

SELECTION GUIDE



HSS-PM, HSS-E & HSS
YG TAP
FORMING

- For Forming Ductile Materials



Please visit
global.yg1.com/mat
for material search

◎ : Excellent ○ : Good

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC						
P	1	Non-alloy steel	About 0.15% C	Annealed	125		⊗	50-80	⊗	25-50	⊗	25-50
	2		About 0.45% C	Annealed	190	13	⊗	50-80	⊗	25-50	⊗	25-50
	3		About 0.45% C	Quenched & Tempered	250	25	⊗	50-80			⊗	25-50
	4		About 0.75% C	Annealed	270	28						
	5		About 0.75% C	Quenched & Tempered	300	32	⊗	10-35			⊗	6-30
	6	Low alloy steel		Annealed	180	10						
	7			Quenched & Tempered	275	29						
	8			Quenched & Tempered	300	32						
	9			Quenched & Tempered	350	38						
	10		High alloyed steel, and tool steel		Annealed	200	15					
	11			Quenched & Tempered	325	35						
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	⊗	20-50	⊗	12-35	⊗	12-35
	13		Martensitic	Quenched & Tempered	240	23	⊗	20-50	⊗	12-35	⊗	12-35
	14		Austenitic		180	10	○	12-15	○	12-15	○	12-15
K	15	Grey cast iron	Pearlitic / ferritic		180	10						
	16		Pearlitic (Martensitic)		260	26						
	17	Nodular cast iron	Ferritic		160	3						
	18		Pearlitic		250	25						
	19	Malleable cast iron	Ferritic		130							
	20		Pearlitic		230	21						
N	21	Aluminum-wrought alloy	Not Curable		60		⊗	50-65	⊗	50-65	⊗	50-65
	22		Curable	Hardened	100		⊗	50-65	⊗	50-65	⊗	50-65
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	45-90	○	40-65	○	40-65
	24		≤ 12% Si, Curable	Hardened	90		○	45-90	○	40-65	○	40-65
	25		> 12% Si, Not Curable		130							
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		⊗	30-65		⊗	30-65	
	27		CuZn, CuSnZn (Brass)		90		⊗	30-65		⊗	30-65	
	28		CuSn, lead-free copper and electrolytic copper		100							
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic									
	30		Rubber, Wood, etc.									
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15						
	32			Cured	280	30						
	33			Annealed	250	25						
	34			Ni or Co Based	Cured	350	38					
	35			Cast	320	34						
	36	Titanium Alloys	Pure Titanium		400 Rm							
	37		Alpha + Beta Alloys	Hardened	1050 Rm							
H	38	Hardened steel		Hardened	550	55						
	39			Hardened	630	60						
	40	Chilled Cast Iron		Cast	400	42						
	41	Hardened Cast Iron		Hardened	550	55						

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50-80	25-50	50-80	25-50	50-80	25-50	50-80	
50-80	25-50	50-80	25-50	50-80	25-50	50-80	
50-80	25-50	50-80	25-50	50-80	25-50	50-80	
10-35	6-30	10-35	6-30	10-35	6-30	10-35	
20-50	12-35	20-50	12-35	20-50	12-35	20-50	
20-50	12-35	20-50	12-35	20-50	12-35	20-50	
12-15	12-15	12-15	12-15	12-15	12-15	12-15	
50-65	50-65	50-65	50-65	50-65	50-65	50-65	
50-65	50-65	50-65	50-65	50-65	50-65	50-65	
45-90	40-65	45-90	40-65	45-90	40-65	45-90	
45-90	40-65	45-90	40-65	45-90	40-65	45-90	
30-65	30-65	30-65	30-65	30-65	30-65	30-65	
30-65	30-65	30-65	30-65	30-65	30-65	30-65	



