



Standard Tap & Drill
Approximately 75% Thread

Thread Size	Drill Size
0-80	3/64
1-64	53
1-72	53
2-56	50
2-64	50
3-48	47
3-56	46
4-40	43
4-48	3/32
5-40	38
5-44	37
6-32	36
6-40	33
8-32	29
8-36	29
10-24	25
10-32	21
12-24	17
12-28	15
1/4-20	7
1/4-28	3
5/16-18	F
5/16-24	I
3/8-16	5/16
3/8-24	Q
7/16-14	U
7/16-20	W
1/2-12	27/64
1/2-13	27/64
1/2-20	29/64
9/16-12	31/64
9/16-18	33/64
5/8-11	17/32
5/8-18	37/64
3/4-10	21/32
3/4-16	11/16
7/8-9	49/64
7/8-14	13/16
1-8	7/8
1-12	59/64
1-14	15/16

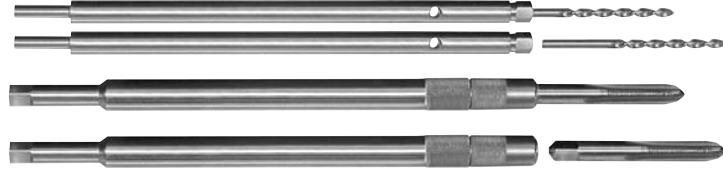
**Taper Pipe (NPT)
Tap & Drill**

1/16-27	D
1/8-27	R
1/4-18	7/16
3/8-18	37/64
1/2-14	45/64
3/4-14	59/64
1 - 11 1/2	1 5/32
1 1/4 - 11 1/2	1 1/2
1 1/2 - 11 1/2	1 47/64
2 - 11 1/2	2 7/32

Metric Tap & Drill
Approximately 70-75%
Thread

Thread Size	Drill Size
M1.6 x .35	1.25mm
M2.0 x .40	1.6
M2.5 x .45	2.05
M3.0 x .50	2.5
M3.5 x .60	2.9
M4.0 x .70	3.3
M4.5 x .75	3.75
M5.0 x .80	4.2
M6.0 x 1.0	5
M7.0 x 1.0	6
M8 x 1.25	6.75
M10 x 1.50	8.5
M12 x 1.75	Y
M14 x 2.0	1.2
M16 x 2.0	1.4
M18 x 2.5	15.5
M20 x 2.5	17.5

Whitney Decimal Equivalents



Rollform Tap & Drill
Approximately 65% Thread

Thread Size	Drill Size
0-80	54
1-64	1.65mm
1-72	1.7mm
2-56	5/64
2-64	2mm
3-48	43
3-56	2.3mm
4-40	39
4-48	2.6mm
5-40	33
5-44	2.9mm
6-32	1/8
6-40	3.2mm
8-32	25
8-36	24
10-24	11/64
10-32	16
12-24	5mm
12-28	8
1/4-20	1
1/4-28	A
5/16-18	7.3mm
5/16-24	M
3/8-16	S
3/8-24	T
7/16-14	13/32
7/16-20	10.5mm
1/2-13	15/32
1/2-20	31/64
9/16-12	17/32
9/16-18	13.5mm
5/8-11	15mm
5/8-18	19/32
3/4-10	45/64
3/4-16	23/32
7/8-9	.823
7/8-14	27/32
1-8	15/16
1-12	.963

