

Tap Drill Chart (Standard 2B)

Tap Size	Cut Tap Drill	Roll Tap Drill	Minor Ø	Major Ø	Tap Size	Cut Tap Drill	Roll Tap Drill	Minor Ø	Major Ø
0-80	3/64	.0469	1.35mm	.0531	.0465/.0514	0.60			
1-72	#53	.0595	1.7mm	.0669	.0561/.0635	.073			
1-64	#53	.0595	1.65mm	.0650	.0561/.0623	.073			
2-64	#50	.070	2.0mm	.0787	.0691/.0753	.086			
2-56	#50	.070	5/64	.0781	.0667/.0737	.086			
3-48	#47	.0785	#43	.089	.0764/.0845	.099			
3-56	#45	.0820	2.3mm	.0906	.0797/.0865	.099			
4-40	#43	.0890	#39	.0995	.0849/.0939	.112			
4-48	#42	.0935	2.6mm	.1024	.0894/.0968	.112			
5-40	#38	.1015	#33	.1130	.0979/.1062	.125			
5-44	#37	.1040	2.9mm	.1142	.1004/.1079	.125			
6-32	#36	.1065	3.1mm	.1220	.1044/.1114	.138			
6-40	#33	.1130	3.2mm	.1260	.111/.119	.138			
8-36	#29	.1360	#26	.1520	.134/.142	.164			
8-32	#29	.1360	#25	.1495	.130/.139	.164			
10-24	#25	.1495	11/64	.1719	.145/.156	.190			
10-32	#21	.1590	#16	.1770	.156/.164	.190			
12-24	#16	.1770	5.0mm	.1968	.171/.181	.216			
12-28	#14	.1820	#8	.1990	.177/.186	.216			
12-32	3/16	.1875	*	*	.182/.190	.216			
14-20	#7	.2010	#1	.2280	.196/.207	.250			
14-28	#3	.2130	A	.2340	.211/.220	.250			
14-32	7/32	.2188	*	*	.216/.224	.250			
5/16-18	F	.2570	L	.2880	.252/.265	.312			
5/16-24	I	.2720	M	.2950	.267/.277	.312			
5/16-32	9/32	.2813	*	*	.279/.286	.312			
3/8-16	5/16	.3120	S	.3480	.307/.321	.375			
3/8-24	Q	.3320	T	.3580	.330/.340	.375			
3/8-32	11/32	.3438	*	*	.341/.349	.375			
7/16-14	U	.3680							
7/16-20	25/64	.3906	Z	.4130	.383/.395	.437			
7/16-28	Y	.4040	*	*	.299/.407	.437			
1/2-13	27/64	.4219	15/32	.4688	.417/.434	.500			
1/2-20	29/64	.4531	12.25mm	.4823	.446/.457	.500			
1/2-28	15/32	.4688	*	*	.461/.470	.500			
9/16-12	31/64	.4844	17/32	.5312	.472/.490	.562			
9/16-18	1/2	.500	13.5mm	.5315	.510/.525	.562			
9/16-24	33/64	.5156	*	*	.517/.527	.562			
5/8-11	17/32	.5313	14.75mm	.5807	.527/.546	.625			
5/8-18	9/16	.5625	15.25mm	.6004	.565/.578	.625			
5/8-24	37/64	.5781	*	*	.580/.590	.625			
11/16-12	39/64	.6094	*	*	.597/.615	.687			
11/16-24	41/64	.6406	*	*	.642/.652	.687			
3/4-10	21/32	.6563	45/64	.7031	.642/.663	.750			
3/4-16	11/16	.6875	23/32	.7188	.682/.696	.750			
3/4-20	45/64	.7031	*	*	.696/.707	.750			
13/16-12	47/64	.7344	*	*	.722/.740	.812			
13/16-16	3/4	.750	*	*	.745/.759	.812			
13/16-20	49/64	.7656	*	*	.758/.770	.812			
7/8-9	49/64	.7656	*	*	.755/.778	.875			
7/8-14	51/64	.7969	*	*	.798/.814	.875			
7/8-20	53/64	.8281	*	*	.821/.832	.875			
15/16-12	55/64	.8594	*	*	.847/.865	.937			
15/16-16	7/8	.8750	*	*	.870/.884	.937			
15/16-20	57/64	.8906	*	*	.883/.895	.937			
1 - 8	7/8	.8750	*	*	.865/.890	1			
1 - 12	59/64	.9219	*	*	.910/.928	1			
1 - 20	61/64	.9531	*	*	.946/.957	1			

Tap Drill Chart (Metric H6)

