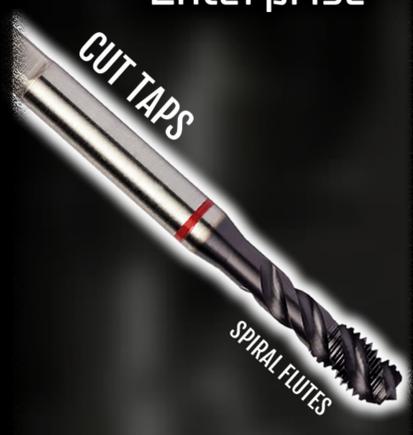


TAP DRILL SIZES



TAP SIZE	CUT TAPS – Target Theor. % of Thread			FORM TAPS – Target Theor. % of Thread		
	55% ← Approx.	65% → Approx.	75%	55% ← Approx.	65% → Approx.	75%
0-80	1.30 mm	1.25 mm	1.20 mm	1.40 mm	1.38 mm	1.36 mm
M1.6 x 0.35	1.35 mm	1.30 mm	1.25 mm	1.47 mm	1.44 mm	1.42 mm
M1.8 x 0.35	1.55 mm	1.50 mm	1.45 mm	1.67 mm	1.64 mm	1.62 mm
1-64	1/16 in	#53	1.45 mm	#51	1.68 mm	1.65 mm
1-72	1.60 mm	1.55 mm	#53	1.72 mm	1.70 mm	1.67 mm
M2 x 0.40	#51	1.65 mm	1.60 mm	#49	1.82 mm	1.79 mm
2-56	#49	1.80 mm	1.73 mm	2.01 mm	5/64 in	1.95 mm
2-64	1.87 mm	#49	1.80 mm	2.03 mm	2.00 mm	5/64 in
M2.2 x 0.45	#49	1.80 mm	1.75 mm	2.03 mm	2.00 mm	1.97 mm
M2.5 x 0.45	#44	2.10 mm	#46	2.33 mm	2.30 mm	2.27 mm
3-48	2.12 mm	#46	2.00 mm	2.32 mm	2.27 mm	2.24 mm
3-56	#44	2.13 mm	#46	2.34 mm	2.30 mm	2.28 mm
4-40	3/32 in	2.30 mm	2.20 mm	2.60 mm	2.55 mm	2.52 mm
4-48	2.45 mm	3/32 in	2.32 mm	#37	2.60 mm	#38
M3 x 0.50	#37	#38	2.50 mm	2.80 mm	7/64 in	2.75 mm
M3 x 0.35	2.75 mm	2.70 mm	2.65 mm	#33	2.85 mm	#34
5-40	#36	#37	#39	2.93 mm	2.88 mm	2.85 mm
5-44	2.75 mm	2.70 mm	2.60 mm	2.95 mm	2.92 mm	#33
M3.5 x 0.60	#31	3.00 mm	2.90 mm	3.27 mm	3.23 mm	3.20 mm
M3.5 x 0.35	3.25 mm	3.20 mm	3.15 mm	3.37 mm	3.35 mm	3.32 mm
6-32	#32	#34	#36	3.20 mm	3.15 mm	3.10 mm
6-40	#31	#32	#33	#30	3.22 mm	1/8 in
M4 x 0.70	3.50 mm	3.40 mm	3.30 mm	#26	3.70 mm	3.65 mm
M4 x 0.50	3.65 mm	9/64 in	3.50 mm	#25	3.77 mm	3.77 mm
8-32	3.60 mm	3.50 mm	3.40 mm	#24	#25	3.75 mm
8-36	#27	9/64 in	#29	3.90 mm	#24	#25
M4.5 x 0.75	5/32 in	#24	#25	#19	4.15 mm	4.10 mm
M4.5 x 0.50	4.15 mm	4.06 mm	4.00 mm	#18	4.27 mm	4.25 mm
10-24	#21	#23	#25	4.42 mm	11/64 in	4.27 mm
10-32	4.25 mm	4.15 mm	#21	4.52 mm	4.45 mm	4.40 mm
M5 x 0.80	4.40 mm	4.30 mm	4.20 mm	#13	4.65 mm	4.60 mm
M5 x 0.50	#14	#15	#16	#12	3/16 in	4.75 mm
12-24	#13	4.60 mm	4.45 mm	5.06 mm	5.00 mm	4.95 mm
12-28	#12	#13	4.60 mm	5.15 mm	5.06 mm	5.00 mm
M6 x 1.00	5.25 mm	13/64 in	5.00 mm	#2	7/32 in	5.50 mm
M6 x 0.75	5.45 mm	5.35 mm	5.25 mm	5.70 mm	5.65 mm	#2
1/4-20	#3	#5	#7	5.85 mm	#1	5.70 mm
1/4-28	5.70 mm	7/32 in	5.45 mm	6.00 mm	15/64 in	5.90 mm
M7 x 1.00	LTR D	LTR C	6.00 mm	LTR G	LTR F	6.50 mm
M7 x 0.75	6.40 mm	1/4 in	LTR D	6.70 mm	6.65 mm	6.60 mm
5/16-18	LTR I	17/64 in	LTR F	7.40 mm	7.30 mm	7.20 mm
5/16-24	9/32 in	LTR J	LTR I	19/64 in	7.45 mm	7.40 mm
M8 x 1.25	7.10 mm	LTR I	LTR H	19/64 in	7.45 mm	LTR L
M8 x 1.00	7.25 mm	9/32 in	7.00 mm	7.60 mm	19/64 in	7.50 mm
