

Tap Drill Size Chart

Thread Cutting

Tap Size	Threads per Inch	65% thread												70% thread												75% thread												Pitch
		METRIC				INCH				METRIC				INCH				METRIC				INCH				M	MF											
		smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical																			
#0	80	1.20	1.26	1.30	0.0472	0.0494	0.0512	1.20	1.24	1.30	0.0472	0.0496	0.0512	1.20	1.21	1.30	0.0472	0.0478	0.0512	M1.6	0.35	1.20	1.30	1.30	0.0512	0.0512	0.0512	1.20	1.26	1.30	0.0472	0.0496	0.0512					

Thread Forming

Tap Size	Threads per Inch	65% thread												70% thread												75% thread											
		METRIC				INCH				METRIC				INCH				METRIC				INCH															
		smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical	smallest drill theoretical	largest drill theoretical						
#0	80	1.20	1.32	1.38	1.40	0.0520	0.0545	0.0550	1.32	1.38	1.40	0.0520	0.0540	0.0550	1.32	1.36	1.40	0.0520	0.0535	0.0550	M1.6	0.35	1.40	1.40	0.0550	0.0550	0.0550	1.40	1.46	1.50	0.0550	0.0575	0.0591				



Pipe Taps

Pipe Tap Size	NPT and NPTF		NPSM	NPS	NPSF
	without reamer	with reamer			
1/16-27	0.2420	0.2344	-	0.2500	0.2460
1/8-27	0.3320	0.3281	0.3580	0.3320	0.3390
1/4-18	0.4375	0.4219	0.4688	0.4375	0.4375
3/8-18	0.5625	0.5625	0.6030	0.5781	0.5781
1/2-14	0.7031	0.6875	0.7480	0.7087	0.7087
3/4-14	0.9063	0.8906	0.9531	0.9219	0.9219
1-11 1/2	1.1406	1.1250	1.2031	1.1563	1.1563
1 1/4-11 1/2	1.4844	1.4688	1.5460	1.5000	1.5000
1 1/2-11 1/2	1.7188	1.7031	1.7813	1.7344	1.7344
2-11 1/2	2.1875	2.1719	2.2500	2.2031	2.2031

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