



Detroit Area: 248.548.0050 Fax: 248.548.0010 Toll Free: 800.334.1660 Fax: 800.88.AMTEK

RIGHT TOOL. RIGHT TIME. RIGHT PRICE.

Decimal Equivalents and Tap Sizes of Fraction, Number, Letter and Metric Sizes
Recommended tap drill sizes for approximately 75% depth of thread

Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes	Sizes	Decimal Inches	Tap Sizes
.15mm	0.0059		58	0.0420		27	0.1440		H	0.2660		17/32	0.5312	5/8-11
.16mm	0.0063		57	0.0430		3.7mm	0.1457		6.8mm	0.2677		13.5mm	0.5315	
.17mm	0.0067		1.1mm	0.0433		26	0.1470	3/16-24NS	6.9mm	0.2717		35/64	0.5469	
.18mm	0.0071		1.15mm	0.0453		3.75mm	0.1476	m4.5x0.75	I	0.2720	5/-16-24NF	14mm	0.5512	m16x2
.19mm	0.0075		56	0.0465		25	0.1495	#10-24	7mm	0.2756	m8x1	9/16	0.5625	
.2mm	0.0079		3/64	0.0469	#0-80	3.8mm	0.1496		J	0.2770		14.5mm	0.5709	m16x1.50
.21mm	0.0083		1.2mm	0.0472		24	0.1520		7.1mm	0.2795		37/64	0.5781	3/8-18NPT PIPE
.22mm	0.0087		1.25mm	0.0492	m1.6x.35	3.9mm	0.1535		K	0.2810		15mm	0.5906	
.23mm	0.0091		1.3mm	0.0512		23	0.1540		9/32	0.2812	5/16-32NS	19/32	0.5938	3/8-18NPS PIPE
.24mm	0.0095		55	0.0520		5/32	0.1562		7.2mm	0.2835		39/64	0.6094	
.25mm	0.0098		1.35mm	0.0531		22	0.1570	3/16-32NS	7.25mm	0.2854		15.5mm	0.6102	m18x2.5
.26mm	0.0102		54	0.0550		4mm	0.1575		7.3mm	0.2874		5/8	0.6250	11/16-16NS
.27mm	0.0106		1.4mm	0.0551		21	0.1590	#10-32	L	0.2900		16mm	0.6299	m18x2.0
.28mm	0.0110		1.45mm	0.0571	m1.8x0.35	20	0.1610		7.4mm	0.2913		41/64	0.6406	
.29mm	0.0114		1.5mm	0.0591		4.1mm	0.1614		M	0.2950		16.5mm	0.6496	
.3mm	0.0118		53	0.0595	#1-64,72	4.2mm	0.1654	m5x0.8	7.5mm	0.2953		21/32	0.6562	3/4-10NC
.31mm	0.0122		1.55mm	0.0610		19	0.1660		19/64	0.2969		17mm	0.6693	
.32mm	0.0126		1/16	0.0625		4.25mm	0.1673		7.6mm	0.2992		43/64	0.6719	
.33mm	0.0130		1.6mm	0.0630	m2x0.4	4.3mm	0.1693		N	0.3020		11/16	0.6875	3/4-16NF
.34mm	0.0134		52	0.0635		18	0.1695		7.7mm	0.3031		17.5mm	0.6890	m20x2.5
.35mm	0.0138		1.65mm	0.0650		11/64	0.1719		7.75mm	0.3051	m9x1.25	45/64	0.7031	
.36mm	0.0142		1.7mm	0.0669		17	0.1730		7.8mm	0.3071		18mm	0.7087	m20x2.0
.37mm	0.0146		51	0.0670	#2-56	4.4mm	0.1732		7.9mm	0.3110		23/32	0.7188	1/2-14NPT PIPE
.38mm	0.0150		1.75mm	0.0689	m2.2x0.45	16	0.1770	#12-24	5/16	0.3125	3/8-16NC	18.5mm	0.7283	m20x1.5