Z0 / Z1 / Z2 / Z3 SERIES

Forming Tap Plug & Bottoming Style



A variety of H Limit



Size	T,PI	EDP No.				Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe
		Plug		Bottom			L2	L1	L3	D2	K	KI	
		Bright	TiN	Bright	TiN								
#0 - 80UNF	-	-	Z2022	Z3022	H2	1.634	.315	.512	.141	.110	.190	4	
#0 - 80UNF	-	-	Z2023	Z3023	H3	1.634	.315	.512	.141	.110	.190	4	
#1 - 64UNC	-	-	Z2042	Z3042	H2	1.693	.374	.571	.141	.110	.190	4	
#1 - 72UNF	-	-	Z2062	Z3062	H2	1.693	.374	.571	.141	.110	.190	4	
#1 - 72UNF	-	-	Z2063	Z3063	H3	1.693	.374	.571	.141	.110	.190	4	
#2 - 56UNC	-	-	Z2082	Z3082	H2	1.752	.433	.650	.141	.110	.190	4	
#2 - 56UNC	-	-	Z2083	Z3083	H3	1.752	.433	.650	.141	.110	.190	4	
#2 - 64UNF	-	-	Z2102	Z3102	H2	1.752	.433	.650	.141	.110	.190	4	
#3 - 48UNC	-	-	Z2122	Z3122	H2	1.811	.492	.728	.141	.110	.190	4	
#3 - 48UNC	-	-	Z2123	Z3123	H3	1.811	.492	.728	.141	.110	.190	4	
#3 - 56UNF	-	-	Z2143	Z3143	H3	1.811	.492	.728	.141	.110	.190	4	
#4 - 40UNC	Z0163	Z1163	Z2163	Z3163	H3	1.874	.563	.799	.141	.110	.190	4	
#4 - 40UNC	Z0165	Z1165	Z2165	Z3165	H5	1.874	.563	.799	.141	.110	.190	4	
#4 - 48UNF	Z0183	Z1183	Z2183	Z3183	H3	1.874	.563	.799	.141	.110	.190	4	
#4 - 48UNF	Z0185	Z1185	Z2185	Z3185	H5	1.874	.563	.799	.141	.110	.190	4	
#5 - 40UNC	Z0203	Z1203	Z2203	Z3203	H3	1.937	.626	.882	.141	.110	.190	4	
#5 - 40UNC	Z0205	Z1205	Z2205	Z3205	H5	1.937	.626	.882	.141	.110	.190	4	
#5 - 44UNF	Z0225	Z1225	Z2225	Z3225	H5	1.937	.626	.882	.141	.110	.190	4	
#6 - 32UNC	Z0243	Z1243	Z2243	Z3243	H3	2.000	.480	.689	.141	.110	.190	4	
#6 - 32UNC	Z0245	Z1245	Z2245	Z3245	H5	2.000	.480	.689	.141	.110	.190	4	
#6 - 40UNF	Z0263	Z1263	Z2263	Z3263	H3	2.000	.480	.689	.141	.110	.190	4	
#6 - 40UNF	Z0265	Z1265	Z2265	Z3265	H5	2.000	.480	.689	.141	.110	.190	4	
#8 - 32UNC	Z0283	Z1283	Z2283	Z3283	H3	2.126	.500	.752	.168	.131	.250	4	
#8 - 32UNC	Z0285	Z1285	Z2285	Z3285	H5	2.126	.500	.752	.168	.131	.250	4	

► Hardslick coating is available on your request (Bright Finish EDP No + H)

► NEXT PAGE

ISO Material Description	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel and tool steel					Stainless steel				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	40	42	45	48	50	52	54	56	58	60	62	64	66	68	70
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
ISO Material Description	N										S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	42	41	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended	◎	◎	◎	◎	◎	◎	◎	◎			◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

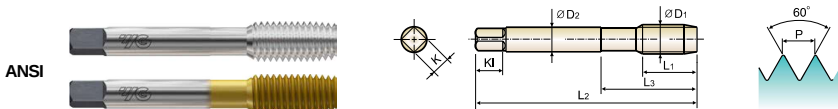
B284 phone:+1-800-765-8665 | Technical Support : 888-868-5988, www.yg1usa.com

YG-1 CO., LTD.