3/8-16	8.40 mm	LTR P	5/16 in	8.90 mm	8.80 mm	11/32 in
3/8-24	11/32 in	LTR R	8.50 mm	23/64 in	9.05 mm	9.00 mm
M10 x 1.50	8.90 mm	11/32 in	8.50 mm	9.40 mm	9.30 mm	9.20 mm
M10 x 1.25	9.10 mm	8.90 mm	11/32 in	3/8 in	9.45 mm	LTR U
M10 x 1.00	9.25 mm	23/64 in	9.00 mm	9.60 mm	9.55 mm	9.50 mm
7/16-14	LTR W	LTR V	LTR U	10.40 mm	10.30 mm	10.20 mm
7/16-20	10.20 mm	10.00 mm	9.95 mm	10.60 mm	10.50 mm	LTR Z
M12 x 1.75	27/64 in	10.50 mm	10.30 mm	11.30 mm	11.20 mm	7/16 in
M12 x 1.50	10.90 mm	27/64 in	10.50 mm	11.40 mm	11.30 mm	11.20 mm
M12 x 1.00	11.25 mm	7/16 in	11.00 mm	11.60 mm	11.55 mm	11.50 mm
1/2-13	11.30 mm	11.00 mm	27/64 in	15/32 in	11.80 mm	11.70 mm
1/2-20	11.80 mm	11.60 mm	11.40 mm	12.20 mm	12.10 mm	12.05 mm
M14 x 2.00	12.50 mm	31/64 in	12.00 mm	13.20 mm	33/64 in	13.00 mm
M14 x 1.50	12.90 mm	1/2 in	12.50 mm	13.40 mm	13.30 mm	13.20 mm
9/16-12	1/2 in	12.50 mm	12.20 mm	17/32 in	13.30 mm	13.20 mm
9/16-18	13.25 mm	33/64 in	12.90 mm	13.75 mm	13.65 mm	13.55 mm
5/8-11	14.20 mm	13.90 mm	13.60 mm	15.00 mm	14.80 mm	37/64 in
5/8-18	14.80 mm	37/64 in	14.50 mm	15.30 mm	15.25 mm	15.15 mm
M16 x 2.00	14.50 mm	9/16 in	14.00 mm	15.25 mm	15.10 mm	15.00 mm
M16 x 1.50	14.90 mm	14.70 mm	14.50 mm	15.40 mm	15.30 mm	15.20 mm
M18 x 2.50	16.20 mm	5/8 in	15.50 mm	43/64 in	16.90 mm	16.75 mm
M18 x 1.50	16.90 mm	21/32 in	16.50 mm	17.40 mm	17.30 mm	17.25 mm
3/4-10	17.20 mm	16.90 mm	16.50 mm	18.10 mm	45/64 in	17.70 mm
3/4-16	17.90 mm	17.70 mm	17.50 mm	18.40 mm	18.30 mm	23/32 in
M20 x 2.50	18.20 mm	45/64 in	17.50 mm	3/4 in	18.90 mm	47/64 in
M20 x 1.50	18.90 mm	18.75 mm	18.50 mm	49/64 in	19.30 mm	19.25 mm
M22 x 2.50	51/64 in	25/32 in	19.50 mm	53/64 in	20.90 mm	20.75 mm
M22 x 1.50	20.90 mm	20.75 mm	20.50 mm	27/32 in	21.30 mm	21.25 mm
7/8-9	51/64 in	25/32 in	19.50 mm	21.10 mm	21.00 mm	20.75 mm
7/8-14	20.90 mm	13/16 in	20.40 mm	21.50 mm	27/32 in	21.30 mm
M24 x 3.00	55/64 in	27/32 in	53/64 in	22.80 mm	57/64 in	22.50 mm
M24 x 2.00	22.50 mm	7/8 in	22.00 mm	23.25 mm	23.10 mm	23.00 mm
1-8	29/32 in	57/64 in	22.25 mm	61/64 in	24.00 mm	23.75 mm
1-12	15/16 in	23.60 mm	23.30 mm	31/32 in	24.40 mm	24.25 mm

IMPORTANT: Actual % of Thread will be lower than Theoretical % of Thread due to drilling operation runout. Carbide drills will cut closer to size and therefore will deliver a higher % of Thread. Conversely, runout will be higher with HSS drills, and Actual % of Thread will be lower.

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