.39mm	0.0154		50	0.0700	#2-64	4.5mm	0.1772		8mm	0.3150		47/64	0.7344	1/2-14NPS PIPE
.4mm	0.0157		1.8mm	0.0709		15	0.1800		O	0.3160		19mm	0.7480	
.41mm	0.0161		1.85mm	0.0728		4.6mm	0.1811		8.1mm	0.3189		3/4	0.7500	
.42mm	0.0165		49	0.0730		14	0.1820	#12-28	8.2mm	0.3228		49/64	0.7656	7/8-9NC
.43mm	0.0169		1.9mm	0.0748	m2.3x0.4	13	0.1850		P	0.3230		19.5mm	0.7677	m22x2.5
.44mm	0.0173		48	0.0760		4.7mm	0.1850		8.25mm	0.3248		25/32	0.7812	
.45mm	0.0177		1.95mm	0.0768		4.75mm	0.1870		8.3mm	0.3268		20mm	0.7874	m22x2.0
.46mm	0.0181		5/64	0.0781		3/16	0.1875		21/64	0.3281		51/64	0.7969	
.47mm	0.0185		47	0.0785	#3-48	4.8mm	0.1890		8.4mm	0.3307		20.5mm	0.8071	m22x1.5
.48mm	0.0189		2mm	0.0787		12	0.1890	7-32-32NS	Q	0.3320	3/8-24NF	13/16	0.8125	7/8-14NF
.49mm	0.0193		2.05mm	0.0807	m2.5x0.45	11	0.1910		8.5mm	0.3346	m10x1.5	21mm	0.8268	m24x3
.5mm	0.0197		46	0.0810		4.9mm	0.1929		8.6mm	0.3386		53/64	0.8281	
.51mm	0.0201		45	0.0820	#3-56	10	0.1935		R	0.3390	1/8-27NPS PIPE	27/32	0.8438	
.52mm	0.0205		2.1mm	0.0827		9	0.1960		8.7mm	0.3425		21.5mm	0.8465	
.53mm	0.0209		2.15mm	0.0846	m2.6x0.45	5mm	0.1969	m6x1	11/32	0.3438		55/64	0.8594	
.54mm	0.0213		44	0.0860	#4-36	8	0.1990		8.75mm	0.3445	m10x1.25	22mm	0.8661	m24x2
.55mm	0.0217		2.2mm	0.0866		5.1mm	0.2008		8.8mm	0.3465		7/8	0.8750	1-8NC
.56mm	0.0221		2.25mm	0.0886		7	0.2010	1/4-20	S	0.3480	1/8-27NPS PIPE	22.25mm	0.8760	
.57mm	0.0225		43	0.0890	#4-40	13/64	0.2031		8.9mm	0.3504		22.5mm	0.8858	m24x1.50
.58mm	0.0229		2.3mm	0.0906		6	0.2040		9mm	0.3543	m10x1.00	57/64	0.8906	
.59mm	0.0233		2.35mm	0.0925		5.2mm	0.2047		T	0.3580		23mm	0.9055	
.6mm	0.0236		42	0.0935	#4-48	5	0.2055		9.1mm	0.3583		29/32	0.9062	
.61mm	0.0240		3/32	0.0938		5.25mm	0.2067	m6x0.75	23/64	0.3594		59/64	0.9219	3/4-14NPT PIPE
.62mm	0.0244		2.4mm	0.0945		5.3mm	0.2087		9.2mm	0.3622		23.5mm	0.9252	
.63mm	0.0248		41	0.0960		4	0.2090	1/4-24	9.25mm	0.3642		15/16	0.9375	3/4-14NPS PIPE
.64mm	0.0252		2.45mm	0.0965		5.4mm	0.2126		9.3mm	0.3661		24mm	0.9449	m27x3
.65mm	0.0256		40	0.0980		3	0.2130	1/4-28	U	0.3680	7/16-14NC	61/64	0.9531	
.66mm	0.0260		2.5mm	0.0984	m3x0.5	5.5mm	0.2165		9.4mm	0.3701		24.5mm	0.9646	
.67mm	0.0264		39	0.0995		7/32	0.2188		9.5mm	0.3740	m11x1.50	31/32	0.9688	
