

TAPPING SPEED GUIDE

| MATERIALS | | | SPEED FEET PER MINUTE | MATERIALS | | | SPEED FEET PER MINUTE |
|-------------------------|--------------------------------|-----------------|-----------------------|-------------------------------------|-------------------------|-----------|-----------------------|
| Aluminum Alloys | | | 90-100 | (Steel, Cont.) Carbon Steel, Plain | Annealed | 40-80 | |
| Brass | | | 60-100 | | Tempered | 15-40 | |
| Bronze | | | 40-60 | Cast, Carbon | Annealed | 40-50 | |
| Copper | | | 40-60 | | Tempered | 30 | |
| High Temperature Alloys | | | Cobalt Base | Cast, Corrosion Resistant, | Annealed | 20-30 | |
| | | | | | Iron Base | as Cast | 20-25 |
| | | | | | Nickel Base | Low Alloy | Annealed |
| Iron | Ductile | Annealed | 60 | Precipitation Hardening, Stainless | Tempered | 15-25 | |
| | | as Cast | 30 | | Treated | 10-15 | |
| | | Tempered | 15-20 | | Annealed | 15-45 | |
| | Gray, | Annealed | 80 | | Tempered | 15-25 | |
| | | As Cast | 35-60 | | Annealed | 45-75 | |
| | Malleable | | 60 | | Tool Steels, High Speed | Annealed | 15-25 |
| Magnesium Alloys | | Heat Treated | 25-50 | Water Hardening | Annealed | 50 | |
| | | Annealed | 175 | Ultra High Strength Steels | Annealed | 35 | |
| Manganese | | | 20 | | Normalized | 20 | |
| Molybdenum Alloys | | Stress Relieved | 50 | | Tempered | 3-7 | |
| Monel | | Annealed | 20 | Maraging Steels | Annealed | 20-15 | |
| Nickel Alloys | | Annealed | 25 | | Maraged | 5-10 | |
| Plastics, | Reinforced | | 25 | Tantalum Alloys, Stress Relieved | | 3 | |
| | Thermoplastics | | 50 | Titanium Alloys, Commercial Pure, | Annealed | 40-60 | |
| | Thermosetting Plastics | | 50 | Alpha & Alpha Beta Alloys, | Annealed | 10-25 | |
| Steels, | Alloys, Annealed or Cold Drawn | | 40-60 | Tungsten Alloys, Pressed & Sintered | | 50 | |
| | Quenched & Tempered | | 15-35 | Zinc Alloys | Die Cast | 150 | |
| | Armor Plate | | 10 | | | | |

