

Inch Sizes (all measurements in inches)

| Tap Size and Pitch | Cutting Taps | | Forming Taps | |
|--------------------|--------------|----------------|--------------|----------------|
| | Drill Size | Decimal Equiv. | Drill Size | Decimal Equiv. |
| 0-80 | 3/64 | .0469 | 54 | .0550 |
| 1-64 | 53 | .0595 | 51 | .0670 |
| 1-72 | 53 | .0595 | 51 | .0670 |
| 2-56 | 50 | .0700 | 5/64 | .0781 |
| 2-64 | 50 | .0700 | 47 | .0785 |
| 3-48 | 47 | .0785 | 43 | .0890 |
| 3-56 | 46 | .0810 | 2.30 | .0905 |
| 4-40 | 43 | .0890 | 38 | .1015 |
| 4-48 | 42 | .0935 | 2.60 | .1024 |
| 5-40 | 38 | .1015 | 33 | .1130 |
| 5-44 | 37 | .1040 | 2.90 | .1142 |
| 6-32 | 36 | .1065 | 1/8 | .1250 |
| 6-40 | 33 | .1130 | 3.25 | .1280 |
| 8-32 | 29 | .1360 | 25 | .1495 |
| 8-36 | 29 | .1360 | 24 | .1520 |
| 10-24 | 26 | .1470 | 11/64 | .1719 |
| 10-32 | 21 | .1590 | 16 | .1770 |
| 12-24 | 16 | .1770 | 8 | .1990 |
| 12-28 | 15 | .1800 | 7 | .2010 |
| 1/4-20 | 7 | .2010 | 1 | .2280 |
| 1/4-28 | 3 | .2130 | 15/64 | .2340 |
| 5/16-18 | F | .2570 | L | .2900 |
| 5/16-24 | I | .2720 | M | .2950 |
| 3/8-16 | 5/16 | .3125 | S | .3480 |
| 3/8-24 | Q | .3320 | T | .3580 |
| 7/16-14 | U | .3680 | Y | .4040 |
| 7/16-20 | 25/64 | .3906 | Z | .4130 |
| 1/2-13 | 27/64 | .4219 | 15/32 | .4682 |
| 1/2-20 | 29/64 | .4531 | 12.25 | .4823 |
| 9/16-12 | 31/64 | .4844 | 17/32 | .5312 |
| 9/16-18 | 33/64 | .5156 | 13.50 | .5315 |
| 5/8-11 | 17/32 | .5312 | 14.75 | .5807 |
| 5/8-18 | 37/64 | .5781 | 15.25 | .6004 |
| 3/4-10 | 21/32 | .6562 | 45/64 | .7031 |
| 3/4-16 | 11/16 | .6875 | 23/32 | .7188 |
| 7/8-9 | 49/64 | .7656 | * | * |
| 7/8-14 | 13/16 | .8125 | * | * |
| 1-8 | 7/8 | .8750 | * | * |
| 1-12 | 59/64 | .9219 | * | * |
| 1-1/8 - 7 | 63/64 | .9844 | * | * |
| 1-1/8 - 12 | 1-3/64 | 1.0469 | * | * |
| 1-1/4 - 7 | 1-7/64 | 1.1094 | * | * |
| 1-1/4 - 12 | 1-11/64 | 1.1719 | * | * |
| 1-3/8 - 6 | 1-7/32 | 1.2188 | * | * |
| 1-3/8 - 12 | 1-19/64 | 1.2969 | * | * |
| 1-1/2 - 6 | 1-11/32 | 1.3438 | * | * |
| 1-1/2 - 12 | 1-27/64 | 1.4219 | * | * |

*Contact Technical Service for recommendations.
Hole sizes shown may not suit UNJ and MJ hole requirements.