.68mm	0.0268		38	0.1015	#5-40	5.6mm	0.2205		3/8	0.3750		25mm	0.9843	m27x2
.69mm	0.0272		2.6mm	0.1024		2	0.2210		V	0.3770		63/64	0.9844	1-1/8-7NC
.7mm	0.0276		37	0.1040	#5-44	5.7mm	0.2244		9.6mm	0.3780		1	1.0000	
.71mm	0.0280		2.7mm	0.1063		5.75mm	0.2264		9.7mm	0.3819		25.5mm	1.0039	
.72mm	0.0284		36	0.1065	#6-32	1	0.2280		9.75mm	0.3839		1-1/4	1.0156	
.73mm	0.0288		2.75mm	0.1083		5.8mm	0.2283		9.8mm	0.3858		26mm	1.0236	
.74mm	0.0292		7/64	0.1094		5.9mm	0.2323		W	0.3860		1-1/32	1.0312	
.75mm	0.0296		35	0.1100		A	0.2340		9.9mm	0.3898		26.5mm	1.0433	
.76mm	0.0300		2.8mm	0.1102		15/64	0.2344		25/64	0.3906	7/16-20	1-3/64	1.0469	1-1/8-12NF
.77mm	0.0304		34	0.1110		6mm	0.2362	m7x1	10mm	0.3937	m12x1.75	1-1/16	1.0625	
.78mm	0.0308		33	0.1130	#6-40	B	0.2380		X	0.3970		27mm	1.0630	
.79mm	0.0312		2.9mm	0.1142	m3.5x0.6	6.1mm	0.2402		Y	0.4040		1-5/64	1.0781	
.8mm	0.0316		32	0.1160		C	0.2420		13/32	0.4062		27.5mm	1.0827	
.81mm	0.0320		3mm	0.1181		6.2mm	0.2441		Z	0.4130		1-3/32	1.0938	
.82mm	0.0324		31	0.1200		D	0.2460	1/16-27NPT PIPE	10.5mm	0.4134	m12x1.25	28mm	1.1024	m30x2.0
.83mm	0.0328		3.1mm	0.1220		6.25mm	0.2461		27/64	0.4219	1/2-13	1-7/64	1.1094	1-1/4-7NC
.84mm	0.0332		1/8	0.1250	5/32-32NS	6.3mm	0.2480		11mm	0.4331		28.5mm	1.1220	
.85mm	0.0336		3.2mm	0.1260		E	0.2500		7/16	0.4375	1/4-18NPT PIPE	1-1/8	1.1250	
.86mm	0.0340		3.25mm	0.1280		1/4	0.2500	1/16-27NPT PIPE	11.5mm	0.4528		1-9/64	1.1406	
.87mm	0.0344		30	0.1285	5/32-36NS	6.4mm	0.2520		29/64	0.4531	1/4-18NPT PIPE	29mm	1.1417	
.88mm	0.0348		3.3mm	0.1299	m4x0.7	6.5mm	0.2559		15/32	0.4688		1-5/32	1.1562	1-11/2 NPT PIPE
.89mm	0.0352		3.4mm	0.1339		F	0.2570	5/16-18NC	12mm	0.4724	m14x2	29.5mm	1.1614	
.9mm	0.0356		29	0.1360	#8-32	6.6mm	0.2598		31/64	0.4844	9/16-12	1-11/64	1.1719	1-1/4-12NF
.91mm	0.0360		3.5mm	0.1378		G	0.2610		12.5mm	0.4921	m14-1.5			
.92mm	0.0364		28	0.1405		6.7mm	0.2638		1/2	0.5000				
.93mm	0.0368		9/64	0.1406		17/64	0.2656		13mm	0.5118	m14x1.25			
.94mm	0.0372		3.6mm	0.1417		6.75mm	0.2657	m8x1.25	33/64	0.5156	9/16-18			

Formula for Obtaining Tap Drill Sizes for Cutting Tap:
Major Diam. .01259 X Amt. of percentage of full thread = Drill
of thread # of threads per Size
Note: Select nearest commercial stock drill