Decimal Equivalents

Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal
.1mm	0.0039	42	0.0935	A	0.2340	13mm	0.5118
.2mm	0.0079	3/32	0.0938	15/64	0.2344	33/64	0.5156
.3mm	0.0118	41	0.0960	6mm	0.2362	17/32	0.5313
80	0.0135	40	0.0980	B	0.2380	13.5mm	0.5315
79	0.0145	2.5mm	0.0984	C	0.2420	35/64	0.5469
1/64	0.0156	39	0.0995	D	0.2460	14mm	0.5512
.4mm	0.0157	38	0.1015	E	0.2500	9/16	0.5625
78	0.0160	37	0.1040	1/4	0.2500	14.5mm	0.5709
77	0.0180	36	0.1065	6.5mm	0.2559	37/64	0.5781
.5mm	0.0197	7/64	0.1094	F	0.2570	15mm	0.5906
76	0.0200	35	0.1100	G	0.2610	19/32	0.5938
75	0.0210	34	0.1110	17/64	0.2656	39/64	0.6094
74	0.0225	33	0.1130	H	0.2660	15.5mm	0.6102
.6mm	0.0236	32	0.1160	I	0.2720	5/8	0.6250
73	0.0240	3mm	0.1181	J	0.2756	16mm	0.6299
72	0.0250	31	0.1200	J	0.2770	41/64	0.6406
71	0.0260	1/8	0.1250	K	0.2810	16.5mm	0.6496
.7mm	0.0276	30	0.1285	9/32	0.2812	21/32	0.6562
70	0.0280	29	0.1360	L	0.2900	17mm	0.6693
69	0.0292	3.5mm	0.1378	M	0.2950	43/64	0.6719
68	0.0310	28	0.1405	7.5mm	0.2953	11/16	0.6875
1/32	0.0312	9/64	0.1406	19/64	0.2969	17.5mm	0.6890
.8mm	0.0315	27	0.1440	N	0.3020	45/64	0.7031
67	0.0320	26	0.1470	5/16	0.3125	18mm	0.7087
66	0.0330	25	0.1495	8mm	0.3150	23/32	0.7188
65	0.0350	24	0.1520	O	0.3160	18.5mm	0.7283
.9mm	0.0354	23	0.1540	P	0.3230	47/64	0.7344
64	0.0360	5/32	0.1562	21/64	0.3281	19mm	0.7480
63	0.0370	22	0.1570	Q	0.3320	3/4	0.7500
62	0.0380	4mm	0.1575	R	0.3346	49/64	0.7656
61	0.0390	21	0.1590	8.5mm	0.3346	19.5mm	0.7677
1mm	0.0394	20	0.1610	11/32	0.3438	25/32	0.7812
60	0.0400	19	0.1660	S	0.3480	20mm	0.7874
59	0.0410	18	0.1695	T	0.3580	51/64	0.7969
58	0.0420	11/64	0.1719	23/64	0.3594	20.5mm	0.8071
57	0.0430	17	0.1730	U	0.3680	13/16	0.8125
56	0.0465	16	0.1770	9.5mm	0.3740	21mm	0.8268
3/64	0.0469	4.5mm	0.1772	3/8	0.3750	53/64	0.8281
55	0.0520	15	0.1800	V	0.3770	27/32	0.8438
54	0.0550	14	0.1820	W	0.3860	21.5mm	0.8465
1.5mm	0.0591	13	0.1850	25/64	0.3906	55/64	0.8594
53	0.0595	3/16	0.1875	10mm	0.3937	22mm	0.8661
1/16	0.0625	12	0.1890	X	0.3970	7/8	0.8750
52	0.0635	11	0.1910	10.5mm	0.4134	22.5mm	0.8858
51	0.0670	10	0.1935	Y	0.4040	57/64	0.8906
50	0.0700	9	0.1960	13/32	0.4062	23mm	0.9055
49	0.0730	5mm	0.1969	Z	0.4130	29/32	0.9062
48	0.0760	8	0.1990	10.5mm	0.4134	59/64	0.9219
5/64	0.0781	7	0.2010	27/64	0.4219	23.5mm	0.9252
47	0.0785	13/64	0.2031	11mm	0.4331	15/16	0.9375
2mm	0.0787	6	0.2040	7/16	0.4375	24mm	0.9449
46	0.0810	5	0.2055	11.5mm	0.4528	61/64	0.9531
45	0.0820	4	0.2090	29/64	0.4531	24.5mm	0.9646
44	0.0860	3	0.2130	15/32	0.4688	31/32	0.9688
43	0.0890	5.5mm	0.2165	12mm	0.4724	25mm	0.9843
Fraction		7/32	0.2188	31/64	0.4844	63/64	0.9844
Number		2	0.2210	12.5mm	0.4921	1	1.0000
Letter		1	0.2280	1/2	0.5000		
mm							

**Straight Pipe (NPS)
Tap & Drill**

1/16 - 27	1/4
1/8 - 27	11/32
1/4 - 18	7/16
3/8 - 18	37/64
1/2 - 14	23/32
3/4 - 14	23/32
1 - 11 1/2	59/64
1 1/4 - 11 1/2	1 5/32
1 1/4 - 11 1/2	1 1/2
1 1/2 - 11 1/2	1 3/4
2 - 11 1/2	2 7/32

**Metric Roll Form
Tap & Drill**
Approximately 65%
Thread

Thread Size	Drill Size
M1.6 x .35	1.45mm
M2.0 x .40	1.85mm
M2.5 x .45	2.30mm
M3.0 x .50	35
M3.5 x .60	30
M4.0 x .70	3.7mm
M5.0 x .80	14
M6.0 x 1.0	5.5mm
M8 x 1.25	7.4mm
M10 x 1.50	9.3mm
M12 x 1.75	7/16
M14 x 2.0	13mm
M16 x 2.0	15mm
M20 x 2.5	18.75mm