CONVERSION TABLE, SURFACE FEET PER MINUTE TO REVOLUTIONS PER MINUTE

| SPEED FEET PER MINUTE | 20 | 25 | 30 | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 110 | 120 | 130 | 140 | 150 |
|-----------------------|------------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| TAP SIZE | REVOLUTIONS PER MINUTE | | | | | | | | | | | | | | |
| 0 | 1273 | 1592 | 1910 | 2546 | 3183 | 3820 | 4456 | 5093 | 5730 | 6366 | 7003 | 7639 | 8276 | 8913 | 9549 |
| 1 | 1047 | 1308 | 1570 | 2093 | 2617 | 3140 | 3663 | 4186 | 4710 | 5233 | 5756 | 6279 | 6808 | 7326 | 7849 |
| 2 | 888 | 1110 | 1333 | 1777 | 2221 | 2665 | 3109 | 3554 | 3999 | 4442 | 4886 | 5330 | 5774 | 6218 | 6662 |
| 3 | 772 | 964 | 1157 | 1543 | 1929 | 2315 | 2701 | 3086 | 3472 | 3858 | 4244 | 4629 | 5015 | 5401 | 5787 |
| 4 | 682 | 853 | 1023 | 1364 | 1705 | 2046 | 2387 | 2728 | 3069 | 3411 | 3751 | 4092 | 4434 | 4775 | 5116 |
| 5 | 611 | 764 | 917 | 1222 | 1528 | 1833 | 2139 | 2445 | 2750 | 3056 | 3361 | 3667 | 3973 | 4278 | 4584 |
| 6 | 553 | 691 | 829 | 1106 | 1382 | 1658 | 1934 | 2211 | 2487 | 2764 | 3040 | 3316 | 3592 | 3869 | 4145 |
| 8 | 466 | 583 | 699 | 932 | 1165 | 1398 | 1631 | 1864 | 2097 | 2330 | 2563 | 2796 | 3029 | 3262 | 3495 |
| 10 | 401 | 502 | 603 | 804 | 1005 | 1205 | 1406 | 1607 | 1808 | 2009 | 2210 | 2411 | 2612 | 2813 | 3014 |
| 12 | 354 | 442 | 531 | 707 | 884 | 1061 | 1238 | 1415 | 1592 | 1769 | 1945 | 2122 | 2300 | 2476 | 2653 |
| 1/4 | 306 | 382 | 458 | 611 | 764 | 917 | 1070 | 1222 | 1375 | 1528 | 1681 | 1833 | 1986 | 2139 | 2292 |
| 5/16 | 245 | 306 | 367 | 489 | 611 | 733 | 856 | 978 | 1100 | 1222 | 1345 | 1467 | 1589 | 1711 | 1833 |
| 3/8 | 204 | 255 | 306 | 407 | 509 | 611 | 713 | 815 | 917 | 1019 | 1120 | 1222 | 1324 | 1426 | 1528 |
| 7/16 | 175 | 219 | 262 | 349 | 437 | 524 | 611 | 698 | 786 | 873 | 960 | 1048 | 1135 | 1222 | 1310 |
| 1/2 | 153 | 191 | 229 | 306 | 382 | 458 | 535 | 611 | 688 | 764 | 840 | 917 | 993 | 1070 | 1146 |
| 9/16 | 137 | 172 | 206 | 275 | 344 | 412 | 481 | 550 | 619 | 687 | 756 | 825 | 893 | 963 | 1031 |
| 5/8 | 122 | 153 | 183 | 244 | 306 | 367 | 428 | 489 | 550 | 611 | 672 | 733 | 794 | 856 | 917 |
| 3/4 | 102 | 128 | 153 | 203 | 255 | 306 | 357 | 407 | 458 | 509 | 560 | 611 | 662 | 713 | 764 |
| 7/8 | 87 | 109 | 131 | 175 | 218 | 262 | 306 | 350 | 392 | 437 | 480 | 524 | 568 | 611 | 655 |
| 1 | 76 | 96 | 115 | 153 | 191 | 230 | 268 | 306 | 344 | 382 | 420 | 458 | 497 | 535 | 573 |

