

Probable Percentage of Full Thread Produced in Tapped Hole Using Stock Sizes of Drill

TAP	Tap Drill	Decimal Equiv.	Theoretical % of Thread	Probable Oversize (Mean)	Hole Size	% of Thread
0-80	56	.0465	83	.0015	.0480	74
	3/64	.0469	81	.0015	.0484	71
1-64	54	.0550	89	.0015	.0565	81
	53	.0595	67	.0015	.0610	59
1-72	53	.0595	75	.0015	.0610	67
	1/16	.0625	58	.0015	.0640	50
2-56	51	.0670	82	.0017	.0687	74
	50	.0700	69	.0017	.0717	62
2-56	49	.0730	56	.0017	.0747	49
	50	.0700	79	.0017	.0717	70
2-64	49	.0730	64	.0017	.0747	56
	48	.0760	85	.0017	.0779	78
3-48	5/64	.0781	77	.0019	.0800	70
	47	.0785	76	.0019	.0804	69
3-48	46	.0810	67	.0019	.0829	60
	45	.0820	63	.0019	.0839	56
3-56	46	.0810	78	.0019	.0829	69
	45	.0820	73	.0019	.0839	65
4-40	44	.0860	56	.0019	.0879	48
	44	.0860	80	.0020	.0880	74
4-40	43	.0890	71	.0020	.0910	65
	42	.0935	57	.0020	.0955	51
4-40	3/32	.0938	56	.0020	.0958	50
	4-48	42	.0935	68	.0020	.0955
3/32		.0938	68	.0020	.0958	60
4-48	41	.0960	59	.0020	.0980	52
	5-40	40	.0980	83	.0023	.1003
39		.0995	79	.0023	.1018	71
5-40	38	.1015	72	.0023	.1038	65
	37	.1040	65	.0023	.1063	58
5-44	38	.1015	79	.0023	.1038	72
	37	.1040	71	.0023	.1063	63
6-32	36	.1065	63	.0023	.1088	55
	6-32	37	.1040	84	.0023	.1063
36		.1065	78	.0026	.1091	71
6-32	7/64	.1094	70	.0026	.1120	64
	35	.1100	69	.0026	.1126	63
6-32	34	.1110	67	.0026	.1136	60
	33	.1130	62	.0026	.1156	55
6-40	34	.1110	83	.0026	.1136	75
	33	.1130	77	.0026	.1156	69
8-32	32	.1160	68	.0026	.1186	60
	8-32	29	.1360	69	.0029	.1389
28		.1405	58	.0029	.1434	51
8-36	29	.1360	78	.0029	.1389	70
		.1405	68	.0029	.1434	57
8-36	9/64	.1406	68	.0029	.1435	57
	10-24	27	.1440	85	.0032	.1472
26		.1170	79	.0032	.1502	74
10-24	25	.1495	75	.0032	.1527	69
	24	.1520	70	.0032	.1552	64
10-24	23	.1540	67	.0032	.1572	61
	5/32	.1563	62	.0032	.1595	56
10-32	22	.1570	61	.0032	.1602	55
	5/32	.1563	83	.0032	.1595	75
10-32	22	.1570	81	.0032	.1602	73
	21	.1590	76	.0032	.1622	68
10-32	20	.1610	71	.0032	.1642	64
	19	.1660	59	.0032	.1692	51
12-24	11/64	.1719	82	.0035	.1754	75
	17	.1730	79	.0035	.1765	73
12-24	16	.1770	72	.0035	.1805	66
	15	.1800	67	.0035	.1835	60
12-28	14	.1820	63	.0035	.1855	56
	12-28	16	.1770	84	.0035	.1805
15		.1800	78	.0035	.1835	70
12-28	14	.1820	73	.0035	.1855	66
	13	.1850	67	.0035	.1885	59
1/4-20	3/16	.1875	61	.0035	.1910	54
	1/4-20	9	.1960	83	.0038	.1998
8		.1990	79	.0038	.2028	73
1/4-20	7	.2010	75	.0038	.2048	70
		.2031	72	.0038	.2069	66
1/4-20	6	.2040	71	.0038	.2078	65
	5	.2055	69	.0038	.2093	63
1/4-20	4	.2090	63	.0038	.2128	57

