

Tap and Drill Bit Selection Guide

American Standards and Unified Form Threads Tap drill size is approximately 75% of thread depth.

Thread Nominal Size	Standard	Drill Size	Decimal
0-80	NF	3/64"	.0469"
1-64	NC	53	.0595"
1-72	NF	53	.0595"
2-56	NC	50	.0700"
2-64	NF	50	.0700"
3-48	NC	47	.0785"
3-56	NF	45	.0820"
4-40	NC-UNC	43	.0890"
4-48	NF	42	.0935"
5-40	NC	38	.1015"
5-44	NF	37	.1040"
6-32	NC-UNC	36	.1065"
6-40	NF	33	.1130"
8-32	NC-UNC	29	.1360"
8-36	NF	29	.1360"
10-24	NC-UNC	25	.1495"
10-32	NF-UNF	21	.1590"
3/16--24	NS	26	.1470"
3/16--32	NS	22	.1570"
12-24	NC	16	.1770"
12-28	NF	14	.1820"
14-20	NS	10	.1935"
1/4--20	NC-UNC	7	.2010"
1/4--28	NF-UNF	3	.2130"
5/16--18	NC-UNC	F	.2570"
5/16--24	NF-UNF	I	.2720"
3/8--16	NC-UNC	5/16"	.3125"
3/8--24	NF-UNF	Q	.3320"
7/16--14	NC-UNC	U	.3680"
7/16--20	NF-UNF	25/64"	.3906"
1/2--13	NC-UNC	27/64"	.4219"
1/2--20	NF-UNF	29/64"	.4531"
9/16--12	NC-UNC	31/64"	.4844"
9/16--18	NF-UNF	33/64"	.5156"
5/8--11	NC-UNC	17/32"	.5312"
5/8--18	NF-UNF	37/64"	.5781"
3/4--10	NC-UNC	21/32"	.6562"
3/4--16	NF-UNF	11/16"	.6875"
7/8--9	NC-UNC	49/64"	.7656"
7/8--14	NF-UNF	13/16"	.8125"
1-8	NC-UNC	7/8"	.8750"
1-14	NS	15/16"	.9375"
1-1/8--7	NC-UNC	63/64"	.9844"

Thread Nominal Size	Standard	Drill Size	Decimal
1-1/8--12	NF-UNF	1-3/64"	1.0469"
1-1/4--7	NC-UNC	1-7/64"	1.1094"
1-1/4--12	NF-UNF	1-11/64"	1.1719"
1-3/8--6	NC-UNC	1-7/32"	1.2188"
1-3/8--12	NF-UNF	1-19/64"	1.2969"
1-1/2--6	NC-UNC	1-11/32"	1.3438"
1-1/2--12	NF-UNF	1-27/64"	1.4219"
1-3/4--5	NC-UNC	1-9/16"	1.5625"
2--4-1/4	NC-UNC	1-25/32"	1.7813"
2-1/4--4 1/2	NC-UNC	2-1/32"	2.0313"
2-1/2--4	NC-UNC	2-1/4"	2.2500"
2-3/4--4	NC-UNC	2-1/2"	2.5000"
3-4	NC-UNC	2-3/4"	2.7500"
3-1/4--4	NC-UNC	3"	3.0000"
3-1/4--4	NC-UNC	3-1/4"	3.2500"
3-3/4--4	NC-UNC	3-1/2"	3.5000"
4-4	NC-UNC	3-3/4"	3.7500"

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Metric Thread

French International Standard (D.I.N.)			
Tap Size	Standard	Drill Size	Decimal
2.5-.45	French	5/64"	.0781"
2.6-.45	D.I.N.	#45	.0820"
3-.50	D.I.N.	#40	.0980"
3-.60	French	#39	.0995"
3-.75	Optional	#43	.8090"
3.5-.60	French & D.I.N.	#33	.1130"
4-.70	D.I.N.	1/8"	.1250"
4-.75	French	1/8"	.1250"
4.5-.75	French & D.I.N.	#26	.1470"
5-.75	Optional	#19	.1660"
5-.80	D.I.N.	11/64"	.1719"
5-.90	French	#20	.1610"
5-1.00	Optional	5/32"	.1563"
5.5-.75	Optional	3/16"	.1875"
5.5-.90	French & D.I.N.	#14	.1820"
6-1.00	French & D.I.N.	13/64"	.2031"
6-1.25	Optional	3/16"	.1875"
7-1.00	French & D.I.N.	15/64"	.2344"
7-1.25	Optional	#1	.2280"
8-1.00	French	J	.2770"
8-1.25	D.I.N.	17/64"	.2656"
9-1.00	French	5/16"	.3125"
9-1.25	D.I.N.	5/16"	.3125"
10-1.00	Optional	23/64"	.3594"
10-1.25	Optional	11/32"	.3437"
10-1.50	French & D.I.N.	11/32"	.3437"
11-1.50	D.I.N.	3/8"	.3750"
12-1.25	Optional	7/16"	.4375"
12-1.50	French	13/32"	.4063"
12-1.75	D.I.N.	27/64"	.4219"
12-1.75	Optional	29/64"	.4531"
13-1.50	Optional	29/64"	.4531"
13-2.00	Optional	7/16"	.4375"
14-1.25	Optional	33/64"	.5156"
14-1.75	Optional	1/2"	.5000"
14-2.00	French & D.I.N.	15/32"	.4687"
15-1.75	Optional	17/32"	.5313"
15-2.00	Optional	33/64"	.5156"
16-1.50	Optional	37/64"	.5781"
16-2.00	French & D.I.N.	35/64"	.5469"
17-2.00	Optional	19/32"	.5937"
18-1.50	Optional	21/32"	.6563"

Taper Pipe- for tapping without reaming

Thread	Drill	Thread	Drill	Thread	Drill
1/16"	D	3/4"	59/64"	2-1/2"	2-5/8"
1/8"	R	1"	1-5/32"	3"	3-1/4"
1/4"	7/16"	1-1/4"	1-1/2"	3-1/2"	3-3/34"
3/8"	37/64"	1-1/2"	1-47/64"	4"	4-1/4"
1/2"	45/64"	2"	2-7/32"	-	-

Straight Pipe

Thread	Drill	Thread	Drill	Thread	Drill
1/16"	1/4"	1/2"	23/32"	1-1/2"	1-3/4"
1/8"	11/32"	3/4"	59/64"	2"	2-7/32"
1/4"	7/16"	1"	1-5/32"	2-1/2"	2-21/32"
3/8"	37/64"	1-1/4"	1-1/2"	-	-