SLOW SPIRAL FLUTED 30° MACHINE SCREW TAPS

LIST 101S

Plug
Bottom



| TAP SIZE | SERIES DESIGN. | NO. OF FLUTES | STYLE | EDP NUMBER | | |
|----------|----------------|---------------|-------|------------|-------|-------|
| | | | | H-1 | H-2 | H-3 |
| 3 - 48 | NC | 2 | PLUG | 18512 | 18522 | |
| 3 - 48 | NC | 2 | BOTT | 18513 | 18523 | |
| 3 - 56 | NF | 2 | PLUG | 18612 | 18622 | |
| 3 - 56 | NF | 2 | BOTT | 18613 | 18623 | |
| 4 - 40 | NC | 2 | PLUG | 18712 | 18722 | |
| 4 - 40 | NC | 2 | BOTT | 18713 | 18723 | |
| 4 - 48 | NF | 2 | PLUG | 18812 | 18822 | |
| 4 - 48 | NF | 2 | BOTT | 18813 | 18823 | |
| 5 - 40 | NC | 2 | PLUG | 18912 | 18922 | |
| 5 - 40 | NC | 2 | BOTT | 18913 | 18923 | |
| 5 - 44 | NF | 2 | PLUG | 19012 | 19022 | |
| 5 - 44 | NF | 2 | BOTT | 19013 | 19023 | |
| 6 - 32 | NC | 2 | PLUG | 19112 | | 19132 |
| 6 - 32 | NC | 2 | BOTT | 19113 | | 19133 |
| 6 - 40 | NF | 2 | PLUG | 19212 | 19222 | |
| 6 - 40 | NF | 2 | BOTT | 19213 | 19223 | |
| 8 - 32 | NC | 2 | PLUG | 19312 | | 19332 |
| 8 - 32 | NC | 2 | BOTT | 19313 | | 19333 |
| 8 - 36 | NF | 2 | PLUG | 19412 | 19422 | |
| 8 - 36 | NF | 2 | BOTT | 19413 | 19423 | |
| 10 - 24 | NC | 2 | PLUG | 19512 | | 19532 |
| 10 - 24 | NC | 2 | BOTT | 19513 | | 19533 |
| 10 - 32 | NF | 2 | PLUG | 19612 | | 19632 |
| 10 - 32 | NF | 2 | BOTT | 19613 | | 19633 |
| 12 - 24 | NC | 2 | PLUG | 19712 | | 19732 |
| 12 - 24 | NC | 2 | BOTT | 19713 | | 19733 |
| 12 - 28 | NF | 2 | PLUG | 19812 | | 19832 |
| 12 - 28 | NF | 2 | BOTT | 19813 | | 19833 |

Penta Relief – Special thread geometry that allows for freer cutting. Available in Standard Taps in List Numbers 106A in size #10 with 2 & 3 Flutes and larger sizes, 103, 102C, 402VPR, 402VMPPR, 403V, 403VM, 407VP and 407VMPPR.