Z0 / Z1 / Z2 / Z3 SERIES

Forming Tap Plug & Bottoming Style



A variety of H Limit



Size	T.PI	EDP No.				Limit	Overall	Thread	Neck	Shank	Square	Square	No. of
		Plug		Bottom			Length	Length	Length	Diameter	Size	Length	
		Bright	TiN	Bright	TiN		L2	L1	L3	D2	K	KI	
#8 - 36UNF		Z0303	Z1303	Z2303	Z3303	H3	2.126	.500	.752	.168	.131	.250	4
#8 - 36UNF		Z0305	Z1305	Z2305	Z3305	H5	2.126	.500	.752	.168	.131	.250	4
#10 - 24UNC		Z0324	Z1324	Z2324	Z3324	H4	2.374	.630	.906	.194	.152	.250	4
#10 - 24UNC		Z0326	Z1326	Z2326	Z3326	H6	2.374	.630	.906	.194	.152	.250	4
#10 - 32UNF		Z0344	Z1344	Z2344	Z3344	H4	2.374	.630	.906	.194	.152	.250	4
#10 - 32UNF		Z0346	Z1346	Z2346	Z3346	H6	2.374	.630	.906	.194	.152	.250	4
#12 - 24UNC		Z0364	Z1364	Z2364	Z3364	H4	2.374	.630	.906	.220	.165	.280	4
#12 - 24UNC		Z0366	Z1366	Z2366	Z3366	H6	2.374	.630	.906	.220	.165	.280	4
1/4 - 20UNC		Z0404	Z1404	Z2404	Z3404	H4	2.500	.858	1.000	.255	.191	.310	4
1/4 - 20UNC		Z0406	Z1406	Z2406	Z3406	H6	2.500	.858	1.000	.255	.191	.310	4
1/4 - 28UNF		Z0424	Z1424	Z2424	Z3424	H4	2.500	.858	1.000	.255	.191	.310	4
1/4 - 28UNF		Z0426	Z1426	Z2426	Z3426	H6	2.720	.858	1.000	.255	.191	.310	4
5/16 - 18UNC		Z0445	Z1445	Z2445	Z3445	H5	2.720	.929	1.126	.318	.238	.380	4
5/16 - 18UNC		Z0447	Z1447	Z2447	Z3447	H7	2.720	.929	1.126	.318	.238	.380	4
5/16 - 24UNF		Z0465	Z1465	Z2465	Z3465	H5	2.720	.929	1.126	.318	.238	.380	4
5/16 - 24UNF		Z0467	Z1467	Z2467	Z3467	H7	2.937	.929	1.126	.318	.238	.380	4
3/8 - 16UNC		Z0485	Z1485	Z2485	Z3485	H5	2.937	.980	1.252	.381	.286	.440	4
3/8 - 16UNC		Z0487	Z1487	Z2487	Z3487	H7	2.937	.980	1.252	.381	.286	.440	4
3/8 - 24UNF		Z0505	Z1505	Z2505	Z3505	H5	2.937	.980	1.252	.381	.286	.440	4
3/8 - 24UNF		Z0507	Z1507	Z2507	Z3507	H7	2.937	.980	1.252	.381	.286	.440	4
7/16 - 14UNC		Z0528	Z1528	Z2528	Z3528	H8	3.157	.949	1.437	.323	.242	.410	4
7/16 - 20UNF		Z0548	Z1548	Z2548	Z3548	H8	3.157	.949	1.437	.323	.242	.410	4
1/2 - 13UNC		Z0565	Z1565	Z2565	Z3565	H5	3.374	1.000	1.594	.367	.275	.440	4
1/2 - 13UNC		Z0568	Z1568	Z2568	Z3568	H8	3.374	1.000	1.594	.367	.275	.440	4

► Hardslick coating is available on your request (Bright Finish EDP No + H)

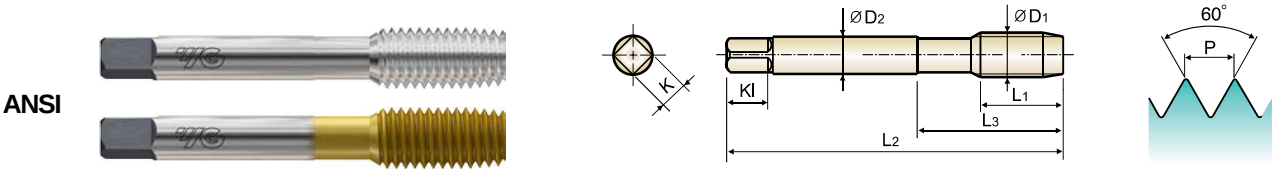
► NEXT PAGE

ISO Material Description	P										M					K					◎ : Excellent ○ : Good							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel					Grey cast iron		Nodular cast iron		Malleable cast iron			
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20								
	HB	13	25	28	32	10	29	32	38	45	55	15	35	15	23	10	26	3	25	21								
	Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎								
ISO Material Description	N										S					H												
	Aluminum-wrought alloy					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials					Heat Resistant Super Alloys					Titanium Alloys		Hardened Steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41							
HRC	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	42	41	55								
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550							
Recommended	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎							



