

TAP / DRILL SIZES

American Std. and Unified Form Threads							
Tap Drill Size is approximately 75% Thread							
THREAD NOMINAL SIZE	Pitch Series	DRILL		THREAD NOMINAL SIZE	Pitch Series	DRILL	
		SIZE	DECIMAL			SIZE	DECIMAL
0-80	NF	3/64	.047	9/16-12	NC-UNC	31/64	.484
1-64	NC	53	.060	18	NF-UNF	33/64	.516
72	NF	53	.060	5/8-11	NC-UNC	17/32	.531
2-56	NC	50	.070	18	NF-UNF	37/64	.578
64	NF	50	.070	3/4-10	NC-UNC	21/32	.656
3-48	NC	47	.079	16	NF-UNF	11/16	.688
56	NF	45	.082	7/8-9	NC-UNC	49/64	.766
4-40	NC-UNC	43	.089	14	NF-UNF	13/16	.813
48	NF	42	.094	1-8	NC-UNC	7/8	.875
5-40	NC	38	.102	14	NS	15/16	.938
44	NF	37	.104	1 1/8-7	NC-UNC	63/64	.984
6-32	NC-UNC	36	.107	12	NF-UNF	13/64	1.047
40	NF	33	.113	1 1/4-7	NC-UNC	17/64	1.109
8-32	NC-UNC	29	.136	12	NF-UNF	111/64	1.172
36	NF	29	.136	1 3/8-6	NC-UNC	17/32	1.219
10-24	NC-UNC	25	.150	12	NF-UNF	119/64	1.297
32	NF-UNF	21	.159	1 1/2-6	NC-UNC	111/32	1.344
12-24	NC	16	.177	12	NF-UNF	127/64	1.422
28	NF	14	.182	1 3/4-5	NC-UNC	19/16	1.563
1/4-20	NC-UNC	7	.201	2 4 1/2	NC-UNC	125/32	1.781
28	NF-UNF	3	.213	2 1/4-4 1/2	NC-UNC	21/32	2.031
5/16-18	NC-UNC	F	.257	2 1/2-4	NC-UNC	2 1/4	2.250
24	NF-UNF	I	.272	2 3/4-4	NC-UNC	2 1/2	2.500
3/8-16	NC-UNC	5/16	.313	3-4	NC-UNC	2 3/4	2.750
24	NF-UNF	Q	.332	3 1/4-4	NC-UNC	3	3.000
7/16-14	NC-UNC	U	.368	3 1/4-4	NC-UNC	3 1/4	3.250
20	NF-UNF	25/64	.391	3 3/4-4	NC-UNC	3 1/2	3.500
1/2-13	NC-UNC	27/64	.422	4-4	NC-UNC	3 3/4	3.750
20	NF-UNF	29/64	.453				

METRIC THREADS

French and International Standard (D.I.N.)			
TAP SIZE	STD.	DRILL	
		STD.	DC.
2.5-45	French	5/64	.0781
2.6-45	D.I.N.	#45	.082
3-50	D.I.N.	#39	.0995
.60	French	3/32	.0937
.75	Optional	#43	.089
3.5-60	French & D.I.N.	#33	.113
4-.70	D.I.N.	#30	.1285
-.75	French	1/8	.125
4.5-75	French & D.I.N.	#26	.147
5-.75	Optional	#19	.166
.80	D.I.N.	#19	.166
.90	French	#20	.161
1.00	Optional	5/32*	.156
5.5-75	Optional	3/16	.1875
.90	French & D.I.N.	#14	.182
6-1.00	French & D.I.N.	#9	.196
1.25	Optional	3/16	.1875
7-1.00	French & D.I.N.	15/64	.234
1.25	Optional	#1	.228
8-1.00	French	J	.277
1.25	D.I.N.	17/64	.265
9-1.00	French	5/16	.3125
1.25	D.I.N.	5/16	.3125
10-1.00	Optional	23/64	.359
1.25	Optional	11/32	.3437
1.50	French & D.I.N.	R	.339
11-1.50	D.I.N.	3/8	.375
12-1.25	Optional	7/16	.4375
1.50	French	13/32	.406
1.75	D.I.N.	13/32	.406
13-1.50	Optional	29/64	.453
1.75	Optional	29/64	.453
2.00	Optional	7/16	.4375
14-1.25	Optional	33/64	.5156
1.75	Optional	1/2	.500
2.00	French & D.I.N.	15/32	.4687
15-1.75	Optional	17/32	.531
2.00	Optional	33/64	.5156
16-2.00	French & D.I.N.	35/64	.5468
17-2.00	Optional	19/32	.5937
18-1.50	Optional	21/32	.656
1/8-28	BSP	21/64	.3281

*TAPER PIPE

THREAD	DRILL
1/16"	D
1/8	R
1/4	7/16
3/8	37/64
1/2	45/64
3/4	59/64
1	15/32
1 1/4	1 1/2

*TAPER PIPE

THREAD	DRILL
1 1/2	1 1/2
2	2 1/2
2 1/2	2 5/8
3	3 1/4
3 1/2	3 3/4
4	4 1/4

*For tapping
without reaming

STRAIGHT PIPE

THREAD	DRILL
1/16	1/4
1/8	1 1/32
1/4	7/16
3/8	37/64
1/2	23/32
3/4	59/64
1	15/32
1 1/4	1 1/2
1 1/2	1 3/4
2	2 1/2
2 1/2	2 21/32

MAGNA

PROFESSIONAL TOOLS

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ELIZABETHTOWN, KY 42701 U.S.A.

0204059034



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