Metric Sizes

| Tap Size and Pitch mm | Cutting Taps | | Forming Taps | |
|-----------------------|---------------|--------------------|---------------------|--------------------|
| | Drill Size mm | Decimal Equiv. in. | Drill Size mm / in. | Decimal Equiv. in. |
| M1.6 x 0.35 | 1.25 | .0492 | 1.45 | .0571 |
| M1.8 x 0.35 | 1.45 | .0571 | 1.65 | .0650 |
| M2 x 0.40 | 1.60 | .0630 | 1.80 | .0709 |
| M2.2 x 0.45 | 1.75 | .0689 | 2.00 | .0787 |
| M2.5 x 0.45 | 2.05 | .0807 | 2.30 | .0906 |
| M3 x 0.50 | 2.50 | .0984 | 7/64 | .1094 |
| M3.5 x 0.60 | 2.90 | .1142 | 3.20 | .1260 |
| M4 x 0.70 | 3.30 | .1299 | 3.70 | .1476 |
| M4.5 x 0.75 | 3.70 | .1476 | 4.10 | .1614 |
| M5 x 0.80 | 4.20 | .1654 | 14 | .1820 |
| M6 x 1.00 | 5.00 | .1969 | 7/32 | .2188 |
| M7 x 1.00 | 6.00 | .2362 | F | .2570 |
| M8 x 1.25 | 6.70 | .2638 | 7.40 | .2913 |
| M8 x 1.00 | 7.00 | .2756 | 19/64 | .2969 |
| M10 x 1.50 | 8.50 | .3346 | U | .3680 |
| M10 x 1.25 | 8.70 | .3425 | 9.40 | .3701 |
| M12 x 1.75 | 10.20 | .4016 | 11.20 | .4409 |
| M12 x 1.25 | 10.80 | .4252 | 11.50 | .4528 |
| M14 x 2.00 | 12.00 | .4724 | 33/64 | .5156 |
| M16 x 2.00 | 14.00 | .5512 | 19/32 | .5938 |
| M16 x 1.50 | 14.50 | .5709 | 15.25 | .6004 |
| M18 x 2.50 | 15.50 | .6102 | 39/64 | .6094 |
| M18 x 1.50 | 16.50 | .6496 | 17.25 | .6791 |
| M20 x 2.50 | 17.50 | .6890 | * | * |
| M20 x 1.50 | 18.50 | .7283 | * | * |
| M22 x 2.50 | 19.50 | .7677 | * | * |
| M22 x 1.50 | 20.50 | .8071 | * | * |
| M24 x 3.00 | 21.00 | .8268 | * | * |
| M24 x 2.00 | 22.00 | .8661 | * | * |
| M27 x 3.00 | 24.00 | .9449 | * | * |
| M27 x 2.00 | 25.00 | .9843 | * | * |
| M30 x 3.50 | 26.50 | 1.0433 | * | * |
| M30 x 2.00 | 28.00 | 1.1024 | * | * |
| M33 x 3.50 | 29.50 | 1.1614 | * | * |
| M33 x 2.00 | 31.00 | 1.2205 | * | * |
| M36 x 4.00 | 32.00 | 1.2598 | * | * |
| M36 x 3.00 | 33.00 | 1.2992 | * | * |
| M39 x 4.00 | 35.00 | 1.3780 | * | * |
| M39 x 3.00 | 36.00 | 1.4173 | * | * |

Pipe Tap Sizes (measurements in millimeters & inches)

| Nominal Pipe Tap Size | NPT & NPTF | | NPSM | NPSC | NPSF |
|-----------------------|----------------|-------------|----------------|---------|--------|
| | Without Reamer | With Reamer | | | |
| 1/16-27 | C .242 | A .234 | — | .250 | D .246 |
| 1/8-27 | Q .332 | 21/64 | T .358 | Q .332 | R .339 |
| 1/4-18 | 7/16 | 27/64 | 15/32 | 7/16 | 7/16 |
| 3/8-18 | 9/16 | 9/16 | .603 (special) | 37/64 | 37/64 |
| 1/2-14 | 45/64 | 11/16 | 19 mm | 18 mm | 18 mm |
| 3/4-14 | 29/32 | 57/64 | 61/64 | 59/64 | 59/64 |
| 1 - 11-1/2 | 1-9/64 | 1-1/8 | 1-13/64 | 1-5/32 | 1-5/32 |
| 1-1/4 - 11-1/2 | 1-31/64 | 1-15/32 | 1-35/64 | 1-1/2 | — |
| 1-1/2 - 11-1/2 | 1-23/32 | 1-45/64 | 1-25/32 | 1-47/64 | — |
| 2 - 11-1/2 | 2-3/16 | 2-11/64 | 2-1/4 | 2-13/64 | — |