

# METRIC TAP DRILL SIZES AND PERCENTAGES OF THREADS

TAP	TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD	TAP	TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD	TAP	TAP DRILL	DECIM. EQUIV.	THEOR. % OF THREAD
M1.6x.35	1.25mm	.0492	77		I	.2720	67	M22x1.5	20.5mm	.8071	77
	1.3mm	.0512	66	M8x1	7mm	.2756	77		13/16	.8125	70
	#55	.0520	61		J	.2770	74	M24x3	21mm	.8268	77
M1.8x.35	1.45mm	.0571	77	M10x1.5	8.5mm	.3346	77		27/32	.8438	66
	1.5mm	.0591	66		R	.3390	71	M24x2	22mm	.8661	77
	#53	.0595	64	M10x1.25	8.75mm	.3445	77		7/8	.8750	68
M2x.4	1.6mm	.0630	77		S	.3480	71	M27x3	24mm	.9449	77
	#52	.0635	74	M12x1.75	13/32	.4062	74		61/64	.9531	72
M2.2x.45	1.75mm	.0689	77		Z	.4130	66	M27x2	25mm	.9843	77
	#50	.0700	72	M12x1.25	27/64	.4219	79		63/64	.9844	77
M2.5x.45	2.05mm	.0807	77		11mm	.4331	62	M30x3.5	26.5mm	1.0433	77
	#45	.0820	71	M14x2	12mm	.4724	77		1-1/16	1.0625	66
M3x.5	2.5mm	.0984	77		31/64	.4844	65	M30x2	28mm	1.1024	77
	#39	.0995	73	M14x1.5	12.5mm	.4921	77		1-7/64	1.1094	70
M3.5x.6	2.9mm	.1142	77		1/2	.5000	67	M33x3.5	29.5mm	1.1614	77
	#32	.1160	71	M16x2	14mm	.5512	77		1-11/64	1.1719	71
M4x.7	3.3mm	.1299	77		9/16	.5625	66	M33x2	31mm	1.2205	77
	3.4mm	.1339	66	M16x1.5	14.5mm	.5709	77		1-15/64	1.2344	63
	#29	.1360	60		37/64	.5781	68	M36x4	32mm	1.2598	77
M4.5x.75	3.75mm	.1476	77	M18x2.5	15.5mm	.6102	77		1-17/64	1.2656	74
	#25	.1495	72		5/8	.6250	65	M36x3	1-19/64	1.2969	78
M5x.8	4.2mm	.1654	77	M18x1.5	16.5mm	.6496	77		33mm	1.2992	77
	#18	.1695	67		21/32	.6562	68		1-5/16	1.3125	68
M6x1	5mm	.1969	77	M20x2.5	17.5mm	.6890	77	M39x4	1-3/8	1.3750	78
	#8	.1990	73		45/64	.7031	66		35mm	1.3780	77
M7x1	6mm	.2362	77	M20x1.5	18.5mm	.7283	77		1-25/64	1.3906	71
	B	.2380	74		47/64	.7344	69	M39x3	36mm	1.4173	77
M8x1.25	6.75mm	.2657	77	M22x2.5	19.5mm	.7677	77		1-27/64	1.4219	74
	6.8mm	.2677	74		25/32	.7812	66				

## PIPE TAP DRILL SIZES

TAP SIZE	*NPT		*NPTF		STRAIGHT	
	TAP DRILL	DECIM. EQUIV.	TAP DRILL	DECIM. EQUIV.	TAP DRILL	DECIM. EQUIV.
1/16	D	.2460	D	.2460	1/4	.2500
1/8	Q	.3320	R	.3390	11/32	.3438
1/4	7/16	.4375	7/16	.4375	7/16	.4375
3/8	9/16	.5625	37/64	.5781	37/64	.5781
1/2	45/64	.7031	45/64	.7031	23/32	.7188
3/4	29/32	.9062	59/64	.9219	59/64	.9219
1	1-9/64	1.1406	1-5/32	1.1562	1-5/32	1.1562
1-1/4	1-31/64	1.4844	1-1/2	1.5000	1-1/2	1.5000
1-1/2	1-47/64	1.7344	1-47/64	1.7344	1-3/4	1.7500
2	2-13/64	2.2031	2-7/32	2.2188	2-7/32	2.2188
2-1/2	2-5/8	2.6250	2-41/64	2.6406	2-21/32	2.6562
3			3-17/64	3.2656		

\* For tapping without reaming.