TAP	Tap Drill	Decimal Equiv.	Theoretical % of Thread	Probable Oversize (Mean)	Hole Size	% of Thread
1/4-28	3	.2130	80	.0038	.2168	72
	7/32	.2188	67	.0038	.2226	59
5/16-18	2	.2210	63	.0038	.2248	55
	F	.2570	77	.0038	.2608	72
5/16-18	G	.2610	71	.0041	.2651	66
	5/16-18	17/64	.2656	65	.0041	.2697
H		.2660	64	.0041	.2701	59
5/16-24	H	.2660	86	.0041	.2701	78
	I	.2720	75	.0041	.2761	67
3/8-16	J	.2770	66	.0041	.2811	58
	5/16	.3125	77	.0044	.3169	72
O		.3160	73	.0044	.3204	68
3/8-16	P	.3230	64	.0044	.3274	59
	3/8-24	21/64	.3281	87	.0044	.3325
Q		.3320	79	.0044	.3364	71
7/16-14	R	.3390	67	.0044	.3434	58
	7/16-14	T	.3580	86	.0046	.3626
23/64		.594	84	.0046	.3640	79
7/16-14	U	.3680	75	.0046	.3726	70
	3/8	.3750	67	.0046	.3796	62
7/16-20	V	.3770	65	.0046	.3816	60
	7/16-20	W	.3860	79	.0046	.3906
25/64		.3906	72	.0046	.3952	65
1/2-13	X	.3970	62	.0046	.4016	55
	27/64	.4219	78	.0047	.4266	73
1/2-20	7/16	.4375	63	.0047	.4422	58
	29/64	.4531	72	.0047	.4578	65
9/16-12	15/32	.4688	87	.0048	.4736	82
	31/64	.4844	72	.0048	.4892	68
9/16-18	1/2	.5000	87	.0048	.5048	80
	33/64	.5156	65	.0048	.5204	58
5/8-11	17/32	.5313	79	.0049	.5362	75
	35/64	.5469	66	.0049	.5518	62
5/8-18	9/16	.5625	87	.0049	.5674	80
	37/64	.5781	65	.0049	.5831	58
3/4-10	41/64	.6406	84	.0050	.6456	80
	21/32	.6563	72	.0050	.6613	68
3/4-16	11/16	.6875	77	.0050	.6925	71
	7/8-9	49/64	.7656	76	.0052	.7708
25/32		.7812	65	.0052	.7864	61
7/8-14	51/64	.7969	84	.0052	.8021	79
	13/16	.8125	67	.0052	.8177	62
1"-8	55/64	.8594	87	.0059	.8653	83
	7/8	.8750	77	.0059	.8809	73
1"-8	57/64	.8906	67	.0059	.8965	64
	29/32	.9063	58	.0059	.9122	54
1"-12	29/32	.9063	87	.0060	.9123	81
	59/64	.9219	72	.0060	.9279	67
1"-14	15/16	.9375	58	.0060	.9435	52
	59/64	.9219	84	.0060	.9279	78
1-1/8 - 7	15/16	.9375	67	.0060	.9435	61
	31/32	.9688	84	.0062	.9750	81
1-1/8 - 7	63/64	.9844	76	.0067	.9911	72
	1	1.0000	67	.0070	1.0070	64
1-1/8 - 12	1-1/64	1.0156	59	.0070	1.0226	55
	1-1/32	1.0313	87	.0071	1.0384	80
1-1/4 - 7	1-3/64	1.0469	72	.0072	1.0541	66
	1-3/32	1.0938	84			
1-1/4 - 12	1-7/64	1.1094	76			
	1-1/8	1.1250	67			
1-3/8 - 6	1-5/32	1.1563	87			
	1-11/64	1.1719	72			
1-3/8 - 6	1-3/16	1.1875	87			
	1-13/64	1.2031	79			
1-3/8 - 12	1-7/32	1.2188	72			
	1-15/64	1.2344	65			
1-1/2 - 6	1-9/32	1.2813	87			
	1-19/64	1.2969	72			
1-1/2 - 6	1-5/16	1.3125	87			
	1-21/64	1.3281	79			
1-1/2 - 12	1-11/32	1.3438	72			
	1-23/64	1.3594	65			
1-1/2 - 12	1-13/32	1.4063	87			
	1-27/64	1.4219	72			

**REAMING
RECOMMENDED**