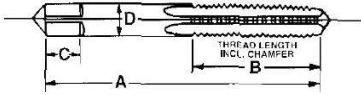


TAP DRILL SIZES AND PERCENTAGE OF THREADS

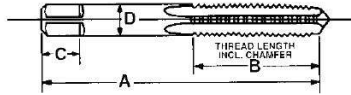
| TAP | | TAP DRILL | DECIM. EQUIV. | THEOR. % OF THREAD | TAP | | TAP DRILL | DECIM. EQUIV. | THEOR. % OF THREAD | TAP | | TAP DRILL | DECIM. EQUIV. | THEOR. % OF THREAD |
|-----------|-----|-----------|---------------|--------------------|-----------|-----|-----------|---------------|--------------------|-----------|-----|-----------|---------------|--------------------|
| NOM. SIZE | TPI | | | | NOM. SIZE | TPI | | | | NOM. SIZE | TPI | | | |
| 0 | 80 | #56 | .0465 | 83 | 1/4 | 20 | 13/64 | .2031 | 72 | 5/8 | 18 | 9/16 | .5625 | 87 |
| | | 3/64 | .0469 | 81 | | | #6 | .2040 | 71 | | | 0.5687 | .5687 | 78 |
| 1 | 64 | #54 | .0550 | 89 | 1/4 | 28 | #5 | .2055 | 69 | 5/8 | 20 | 37/64 | .5781 | 72 |
| | | #53 | .0595 | 67 | | | #3 | .2130 | 80 | | | 37/64 | .5781 | 87 |
| 1 | 72 | #53 | .0595 | 75 | 1/4 | 32 | 7/32 | .2188 | 67 | 5/8 | 24 | 0.5828 | .5828 | 78 |
| | | 1/16 | .0625 | 58 | | | 7/32 | .2188 | 77 | | | 5/8 | 28 | 19/32 |
| 2 | 56 | #51 | .0670 | 82 | 1/4 | 36 | #2 | .2210 | 71 | 5/8 | 32 | 19/32 | .5938 | 77 |
| | | #50 | .0700 | 69 | | | #2 | .2210 | 80 | | | 19/32 | .5938 | 87 |
| 2 | 64 | #49 | .0730 | 56 | 5/16 | 18 | F | .2570 | 77 | 11/16 | 12 | 39/64 | .6094 | 72 |
| | | #50 | .0700 | 79 | | | G | .2610 | 71 | | | 5/8 | 16 | .6250 |
| 3 | 48 | #48 | .0760 | 85 | 5/16 | 20 | F | .2570 | 85 | 11/16 | 20 | 41/64 | .6406 | 72 |
| | | 5/64 | .0781 | 77 | | | G | .2610 | 79 | | | 11/16 | 24 | 41/64 |
| 3 | 56 | #47 | .0785 | 76 | 5/16 | 24 | H | .2660 | 72 | 11/16 | 28 | 21/32 | .6562 | 67 |
| | | #46 | .0810 | 67 | | | H | .2660 | 86 | | | 11/16 | 32 | 21/32 |
| 3 | 40 | #45 | .0820 | 63 | 5/16 | 28 | I | .2720 | 75 | 3/4 | 10 | 41/64 | .6406 | 84 |
| | | #48 | .0810 | 78 | | | J | .2770 | 66 | | | 21/32 | .6562 | 72 |
| 4 | 40 | #44 | .0860 | 80 | 5/16 | 32 | J | .2770 | 77 | 3/4 | 12 | 21/32 | .6562 | 87 |
| | | #43 | .0890 | 71 | | | K | .2810 | 68 | | | 43/64 | .6719 | 72 |
| 4 | 48 | #42 | .0935 | 57 | 5/16 | 36 | 9/32 | .2812 | 67 | 3/4 | 16 | 11/16 | .6875 | 77 |
| | | 3/32 | .0938 | 56 | | | K | .2810 | 78 | | | 3/4 | 20 | 45/64 |
| 4 | 48 | #43 | .0890 | 85 | 3/8 | 16 | 9/32 | .2812 | 77 | 3/4 | 28 | 23/32 | .7188 | 67 |
| | | #42 | .0935 | 68 | | | 5/16 | .3125 | 77 | | | 3/4 | 32 | 23/32 |
| 5 | 40 | 3/32 | .0938 | 67 | 3/8 | 20 | O | .3160 | 73 | 13/16 | 12 | 47/64 | .7344 | 72 |
| | | #41 | .0960 | 59 | | | P | .3230 | 80 | | | 13/16 | 16 | 3/4 |
| 5 | 44 | #40 | .0980 | 83 | 3/8 | 24 | Q | .3320 | 66 | 13/16 | 20 | 49/64 | .7656 | 72 |
| | | #39 | .0995 | 79 | | | Q | .3320 | 79 | | | 13/16 | 28 | 25/32 |
| 5 | 32 | #38 | .1015 | 72 | 3/8 | 28 | R | .3390 | 67 | 13/16 | 32 | 25/32 | .7812 | 77 |
| | | #37 | .1040 | 65 | | | R | .3390 | 78 | | | 7/8 | 9 | 49/64 |
| 6 | 40 | #38 | .1015 | 80 | 3/8 | 32 | 11/32 | .3438 | 67 | 7/8 | 12 | 25/32 | .7812 | 87 |