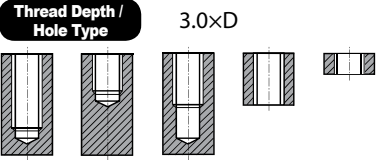
Z0/Z1/Z2/Z3 SERIES

Forming Tap Plug & Bottoming Style



A variety of H Limit

Material groups: GV, HSS-E, UNC UNF, USCTI 302A, 4P~5P Plug, 1.5P~2P Bottoming, Bright, TiN, p.B278



Unit : Inch

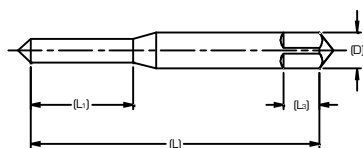
Size	T.PI	EDP No.				Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe
D1		Plug		Bottom			L2	L1	L3	D2	K	KI	
		Bright	TiN	Bright	TiN								
1/2 - 20UNF		Z0585	Z1585	Z2585	Z3585	H5	3.374	1.000	1.594	.367	.275	.440	4
1/2 - 20UNC		Z0588	Z1588	Z2588	Z3588	H8	3.374	1.000	1.594	.367	.275	.440	4
9/16 - 12UNC		Z0607	Z1607	Z2607	Z3607	H7	3.594	1.000	1.657	.429	.322	.500	4
9/16 - 12UNC		Z0600	Z1600	Z2600	Z3600	H10	3.594	1.000	1.657	.429	.322	.500	4
9/16 - 18UNF		Z0628	Z1628	Z2628	Z3628	H8	3.594	1.000	1.657	.429	.322	.500	4
9/16 - 18UNF		Z0620	Z1620	Z2620	Z3620	H10	3.594	1.000	1.657	.429	.322	.500	4
5/8 - 11UNC		Z0648	Z1648	Z2648	Z3648	H8	3.811	1.000	1.811	.480	.360	.560	4
5/8 - 11UNC		Z0640	Z1640	Z2640	Z3640	H10	3.811	1.000	1.811	.480	.360	.560	4
5/8 - 18UNF		Z0660	Z1660	Z2660	Z3660	H10	3.811	1.000	1.811	.480	.360	.560	4
3/4 - 10UNC		Z0700	Z1700	Z2700	Z3700	H10	4.252	1.000	2.000	.590	.442	.690	4
3/4 - 10UNC		Z070B	Z170B	Z270B	Z370B	H12	4.252	1.000	2.000	.590	.442	.690	4
3/4 - 16UNF		Z0728	Z1728	Z2728	Z3728	H8	4.252	1.000	2.000	.590	.442	.690	4
3/4 - 16UNF		Z0720	Z1720	Z2720	Z3720	H10	4.252	1.000	2.000	.590	.442	.690	4

► Hardslick coating is available on your request (Bright Finish EDP No + H)

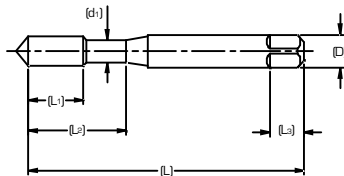
ISO	P										M			K						◎ : Excellent ○ : Good			
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	◎		◎							◎	◎	○									
ISO	N										S							H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC											15	30	25	34	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎	○	○		◎	◎																



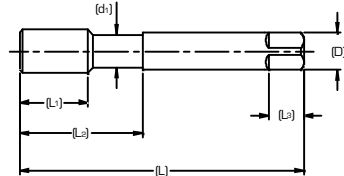
STANDARD FORMING TAP DIMENSION



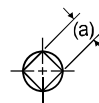
Blank Design (1)



Blank Design (2)



Blank Design (3)



Forming Tap Blank (Inch)

