


TAP DRILL SIZES - UNIFIED THREAD

Size	Threads Per Inch		Drills for Cutting Taps				Drill for Forming Taps
	UNC	UNF	Tap Drill	Inch Equiv.	Probable Hole Size (Inch)	Probable Percent of Thread	Drill for 65%
0		80	3/64	.0469	.0484	71	54 or 1.4mm
1	64	72	53	.0595	.0610	59	51 or 1.7mm
2	56	64	50	.0700	.0717	62	51 or 1.75mm
3	48	56	47	.0785	.0804	69	47 or 2.0mm
4	40	48	43	.0890	.0910	65	2.0mm
5	40	44	38	.1015	.1038	65	2.3mm
6	32	40	36	.1065	.1088	63	2.3mm
8	32	36	29	.1360	.1389	61	39
10	24	32	25	.1495	.1527	69	37
12	24	28	21	.1590	.1622	68	33 or 2.9mm
1/4	20	28	7	.2010	.2048	72	33 or 2.9mm
5/16	18	24	3	.2130	.2168	72	3.1mm
3/8	16	24	1	.2570	.2608	67	1/8 or 3.2mm
7/16	14	20	5/16	.3125	.3169	72	25 or 3.8mm
1/2	13	20	Q	.3320	.3364	71	24
9/16	12	18	U	.3680	.3726	70	11/64
5/8	11	18	25/64	.3906	.3952	65	16 or .176
3/4	10	16	27/64	.4219	.4266	73	9 or 5.0mm
7/8	9	14	29/64	.4531	.4578	65	7 or 5.1mm
1	8	12	31/64	.4844	.4892	68	5.75mm
1-1/8	7	12	33/64	.5156	.5204	58	A
1-1/4	7	12	17/32	.5312	.5362	75	7.25mm
1-3/8	6	16	37/64	.5781	.5831	58	.293
1-1/2	6	12	21/32	.6562	.6613	68	S or 11/32mm
			11/16	.6875	.6925	71	9.0mm
			49/64	.7656	.7708	72	Y
			13/16	.8125	.8177	62	Z or 10.5mm
			7/8	.8750	.8809	73	.463
			59/64	.9219	.9279	67	.476
			63/64	.9844	.9911	72	.521
			1-3/64	1.0469	1.0541	65	.536
			1-7/64	1.1094			37/64
			1-11/64	1.1719			.598
			1-7/32	1.2187			45/64
			1-19/64	1.2969			23/32
			1-11/32	1.3437			.823
			1-27/64	1.4219			27/32

10 TAP DRILL SIZES - METRIC THREAD

Size	Pitch	Recommended Metric Drill				Closest Recommended Inch Drill				Drill for Forming Taps
		Tap Drill (mm)	Inch Equiv.	Probable Hole Size (Inch)	Probable Percent of Thread	Tap Drill	Inch Equiv.	Probable Hole Size (Inch)	Probable Percent of Thread	6H Recommended
M1.6	0.35	1.25	.0492	.0507	69					1.45
M1.8	0.35	1.45	.0571	.0586	69					1.65
M2	0.40	1.6	.0630	.0647	69	52	.0635	.0652	66	1.85
M2.2	0.45	1.75	.0689	.0706	70					2.0
M2.5	0.45	2.05	.0807	.0826	69	46	.0810	.0829	67	2.3
M3	0.50	2.5	.0984	.1007	68	40	.0980	.1003	70	#35
M3.5	0.60	2.9	.1142	.1168	68	33	.1130	.1156	72	#30
M4	0.70	3.3	.1299	.1328	69	30	.1285	.1314	73	3.7
M4.5	0.75	3.7	.1457	.1486	74	26	.1470	.1502	70	4.16
M5	0.80	4.2	.1654	.1686	69	19	.1660	.1692	68	#14
M6	1.00	5.0	.1968	.2006	70	9	.1960	.1998	71	5.5
M7	1.00	6.0	.2362	.2400	70	15/64	.2344	.2382	73	6.5
M8	1.25	6.7	.2638	.2679	74	17/64	.2656	.2697	71	7.4
	1.00	7.0	.2756	.2797	69	J	.2770	.2811	66	7.55
M10	1.50	8.5	.3346	.3390	71	Q	.3320	.3364	75	9.3
	1.25	8.7	.3425	.3471	73	11/32	.3438	.3483	71	9.4
M12	1.75	10.2	.4016	.4063	74	Y	.4040	.4087	71	7/16
	1.25	10.8	.4252	.4299	67	27/64	.4219	.4266	72	11.3
M14	2.00	12.0	.4724	.4772	72	15/32	.4688	.4736	76	
	1.50	12.5	.4921	.4969	71					
M16	2.00	14.0	.5512	.5561	72	35/64	.5469	.5518	76	
	1.50	14.5	.5709	.5758	71					
M18	2.50	15.5	.6102	.6152	73	39/64	.6094	.6144	74	
	1.50	16.5	.6496	.6546	70					
M20	2.50	17.5	.6890	.6942	73	11/16	.6875	.6925	74	
	1.50	18.5	.7283	.7335	70					
M22	2.50	19.5	.7677	.7729	73	49/64	.7656	.7708	75	
	1.50	20.5	.8071	.8123	70					
M24	3.00	21.0	.8268	.8327	73	53/64	.8281	.8340	72	
	2.00	22.0	.8661	.8720	71					
M27	3.00	24.0	.9449	.9511	73	15/16	.9375	.9435	78	
	2.00	25.0	.9843	.9913	70	63/64	.9844	.9914	70	
M30	3.00	26.5	1.0433							
	2.00	28.0	1.1024							
M33	3.50	29.5	1.1614							
	2.00	31.0	1.2205							
M36	4.00	32.0	1.2598							
	3.00	33.0	1.2992							
M39	4.00	35.0	1.3780							
	3.00	36.0	1.4173							

Reaming Recommended to the Drill Size Shown



CONVERSION TABLE

SURFACE FEET PER MINUTE TO REVOLUTIONS PER MINUTE

Surface 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	4422	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	402	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	486	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	252	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