| | | #37 | .1040 | 71 | | | 11/32 | .3438 | 77 | | | 7/8 | 14 | 51/64 |
| 6 | 48 | #36 | .1065 | 63 | 3/8 | 36 | S | .3480 | 67 | 7/8 | 14 | 51/64 | .7969 | 84 |
| | | #37 | .1040 | 84 | | | S | .3480 | 75 | | | 0.8024 | .8024 | 78 |
| 6 | 32 | #36 | .1065 | 78 | 7/16 | 14 | T | .3580 | 86 | 7/8 | 16 | 13/16 | .8125 | 67 |
| | | 7/64 | .1094 | 70 | | | 23/64 | .3594 | 84 | | | 7/8 | 20 | 53/64 |
| 6 | 40 | #35 | .1100 | 69 | 7/16 | 16 | 3/8 | .3750 | 77 | 7/8 | 28 | 27/32 | .8438 | 67 |
| | | #34 | .1110 | 67 | | | V | .3770 | 75 | | | 7/8 | 32 | 27/32 |
| 8 | 32 | #33 | .1130 | 77 | 7/16 | 20 | W | .3860 | 79 | 15/16 | 12 | 27/32 | .8438 | 87 |
| | | #32 | .1160 | 68 | | | 25/64 | .3906 | 72 | | | 7/8 | 32 | 27/32 |
| 8 | 36 | #29 | .1360 | 69 | 7/16 | 28 | Y | .4040 | 72 | 15/16 | 16 | 27/32 | .8438 | 87 |
| | | #29 | .1360 | 78 | | | Y | .4040 | 83 | | | 15/16 | 20 | 55/64 |
| 10 | 24 | #28 | .1405 | 65 | 1/2 | 12 | 13/32 | .4062 | 77 | 15/16 | 16 | 7/8 | .8750 | 77 |
| | | 9/64 | .1406 | 65 | | | Z | .4130 | 80 | | | 15/16 | 20 | 57/64 |
| 10 | 24 | #27 | .1440 | 85 | 1/2 | 13 | 27/64 | .4219 | 72 | 15/16 | 28 | 29/32 | .9062 | 67 |
| | | #26 | .1470 | 79 | | | 27/64 | .4219 | 78 | | | 15/16 | 32 | 29/32 |
| 10 | 32 | #25 | .1495 | 75 | 1/2 | 16 | 7/16 | .4375 | 77 | 1 | 8 | 55/64 | .8594 | 87 |
| | | #24 | .1520 | 70 | | | 1/2 | 20 | 29/64 | | | .4531 | 72 | 7/8 |
| 10 | 32 | #23 | .1540 | 66 | 1/2 | 28 | 15/32 | .4688 | 67 | 1 | 12 | 29/32 | .9062 | 87 |
| | | 5/32 | .1562 | 83 | | | 1/2 | 32 | 15/32 | | | .4688 | 77 | 59/64 |
| 12 | 24 | #22 | .1570 | 81 | 9/16 | 12 | 15/32 | .4688 | 87 | 1 | 14 | 59/64 | .9219 | 84 |
| | | #21 | .1590 | 76 | | | 31/64 | .4844 | 72 | | | 0.9274 | .9274 | 78 |
| 12 | 28 | #20 | .1610 | 71 | 9/16 | 16 | 1/2 | .5000 | 77 | 1 | 16 | 15/16 | .9375 | 77 |
| | | 11/64 | .1719 | 82 | | | 0.5062 | .5062 | 69 | | | 1 | 20 | 61/64 |
| 12 | 28 | #17 | .1730 | 79 | 9/16 | 18 | 1/2 | .5000 | 87 | 1 | 28 | 31/32 | .9688 | 67 |
| | | #16 | .1770 | 72 | | | 0.5062 | .5062 | 78 | | | 1 | 32 | 31/32 |
| 12 | 32 | #15 | .1800 | 67 | 9/16 | 20 | 33/64 | .5156 | 72 | 1 1/16 | 8 | 59/64 | .9219 | 87 |
| | | #16 | .1770 | 84 | | | 33/64 | .5156 | 87 | | | 0.9274 | .9274 | 83 |
| 12 | 32 | #15 | .1800 | 78 | 9/16 | 24 | 0.5203 | .5203 | 78 | 1 1/16 | 12 | 15/16 | .9375 | 77 |
| | | #14 | .1820 | 73 | | | 17/32 | .5312 | 67 | | | 31/32 | .9688 | 87 |
| 1/4 | 20 | #13 | .1850 | 67 | 9/16 | 28 | 0.5263 | .5263 | 78 | 1 1/16 | 16 | 63/64 | .9844 | 72 |
| | | #14 | .1820 | 84 | | | 17/32 | .5312 | 77 | | | 1 | 1.0000 | 77 |
| 1/4 | 20 | #13 | .1850 | 76 | 5/8 | 11 | 17/32 | .5312 | 79 | 1 1/16 | 18 | 1 | 1.0000 | 87 |
| | | #12 | .1890 | 67 | | | 5/8 | 12 | 35/64 | | | .5469 | 72 | 1 1/16 |
| 1/4 | 20 | #9 | .1960 | 83 | 5/8 | 16 | 9/16 | .5625 | 77 | | | | | |
| | | #8 | .1990 | 79 | | | 0.5687 | .5687 | 69 | | | | | |
| | | #7 | .2010 | 75 | | | | | | | | | | |