Nominal Size	Overall Length (L)	Thread Length (L ₁)	Neck Length (L ₂)	Shank Diameter (D)	Square Length (L ₃)	Square Size (a)	Blank Design No.
#0	1.63	.31	—	.141	.19	.110	1
#1	1.69	.38	—	.141	.19	.110	1
#2	1.75	.44	—	.141	.19	.110	1
#3	1.81	.50	—	.141	.19	.110	1
#4	1.88	.56	—	.141	.19	.110	1
#5	1.94	.63	—	.141	.19	.110	1
#6	2.00	.48	.69	.141	.19	.110	1
#8	2.13	.50	.75	.168	.25	.131	1
#10	2.38	.63	.88	.194	.25	.152	1
#12	2.38	.63	.94	.220	.28	.165	1
1/4	2.50	.86	1.00	.255	.31	.191	2
5/16	2.72	.93	1.13	.318	.38	.238	2
3/8	2.94	.98	1.25	.381	.44	.286	2
7/16	3.16	.95	1.44	.323	.41	.242	3
1/2	3.38	1.00	1.60	.367	.44	.275	3
9/16	3.59	1.00	1.66	.429	.50	.322	3
5/8	3.81	1.00	1.81	.480	.56	.360	3
3/4	4.25	1.00	2.0	.590	.69	.442	3

Forming Tap Blank (Metric)

Nominal Size	Overall Length (L)	Thread Length (L ₁)	Neck Length (L ₂)	Shank Diameter (D)	Square Length (L ₃)	Square Size (a)	Blank Design No.
M2	1.75	.40	—	.141	.19	.110	1
M3	1.94	.63	—	.141	.19	.110	1
M4	2.13	.50	.75	.168	.25	.131	1
M5	2.38	.63	.88	.194	.25	.152	1
M6	2.50	.86	1.0	.255	.31	.191	2
M8	2.72	.93	1.13	.318	.38	.238	2
M10	2.94	.98	1.25	.381	.44	.286	2
M12	3.38	1.00	1.60	.367	.44	.275	3

