



FOR CUTTING & FORMING TAPS TAP DRILL RECOMMENDATIONS



Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
0-80		3/64	0.469	54	0.950
	M1.6 x 0.35	1.25	0.490	1.45	0.671
1-64		1.45	0.671	1.65	0.650
	M1.6 x 0.35	53	0.690	51	0.670
1-72		53	0.690	51	0.670
	M2 x 0.40	1.80	0.630	1.80	0.709
2-56		50	0.700	5/64	0.781
	M2 x 0.45	50	0.700	47	0.785
2-64		1.75	0.649	2.00	0.787
	M2.5 x 0.45	2.05	0.807	2.30	0.908
3-48		47	0.785	43	0.890
	M2.5 x 0.45	46	0.810	3.30	0.900
3-56		43	0.890	38	1.015
		42	0.905	2.80	1.024
4-40		2.50	0.954	2.84	1.094
	M3 x 0.50	38	1.015	33	1.130
5-44		37	1.040	2.90	1.142
	M3.5 x 0.60	2.80	1.142	3.20	1.280
6-32		36	1.065	3.8	1.250
		33	1.130	3.25	1.280
6-40		3.30	1.299	3.70	1.478
	M4 x 0.70	29	1.360	29	1.495
8-36		29	1.360	24	1.520
	M4.5 x 0.75	3.75	1.478	4.10	1.614
10-24		28	1.470	11/64	1.719
		21	1.580	18	1.770
10-32		4.20	1.654	14	1.820
	M5 x 0.80	18	1.770	8	1.990
12-24		18	1.800	7	2.010
		15	1.900	7	2.188
12-28		5.00	1.969	7/32	2.188
	M6 x 1.00	7	2.010	1	2.280
1/4-20		3	2.130	15/64	2.340
		3	2.360	F	2.570
1/4-28		5.00	2.360	L	2.900
	M7 x 1.00	F	2.570	M	2.900
5/16-18		1	2.720	M	2.900
		1	2.720	M	2.900
5/16-24		8.70	2.638	7/40	2.913
	M8 x 1.25	7.00	2.758	15/64	2.968
3/8-16		5/16	3.125	5	3.480
		O	3.320	T	3.690
3/8-24		8.50	3.348	12	3.680
	M10 x 1.50	8.70	3.425	9.40	3.701
3/16-14		U	3.690	V	4.040
		25/64	3.608	Z	4.130
3/16-20		10.20	4.018	11.20	4.409
	M12 x 1.75	10.80	4.252	11.50	4.528
1/2-13		27/64	4.219	15/32	4.692
		29/64	4.531	12.25	4.820
1/2-20		12.00	4.724	13/64	5.158
	M14 x 2.00	12.00	4.844	17/32	5.312
9/16-12		33/64	5.158	13.50	5.315
9/16-18		33/64	5.158	13.50	5.315

Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
5/8-11		17/32	5.312	14.75	5.807
		37/64	5.781	15.25	6.004
5/8-18		14.00	5.512	15.02	6.008
	M18 x 2.50	14.00	5.709	15.25	6.004
3/4-10		15.50	6.102	15.25	6.004
	M18 x 2.50	15.50	6.496	17.25	6.791
3/4-16		17/32	6.562	15.54	7.021
		17/32	6.875	23/32	7.188
3/4-20		17.50	6.890	"	"
	M20 x 2.50	18.50	7.280	"	"
3/4-24		19.50	7.671	"	"
	M22 x 1.50	20.50	8.071	"	"
7/8-9		49/64	7.656	"	"
		12/16	8.125	"	"
7/8-14		21.00	8.268	"	"
	M24 x 2.00	22.00	8.661	"	"
1-8		7/8	8.750	"	"
		35/64	9.219	"	"
1-12		34/64	9.449	"	"
	M27 x 3.00	24.00	9.843	"	"
1-16		25.00	9.843	"	"
	M27 x 2.00	25.00	10.444	"	"
1 1/8-7		1 3/64	1.0489	"	"
	1 1/8-12	M30 x 3.50	26.50	1.0430	"
1 1/8-12		26.50	1.1024	"	"
	M30 x 2.00	26.50	1.1094	"	"
1 1/4-7		1 7/64	1.1094	"	"
	1 1/4-12	1 15/64	1.1719	"	"
1 1/4-12		29.50	1.1814	"	"
	M33 x 3.50	29.50	1.2206	"	"
1 1/4-12		31.00	1.2188	"	"
	M33 x 2.00	31.00	1.2989	"	"
1 3/8-6		1 7/32	1.2989	"	"
	1 3/8-12	1 15/64	1.2989	"	"
1 3/8-12		32.00	1.2990	"	"
	M36 x 4.00	32.00	1.2992	"	"
1 1/2-6		1 11/32	1.3438	"	"
	1 1/2-12	1 27/64	1.4219	"	"
1 1/2-12		36.00	1.3780	"	"
	M39 x 4.00	36.00	1.4173	"	"

PIPE TAPS: NPT, NPTF, NPSM, NPSC, NPSP

Nominal Pipe Tap Size	NPT & NPTF					NPSM
	Metric Equivalent	WSS Equivalent	NPSM	NPSC	NPSP	
1/16-27	C (1.412)	A (1.234)	—	—	290	C (1.248)
1/8-27	C (1.332)	2.184	T (1.368)	C (1.302)	—	H (1.308)
1/4-18	7.18	2.784	7.532	7.18	—	7.18
3/8-18	9.78	3.784	9.532	3.784	—	3.784
1/2-14	45.84	13.18	13.2 mm	13.2 mm	—	13.2 mm
3/4-14	29.82	2.784	2.784	2.784	—	2.784
1-11 1/2	1.644	1.18	1.18	1.18	—	1.18
1 1/4-11 1/2	1.314	1.182	1.182	1.182	—	1.182
1 1/2-11 1/2	1.232	1.454	1.252	1.474	—	1.474
2-11 1/2	2.318	2.184	2.184	2.184	—	2.184

■ METRIC
 ■ FRACTIONAL
 ■ WIRE GAGE
 ■ LETTER SIZE

Machine Tapping Guide

Sebastian Brünink



Machine Tapping Guide:

Reviewing **Machine Tapping Guide**: Unlocking the Spellbinding Force of Linguistics

In a fast-paced world fueled by information and interconnectivity, the spellbinding force of linguistics has acquired newfound prominence. Its capacity to evoke emotions, stimulate contemplation, and stimulate metamorphosis is actually astonishing. Within the pages of "**Machine Tapping Guide**," an enthralling opus penned by a highly acclaimed wordsmith, readers embark on an immersive expedition to unravel the intricate significance of language and its indelible imprint on our lives. Throughout this assessment, we shall delve in to the book is central motifs, appraise its distinctive narrative style, and gauge its overarching influence on the minds of its readers.

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