

TAP AND DIE CHART

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DRILL THIS SIZE HOLE:			TO TAP FOR THIS SIZE BOLT OR SCREW:
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.0984	2.5 mm	none	3 mm – 0.60 pitch
.1015	No. 38	none	5 – 40
.1100	No. 35	7/64	6 – 32
.1338	3.4 mm	none	4 mm – 0.70 pitch
.1360	No. 29	none	8 – 32
.1495	No. 25	5/32	10 – 24
.1590	No. 21	5/32	10 – 32
.1653	4.2 mm	none	5 mm – 0.90 pitch
.1693	4.3 mm	none	5 mm – 0.80 pitch
.1770	No. 16	11/64	12 – 24
.2010	No. 7	13/64	1/4 – 20
.2047	5.2 mm	none	6 mm – 1.00 pitch
.2130	No. 3	7/32	1/4 – 28
.2401	6.1 mm	15/64	7 mm – .00 pitch
.2570	Ltr. F	17/64	5/16 – 18
.2716	6.9 mm	17/64	8 mm – 1.25 pitch
.2720	Ltr. I	none	5/16 – 24
.2795	7.1 mm	none	8 mm – 1.00 pitch
.3110	7.9 mm	none	9 mm – 1.25 pitch
.3125	5/16	5/16	3/8 – 16
.3189	8.1 mm	none	9 mm – 1.00 pitch
.3268	8.3 mm	none	9 mm – 0.75 pitch
.3320	Ltr. Q	21/64	3/8 – 24
.3425	8.7 mm	none	10 mm – 1.50 pitch
.3503	8.9 mm	11/32	10 mm – 1.25 pitch
.3583	9.1 mm	none	10 mm – 1.00 pitch*
.3680	Ltr. U	23/64	7/16 – 14
.3818	9.7 mm	none	11 mm – 1.50 pitch
.3906	25/64	25/64	7/16 – 20
.4133	10.5 mm	none	12 mm – 1.75 pitch
.4212	10.7 mm	27/64	12 mm – 1.50 pitch
.4219	27/64	27/64	1/2 – 13
.4291	10.9 mm	27/64	12 mm – 1.25 pitch*
.4561	29/64	29/64	1/2 – 20
.4803	12.2 mm	none	14 mm – 2.00 pitch
.4844	31/64	31/64	9/16 – 12

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DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.4999	12.7 mm	none	14 mm – 1.50 pitch
.5039	12.8 mm	none	14 mm – 1.25 pitch
.5156	33/64	33/64	9/16 – 18
.5312	17/32	17/32	5/8 – 11
.5590	14.2 mm	35/64	16 mm – 2.00 pitch
.5781	37/64	37/64	5/8 – 18
.5787	14.7 mm	none	16 mm – 1.50 pitch
.6220	15.8 mm	39/64	18 mm – 2.50 pitch
.6562	21/32	21/32	3/4 – 10
.6614	16.8 mm	none	18 mm – 1.50 pitch*
.6875	11/16	11/16	3/4 – 16
.7008	17.8 mm	11/16	20 mm – 2.50pitch
.7656	49/64	49/64	7/8 – 9
.8125	13/16	13/16	7/8 – 14
.8228	20.9 mm	none	22 mm – 1.50 pitch
.8425	21.4 mm	53/64	24 mm – 3.00 pitch
.8750	7/8	7/8	1 – 8
.8779	22.3 mm	none	24 mm – 2.00 pitch
.9219	59/64	59/64	1 – 12
.9844	63/64	63/64	1-1/8 – 7
1.0469	1-3/64	1-3/64	1-1/8 – 12
1.1094	1-7/64	1-7/64	1-1/4 – 7
1.1719	1-11/64	1-11/64	1-1/4 – 12
1.3138	1-11/32	1-11/32	1-1/2 – 6
1.4219	1-27/64	1-27/64	1-1/2 – 12

* Spark plug taps

NATIONAL PIPE TAPERED TAPS

DRILL THIS SIZE HOLE:			TO TAP FOR THIS SIZE BOLT OR SCREW:
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.3390	Letter R	NONE	1/8 – 27 NPT
.4375	7/16	7/16	1/4 – 18 NPT
.5781	37/64	37/64	3/8 – 18 NPT
.7031	45/64	45/64	1/2 – 14 NPT
.9219	59/64	59/64	3/4 – 14 NPT