.50
1 1/4	7(U)NC	1 7/64	28.00
	12(U)NF	1 11/64	29.50
1 3/8	6(U)NC	1 7/32	30.75
	12(U)NF	1 19/64	32.75
1 1/2	6(U)NC	1 11/32	34.00
	12(U)NF	1 27/64	36.00
1 3/4	5(U)NC	1 9/16	39.50
2	4 1/2(U)NC	1 25/32	45.00

ENGLISH / METRIC CONVERSION TABLES

The principal units are the meter for length, the liter for capacity and the gram for weight. The following prefixes are used for sub-divisions and multiples: milli = 1/1000; centi = 1/100; deci = 1/10; deca = 10; hecto = 100; kilo = 1000.

Measures of Length

10 millimeters (mm)	= 1 centimeter (cm)
10 centimeters	= 1 decimeter (dm)
10 decimeters	= 1 meter (m)
1000 meters	= 1 kilometer (km)

Measures of Weight

10 milligrams (mg)	= 1 centigram (cg)
10 centigrams	= 1 decigram (dg)
10 decigrams	= 1 gram (g)
10 grams	= 1 decagram (Dg)
10 decagrams	= 1 hectogram (Hg)
10 hectograms	= 1 kilogram (Kg)
1000 kilograms	= 1 (Metric) ton (T)

Surveyor's Square Measure

100 square Meters (m ²)	= 1 acre (ar)
100 acres	= 1 hectare (har)
100 hectares	= 1 sq. kilometer (Km. ²)

Square Measure

100 sq. millimeters (mm ²)	= 1 sq. centimeter (cm ²)
100 sq. centimeters	= 1 sq. decimeter (dm ²)
100 sq. decimeters	= 1 sq. meter (m ²)

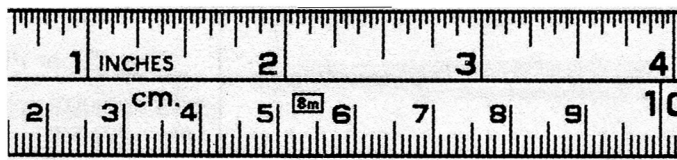
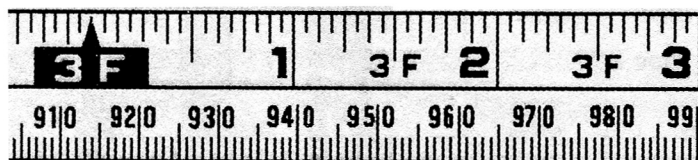
Cubic Measure

1000 cu. millimeters (mm ³)	= 1 cu. centimeter (cm ³)
1000 cu. centimeters	= 1 cu. decimeter (dm ³)
1000 cu. decimeters	= 1 cu. meter (m ³)

Dry & Liquid Measure

10 milliliters (ml)	= 1 centiliter (cl)
10 centiliters	= 1 deciliter (dl)
10 deciliters	= 1 liter (l)
100 liters	= 1 hectoliter (Hl)

1 liter = 1 cubic decimeter = The volume of 1 kilogram of pure water at a temperature of 39.2 degrees F.



TO CHANGE:

Millimeters
 Centimeters
 Meters
 Meters
 Kilometers
 Square Centimeters
 Square Meters
 Cubic Centimeters
 Cubic Meters
 Grams
 Kilograms
 Kilograms / Square Centimeter

Inches
 Inches
 Inches
 Feet
 Miles
 Square Inches
 Square Feet
 Cubic Inches
 Cubic Feet
 Ounces
 Pounds
 Pounds / Square Inch

Tons

INTO:

Inches
 Inches
 Inches
 Feet
 Miles
 Square Inches
 Square Feet
 Cubic Inches
 Cubic Feet
 Ounces
 Pounds
 Pounds / Square Inch

Millimeters
 Centimeters
 Meters
 Meters
 Kilometers
 Square Centimeters
 Square Meters
 Cubic Centimeters
 Cubic Meters
 Grams
 Kilograms
 Kilograms / Square Centimeters

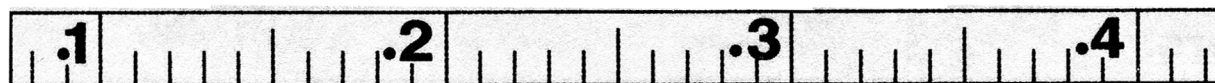
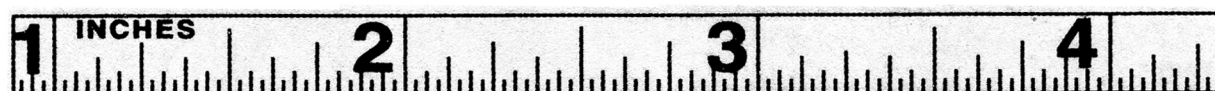
Kilograms

MULTIPLY BY:

0.03937
 0.3937
 39.37
 3.281
 0.62137
 0.1550
 10.7649
 0.061
 35.314
 0.03527
 2.2046
 14.223

25.4
 2.54
 0.0254
 0.3048
 1.609347
 6.452
 0.0929
 16.3872
 0.02832
 28.3495
 0.45359
 0.0703

907.185

FRACTIONS / DECIMALS / MILLIMETERS


Inch Fraction	Decimal	mm	Inch Fraction	Decimal	mm
1/64	.0156	.0396	33/64	.5156	13.096
1/32	.0312	.0793	17/32	.5312	13.493
3/64	.0468	1.190	35/64	.5468	13.890
1/16	.0625	1.587	9/16	.5625	14.287
5/64	.0781	1.984	37/64	.5781	14.684
3/32	.0937	2.381	19/32	.2937	15.081
7/64	.1093	2.778	39/64	.6093	15.478
1/8	.1250	3.175	5/8	.6250	15.875
9/64	.1406	3.571	41/64	.6406	16.271
5/32	.1562	3.968	21/32	.6562	16.668
11/64	.1718	4.365	43/64	.6718	17.065
3/16	.1875	4.762	11/16	.6875	17.462
13/64	.2031	5.129	45/64	.7031	17.859
7/32	.2187	5.556	23/32	.7187	18.256
15/64	.2343	5.953	47/64	.7343	18.653
1/4	.2500	6.350	3/4	.7500	19.050
17/64	.2656	6.746	49/64	.7656	19.446
9/32	.2812	7.143	25/32	.7812	19.843
19/64	.2968	7.540	51/64	.7968	20.240
5/16	.3125	7.937	13/16	.8125	20.637
21/64	.3281	8.334	53/64	.8281	21.034
11/32	.3437	8.731	27/32	.8437	21.431
23/64	.3593	9.128	55/64	.8593	21.828
3/8	.3750	9.52	7/8	.8750	22.225
25/64	.3906	9.921	57/64	.8906	22.621
13/32	.4062	10.318	29/32	.9062	23.018
27/64	.4218	10.715	59/64	.9218	23.415
7/16	.4375	11.112	15/16	.9375	23.812
29/64	.4531	11.509	61/64	.9531	24.209
15/32	.4687	11.906	31/32	.9687	24.606
31/64	.4843	12.303	63/64	.9843	25.003
1/2	.5000	12.700	1	1.000	25.400