THREAD
MILLS

COMBO
TAPS

SPIRAL
FLUTE TAPS

SPIRAL
POINT TAPS

STRAIGHT
FLUTE TAPS

FORMING
TAPS

SCREW
THREAD
INSERT TAPS

PIPE TAPS

TECHNICAL
DATA


TAP DRILL SIZES - UNIFIED THREAD / FORMING TAPS

Size	Threads Per Inch			Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	Min. 2B&3B	Max. 2B	Max. 3B	75% Thread	70% Thread	65% Thread	60% Thread	55% Thread
#0	-	80	-	.0465	.0514	.0514	.0536	.0541	.0545	.0549	.0553
#1	64	-	-	.0561	.0623	.0623	.0650	.0656	.0661	.0666	.0672
	-	72	-	.0580	.0635	.0635	.0659	.0664	.0669	.0673	.0678
#2	56	-	-	.0667	.0737	.0737	.0769	.0775	.0781	.0787	.0793
	-	64	-	.0691	.0753	.0753	.0780	.0786	.0791	.0796	.0802
#3	48	-	-	.0764	.0845	.0845	.0884	.0891	.0898	.0905	.0912
	-	56	-	.0797	.0865	.0865	.0899	.0905	.0911	.0917	.0923
#4	40	-	-	.0849	.0939	.0939	.0993	.1001	.1010	.1018	.1027
	-	48	-	.0894	.0968	.0968	.1014	.1021	.1028	.1035	.1042
#5	40	-	-	.0979	.1062	.1062	.1123	.1131	.1140	.1148	.1157
	-	44	-	.1004	.1079	.1079	.1134	.1142	.1150	.1157	.1165
#6	32	-	-	.1040	.1140	.1140	.1221	.1231	.1242	.1253	.1263
	-	40	-	.1110	.1190	.1186	.1253	.1261	.1270	.1278	.1287
#8	32	-	-	.1300	.1390	.1389	.1481	.1491	.1502	.1513	.1523
	-	36	-	.1340	.1420	.1416	.1498	.1508	.1517	.1527	.1536
#10	24	-	-	.1450	.1560	.1555	.1688	.1702	.1716	.1730	.1744
	-	32	-	.1560	.1640	.1641	.1741	.1751	.1762	.1773	.1783
#12	24	-	-	.1710	.1810	.1807	.1948	.1962	.1976	.1990	.2004
	-	28	-	.1770	.1860	.1857	.1978	.1990	.2002	.2014	.2026
	-	-	32	.1820	.1900	.1895	.2001	.2011	.2022	.2033	.2043
	20	-	-	.1960	.2070	.2067	.2245	.2262	.2279	.2296	.2313
1/4	-	28	-	.2110	.2200	.2190	.2318	.2330	.2342	.2354	.2366
	-	-	32	.2160	.2240	.2229	.2341	.2351	.2362	.2373	.2383
	18	-	-	.2520	.2650	.2630	.2842	.2861	.2879	.2898	.2917
	-	24	-	.2670	.2770	.2754	.2913	.2927	.2941	.2955	.2969
5/16	-	-	-	.2740	.2820	.2807	.2943	.2955	.2967	.2979	.2991
	-	-	32	.2790	.2860	.2847	.2966	.2976	.2987	.2998	.3008
	16	-	-	.3070	.3210	.3182	.3431	.3453	.3474	.3495	.3516
	-	24	-	.3300	.3400	.3372	.3538	.3552	.3566	.3580	.3594
3/8	-	-	-	.3360	.3450	.3426	.3568	.3580	.3592	.3604	.3616
	-	-	32	.3410	.3490	.3469	.3591	.3601	.3612	.3623	.3633
	14	-	-	.3600	.3760	.3717	.4011	.4035	.4059	.4084	.4108
	-	20	-	.3830	.3950	.3916	.4120	.4137	.4154	.4171	.4188
7/16	-	-	28	.3990	.4070	.4051	.4193	.4205	.4217	.4229	.4241
	13	-	-	.4170	.4340	.4284	.4608	.4634	.4660	.4686	.4712
1/2	-	20	-	.4460	.4570	.4537	.4745	.4762	.4779	.4796	.4813
	-	-	28	.4610	.4700	.4676	.4818	.4830	.4842	.4854	.4866
	12	-	-	.4720	.4900	.4843	.5200	.5228	.5257	.5285	.5313
	-	18	-	.5020	.5150	.5106	.5342	.5361	.5379	.5398	.5417
9/16	-	-	24	.5170	.5270	.5244	.5413	.5427	.5441	.5455	.5469
	11	-	-	.5270	.5460	.5391	.5786	.5817	.5848	.5879	.5910
	-	-	-	.5570	.5710	.5662	.5931	.5953	.5974	.5995	.6016
	-	18	-	.5650	.5780	.5730	.5967	.5986	.6004	.6023	.6042
5/8	-	-	24	.5800	.5900	.5869	.6038	.6052	.6066	.6080	.6094
	10	-	-	.6420	.6630	.6545	.6990	.7024	.7058	.7092	.7126
3/4	-	16	-	.6820	.6960	.6908	.7181	.7203	.7224	.7245	.7266
	-	-	20	.6960	.7070	.7037	.7245	.7262	.7279	.7296	.7313

Size	Threads Per Inch			Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	Min. 2B&3B	Max. 2B	Max. 3B	75% Thread	70% Thread	65% Thread	60% Thread	55% Thread
7/8	9	-	-	.7550	.7780	.7681	.8183	.8221	.8259	.8297	.8334
	-	14	-	.7980	.8140	.8068	.8386	.8410	.8434	.8459	.8483
	-	-	20	.8210	.8320	.8287	.8495	.8512	.8529	.8546	.8563
1	8	-	-	.8650	.8900	.8797	.9363	.9405	.9448	.9490	.9533
	-	12	-	.9100	.9280	.9198	.9575	.9603	.9632	.9660	.9688
	-	-	20	.9460	.9570	.9537	.9745	.9762	.9779	.9796	.9813
1-1/8	7	-	-	.9700	.9980	.9875	1.0521	1.0570	1.0619	1.0667	1.0716
	-	12	-	1.0350	1.0530	1.0448	1.0825	1.0853	1.0882	1.0910	1.0938
	-	-	18	1.0650	1.0780	1.0730	1.0967	1.0986	1.1004	1.1023	1.1042
1-1/4	7	-	-	1.0950	1.1230	1.1125	1.1771	1.1820	1.1869	1.1917	1.1966
	-	12	-	1.1600	1.1780	1.1698	1.2075	1.2103	1.2132	1.2160	1.2188
	-	-	18	1.1900	1.2030	1.1980	1.2217	1.2236	1.2254	1.2273	1.2292