STANDARD TAP DIMENSIONS, GROUND THREAD

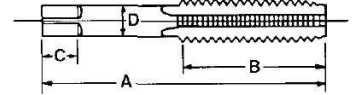
General Dimensions



STYLE 1



STYLE 2



STYLE 3

| NOMINAL DIAMETER RANGE - INCHES | | MACHINE SCREW SIZE NO. | NOMINAL FRACTIONAL DIAMETER INCHES | NOMINAL METRIC DIAMETER MILLIMETER | STYLE* | TAP DIMENSIONS - INCHES | | | | |
|---------------------------------|------------|------------------------|------------------------------------|------------------------------------|--------|-------------------------|--------------|-------------|--------------|---------------|
| | | | | | | O/A LENGTH A | THD. LGTH. B | SQ. LGTH. C | SHANK DIA. D | SIZE OF SQ. E |
| OVER | TO (INCL.) | | | | | | | | | |
| .052 | .065 | 0 | 1/16 | M1.6 | 1 | 1 5/8 | 5/16 | 3/16 | .141 | .110 |
| .065 | .078 | 1 | | M1.8 | 1 | 1 11/16 | 3/8 | 3/16 | .141 | .110 |
| .078 | .091 | 2 | | M2, M2.2 | 1 | 1 3/4 | 7/16 | 3/16 | .141 | .110 |
| .091 | .104 | 3 | 3/32 | M2.5 | 1 | 1 13/16 | 1/2 | 3/16 | .141 | .110 |
| .104 | .117 | 4 | | | 1 | 1 7/8 | 9/16 | 3/16 | .141 | .110 |
| .117 | .130 | 5 | 1/8 | M3, M3.15 | 1 | 1 15/16 | 5/8 | 3/16 | .141 | .110 |
| .130 | .145 | 6 | | M3.5 | 1 | 2 | 11/16 | 3/16 | .141 | .110 |
| .145 | .171 | 8 | 5/32 | M4 | 1 | 2 1/8 | 3/4 | 1/4 | .168 | .131 |
| .171 | .197 | 10 | 3/16 | M4.5, M5 | 1 | 2 3/8 | 7/8 | 1/4 | .194 | .152 |
| .197 | .223 | 12 | 7/32 | | 1 | 2 3/8 | 15/16 | 9/32 | .220 | .165 |
| .223 | .260 | 14 | 1/4 | M6, M6.3 | 2 | 2 1/2 | 1 | 5/16 | .255 | .191 |
| .260 | .323 | | 5/16 | M7, M8 | 2 | 2 23/32 | 1 1/8 | 3/8 | .318 | .238 |
| .323 | .395 | | 3/8 | M10 | 2 | 2 15/16 | 1 1/4 | 7/16 | .381 | .286 |
| .395 | .448 | | 7/16 | | 3 | 3 5/32 | 1 7/16 | 13/32 | .323 | .242 |
| .448 | .510 | | 1/2 | M12, M12.5 | 3 | 3 3/8 | 1 21/32 | 7/16 | .367 | .275 |
| .510 | .573 | | 9/16 | M14 | 3 | 3 19/32 | 1 21/32 | 1/2 | .429 | .322 |
| .573 | .635 | | 5/8 | M16 | 3 | 3 13/16 | 1 13/16 | 9/16 | .480 | .360 |
| .635 | .709 | | 11/16 | M18 | 3 | 4 1/32 | 1 13/16 | 5/8 | .542 | .406 |
