



# 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	0.650
	M1.6 x 0.35	1.25	0.492	1.45	0.671
	M1.6 x 0.35	1.45	0.671	1.65	0.650
1-64		53	0.695	51	0.670
1-72		53	0.695	51	0.670
	M2 x 0.40	1.80	0.630	1.80	0.709
2-56		50	0.700	48	0.751
2-64		50	0.700	47	0.735
	M2.2 x 0.45	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
3-56		46	0.810	3.30	0.900
4-40		43	0.890	39	1.015
4-48		42	0.905	2.80	1.024
	M3 x 0.50	2.50	0.954	2.84	1.094
5-40		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
6-40		33	1.130	3.25	1.280
	M4 x 0.70	3.30	1.299	3.70	1.478
8-32		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		26	1.470	11.64	1.719
10-32		21	1.580	16	1.770
	M5 x 0.80	4.20	1.654	14	1.820
12-24		18	1.770	8	1.990
12-28		18	1.800	7	2.010
	M6 x 1.00	5.00	1.969	7.32	2.188
1/4-20		7	2.010	1	2.080
1/4-28		3	2.130	15.64	2.340
	M7 x 1.00	6.00	2.362	F	2.570
5/16-18		F	2.570	L	2.900
5/16-24		L	2.720	M	2.900
	M8 x 1.25	6.70	2.638	7.40	2.913
	M8 x 1.00	7.00	2.756	16.64	2.969
3/8-16		9.75	3.125	S	3.480
3/8-24		O	3.320	T	3.680
	M10 x 1.50	8.50	3.348	9.40	3.701
	M10 x 1.25	8.70	3.425	9.40	4.040
		U	3.690	V	4.130
7/16-14		11.64	3.608	Z	4.130
7/16-20		10.20	4.018	11.20	4.429
	M12 x 1.75	10.20	4.252	11.50	4.529
	M12 x 1.25	10.80	4.252	15.72	4.692
		23.64	4.219	12.25	4.620
1/2-13		20.64	4.531	12.25	5.158
1/2-20		12.00	4.724	23.64	5.312
9/16-12		23.64	4.844	17.72	5.312
9/16-18		23.64	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		17.00	5.312	14.75	5.807
5/8-18		20.64	5.312	15.25	6.004
	M18 x 2.50	14.00	5.512	19.72	6.568
	M18 x 1.50	14.50	5.709	15.25	6.004
	M18 x 2.50	15.50	6.102	20.64	6.094
	M18 x 1.50	16.50	6.496	17.25	6.791
3/4-10		21.00	6.562	25.64	7.251
3/4-16		17.75	6.875	23.72	7.168
	M20 x 2.50	17.50	6.890	"	"
	M20 x 1.50	18.50	7.283	"	"
	M20 x 2.50	19.50	7.677	"	"
	M22 x 1.50	20.50	8.071	"	"
7/8-9		24.64	7.658	"	"
7/8-14		19.75	8.125	"	"
	M24 x 3.00	21.00	8.268	"	"
	M24 x 2.00	22.00	8.661	"	"
1-8		27.8	8.750	"	"
1-12		30.64	9.219	"	"
	M27 x 3.00	24.00	9.449	"	"
	M27 x 2.00	25.00	9.843	"	"
1 1/8-7		35.64	9.844	"	"
1 1/8-12		1 3/64	1.0490	"	"
	M30 x 3.00	26.50	1.0430	"	"
	M30 x 2.00	28.50	1.1024	"	"
1 1/4-7		1 7/64	1.1094	"	"
1 1/4-12		1 15/64	1.1719	"	"
	M33 x 3.00	29.50	1.1614	"	"
	M33 x 2.00	31.00	1.2206	"	"
1 3/8-6		1 7/32	1.2188	"	"
1 3/8-12		1 19/64	1.2969	"	"
	M36 x 4.00	32.00	1.2990	"	"
	M36 x 3.00	33.00	1.2990	"	"
1 1/2-6		1 11/32	1.3438	"	"
1 1/2-12		1 27/64	1.4219	"	"
	M39 x 4.00	34.00	1.3780	"	"
	M39 x 3.00	35.00	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	9.78	9.52	9.78	—	9.78
1/2-14	12.54	13.18	13.0	13.0 mm	13.0 mm	13.0 mm
3/4-14	20.62	21.64	21.64	20.64	—	20.64
1-11 1/2	1 6/64	1.18	1 13/64	1 5/32	—	1 5/32
1 1/4-11 1/2	1 31/64	1 39/32	1 39/64	1 1/2	—	—
1 1/2-11 1/2	1 23/32	1 45/64	1 25/32	1 47/64	—	—
2-11 1/2	2 3/16	2 1/8	2 1/4	2 13/64	—	—

■ METRIC    
 ■ FRACTIONAL    
 ■ WIRE GAGE    
 ■ LETTER SIZE

# Machine Tapping Guide

**Richard Bailey**



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