Tap Size	Cut Tap Drill	Roll Tap Drill	Minor Ø	Major Ø				
M1.6 x .35	1.25	.0492	1.45	.0571	1.221/1.321	.0481/.0520	1.6	.0630
M1.8 x .35	1.45	.0571	#51	.0670	1.371/1.421	.0540/.0559	1.8	.0709
M2 x .4	1.6	.0630	1.8	.0709	1.567/1.679	.0620/.0661	2.0	.0787
M2.2 x .45	1.75	.0689	2.0	.0787	1.648/1.713	.0649/.0674	2.2	.0866
M2.5 x .45	2.05	.0807	2.3	.0906	2.013/2.138	.0793/.0842	2.5	.0984
M3 x .5	2.5	.0984	7/64	.1094	2.459/2.599	.0968/.1023	3.0	.1181
M3.5 x .6	2.9	.1142	3.2	.1260	2.850/3.010	.1122/.1185	3.5	.1378
M4 x .7	3.3	.1299	3.7	.1457	3.242/3.422	.1276/.1347	4.0	.1575
M4.5 x .75	3.7	.1457	4.1	.1614	3.580/3.688	.1406/.1452	4.5	.1772
M5 x .8	4.2	.1654	#14	.182	4.134/4.334	.1628/.1706	5.0	.1969
M6 x 1.0	5.0	.1969	7/32	.2188	4.917/5.153	.1936/.2029	6.0	.2362
M7 x 1.0	6.0	.2362	F	.2570	5.773/5.917	.2273/.2330	7.0	.2756
M8 x 1.25	6.7	.2638	7.4	.2913	6.647/6.912	.2617/.2721	8.0	.3150
M8 x 1.0	7.0	.2756	19/64	.2969	6.917/7.153	.2723/.2816	8.0	.3150
M10 x 1.5	8.5	.3346	U	.3680	8.376/8.676	.3298/.3416	10.0	.3937
M10 x 1.25	8.7	.3425	9.4	.3701	8.647/8.912	.3404/.3509	10.0	.3937
M12 x 1.75	10.2	.4016	11.2	.4409	10.106/10.441	.3979/.4111	12.0	.4724
M12 x 1.25	10.8	.4252	11.5	.4528	10.647/10.912	.4192/.4296	14.0	.5512
M14 x 2.0	12.0	.4724	33/64	.5156	11.835/12.210	.4659/.4807	16.0	.6299
M16 x 2.0	14.0	.5512	19/32	.5938	13.835/14.210	.5447/.5594	18.0	.7087
M16 x 1.5	14.5	.5709	15.25	.6004	14.376/14.676	.5660/.5778	18.0	.7087
M18 x 2.5	15.5	.6102	39/64	.6094	14.933/15.394	.5879/.6061	18.0	.7087
M18 x 1.5	16.5	.6496	17.25	.6791	16.376/16.676	.6447/.6565	20.0	.7874
M20 x 2.5	17.5	.6890	18.75	.7382	17.294/17.744	.6809/.6986	20.0	.7874
M20 x 1.5	18.5	.7283	19.25	.7579	18.376/18.676	.7235/.7353	20.0	.7874
M22 x 2.5	19.5	.7677	*	*	19.294/19.744	.7596/.7773	22.0	.8661
M22 x 1.5	20.5	.8071	*	*	20.376/20.676	.8022/.8140	22.0	.8661
M24 x 3.0	21.0	.8268	*	*	20.752/21.252	.8170/.8367	24.0	.9449
M24 x 2.0	22.0	.8661	*	*	21.835/22.210	.8596/.8744	24.0	.9449
M27 x 3.0	24.0	.9449	*	*	23.752/24.252	.9351/.9548	27.0	1.0630
M27 x 2.0	25.0	.9843	*	*	24.835/25.210	.9778/.9925	27.0	1.0630
M30 x 3.5	26.5	1.0433	*	*	26.211/26.771	1.0319/1.0540	30.0	1.1811
M30 x 2.0	28.0	1.1024	*	*	27.835/28.210	1.0959/1.1106	30.0	1.1811
M33 x 3.5	29.5	1.1614	*	*	28.706/29.211	1.1302/1.1500	33.0	1.2992
M33 x 2.0	31.0	1.2205	*	*	30.835/31.210	1.2140/1.2287	33.0	1.2992
M36 x 4.0	32.0	1.2598	*	*	31.670/32.270	1.2469/1.2705	36.0	1.4173
M36 x 3.0	33.0	1.2992	*	*	31.083/31.670	1.2241/1.2469	36.0	1.4173
M39 x 4.0	35.0	1.3780	*	*	34.093/34.670	1.3422/1.3650	39.0	1.5354
M39 x 3.0	36.0	1.4173	*	*	35.319/35.752	1.3905/1.4076	39.0	1.5354

Pipe Tap Drill Chart

Nominal Pipe Tap Size	NPT & NPTF	
	w/o Reamer	w/Reamer
1/16-27	C	A
1/8-27	Q	2/64
1/4-18	7/16	21/64
3/8-18	9/16	9/16
1/2-14	45/64	11/16
3/4-14	29/32	57/64
1 - 11 1/2	1 9/64	1 1/8
1 1/4 - 11 1/2	1 31/64	1 15/32
1 1/2 - 11 1/2	2 13/32	1 45/64
2 - 11 1/2	2 3/16	2 11/64

Nominal Pipe Tap Size	NPSM	NPSC	NPSF
1/16-27	-	1/4	D
1/8-27	T	Q	R
1/4-18	15/32	7/16	7/16
3/8-18	.603	37/64	37/64
1/2-14	19.0MM	45/64	45/64
3/4-14	61/64	59/64	59/64
1 - 11 1/2	1 13/64	1 5/32	1 5/32
1 1/4 - 11 1/2	1 35/64	1 1/2	1 1/2
1 1/2 - 11 1/2	1 25/32	1 41/64	1 41/64
2 - 11 1/2	2 1/4	2 13/64	-

Italics = Metric

\* - Form Tap not available or not standard. Check with Tap Manufacturer for required Drill Size.