| .709 | .760 | | 3/4 | | 3 | 4 1/4 | 2 | 11/16 | .590 | .442 |
| .760 | .823 | | 13/16 | M20 | 3 | 4 15/32 | 2 | 11/16 | .652 | .489 |
| .823 | .885 | | 7/8 | M22 | 3 | 4 11/16 | 2 7/32 | 3/4 | .697 | .523 |
| .885 | .948 | | 15/16 | M24 | 3 | 4 29/32 | 2 7/32 | 3/4 | .760 | .570 |
| .948 | 1.010 | | 1 | M25 | 3 | 5 1/8 | 2 1/2 | 13/16 | .800 | .600 |
| 1.010 | 1.073 | | 1 1/16 | M27 | 3 | 5 1/8 | 2 1/2 | 7/8 | .896 | .672 |
| 1.073 | 1.135 | | 1 1/8 | | 3 | 5 7/16 | 2 9/16 | 7/8 | .896 | .672 |
| 1.135 | 1.198 | | 1 3/16 | M30 | 3 | 5 7/16 | 2 9/16 | 1 | 1.021 | .766 |
| 1.198 | 1.260 | | 1 1/4 | | 3 | 5 3/4 | 2 9/16 | 1 | 1.021 | .766 |
| 1.260 | 1.323 | | 1 5/16 | M33 | 3 | 5 3/4 | 2 9/16 | 1 1/16 | 1.108 | .831 |
| 1.323 | 1.385 | | 1 3/8 | | 3 | 6 1/16 | 3 | 1 1/16 | 1.108 | .831 |
| 1.385 | 1.448 | | 1 7/16 | M36 | 3 | 6 1/16 | 3 | 1 1/8 | 1.233 | .925 |
| 1.448 | 1.510 | | 1 1/2 | | 3 | 6 3/8 | 3 | 1 1/8 | 1.233 | .925 |
| 1.510 | 1.635 | | 1 5/8 | M39 | 3 | 6 11/16 | 3 3/16 | 1 1/8 | 1.305 | .979 |
| 1.635 | 1.760 | | 1 3/4 | M42 | 3 | 7 | 3 3/16 | 1 1/4 | 1.430 | 1.072 |
| 1.760 | 1.885 | | 1 7/8 | | 3 | 7 5/16 | 3 9/16 | 1 1/4 | 1.519 | 1.139 |
| 1.885 | 2.010 | | 2 | M48 | 3 | 7 5/8 | 3 9/16 | 1 3/8 | 1.644 | 1.233 |
| 2.010 | 2.135 | | 2 1/8 | | 3 | 8 | 3 9/16 | 1 3/8 | 1.769 | 1.327 |
| 2.135 | 2.260 | | 2 1/4 | M56 | 3 | 8 1/4 | 3 9/16 | 1 7/16 | 1.894 | 1.420 |
| 2.260 | 2.385 | | 2 3/8 | | 3 | 8 1/2 | 4 | 1 7/16 | 2.019 | 1.514 |
| 2.385 | 2.510 | | 2 1/2 | | 3 | 8 3/4 | 4 | 1 1/2 | 2.100 | 1.575 |
| 2.510 | 2.635 | | 2 5/8 | M64 | 3 | 8 3/4 | 4 | 1 1/2 | 2.225 | 1.669 |
| 2.635 | 2.760 | | 2 3/4 | | 3 | 9 1/4 | 4 | 1 9/16 | 2.350 | 1.762 |
| 2.760 | 2.885 | | 2 7/8 | M72 | 3 | 9 1/4 | 4 | 1 9/16 | 2.475 | 1.856 |
| 2.885 | 3.010 | | 3 | | 3 | 9 3/4 | 4 9/16 | 1 5/8 | 2.543 | 1.907 |
| 3.010 | 3.135 | | 3 1/8 | | 3 | 9 3/4 | 4 9/16 | 1 5/8 | 2.668 | 2.001 |
| 3.135 | 3.260 | | 3 1/4 | M80 | 3 | 10 | 4 9/16 | 1 3/4 | 2.793 | 2.095 |

*Styles shown are for Ground Thread Taps.