



Tap and Drill Bit Selection Guide

American Standard & Unified Form Threads

Tap drill size is approximately 75% of threaded depth.

Thread Nominal Size	Pitch Series	Drill Size	Drill Decimal Inches
0-80	NF	3/64	.0469
1-64	NC	53	.0595
1-72	NF	53	.0595
2-56	NC	50	.0700
2-64	NF	50	.0700
3-48	NC	47	.0785
3-56	NF	45	.0820
4-40	NC-UNC	43	.0890
4-48	NF	42	.0935
5-40	NC	38	.1015
5-44	NF	37	.1040
6-32	NC-UNC	36	.1065
6-40	NF	33	.1130
8-32	NC-UNC	29	.1360
8-36	NF	29	.1360
10-24	NC-UNC	25	.1495
10-32	NF-UNF	21	.1590
3/16-24	NS	26	.1470
3/16-32	NS	22	.1570
12-24	NC	16	.1770
12-28	NF	14	.1820
14-20	NS	10	.1935
1/4-20	NC-UNC	7	.2010
1/4-28	NF-UNF	3	.2130
5/16-18	NC-UNC	F	.2570
5/16-24	NF-UNF	I	.2720
3/8-16	NC-UNC	5/16	.3125
3/8-24	NF-UNF	Q	.3320
7/16-14	NC-UNC	U	.3680
7/16-20	NF-UNF	25/64	.3906
1/2-13	NC-UNC	27/64	.4219
1/2-20	NF-UNF	29/64	.4531
9/16-12	NC-UNC	31/64	.4844
9/16-18	NF-UNF	33/64	.5156
5/8-11	NC-UNC	17/32	.5312
5/8-18	NF-UNF	37/64	.5781
3/4-10	NC-UNC	21/32	.6562
3/4-16	NF-UNF	11/16	.6875
7/8-9	NC-UNC	49/64	.7656
7/8-14	NF-UNF	13/16	.8125
1-8	NC-UNC	7/8	.8750
1-14	NS	15/16	.9375
1-1/8 - 7	NC-UNC	63/64	.9844
1-1/8 - 12	NF-UNF	1-3/64	1.0469
1-1/4 - 7	NC-UNC	1-7/64	1.1094
1-1/4 - 12	NF-UNF	1-11/64	1.1719
1-3/8 - 6	NC-UNC	1-7/32	1.2188
1-3/8 - 12	NF-UNF	1-19/64	1.2969
1-1/2 - 6	NC-UNC	1-11/32	1.3438
1-1/2 - 12	NF-UNF	1-27/64	1.4219
1-3/4 - 5	NC-UNC	1-9/16	1.5625
2 - 4-1/2	NC-UNC	1-25/32	1.7813
2-1/4 - 4-1/2	NC-UNC	2-1/32	2.0313
2-1/2 - 4	NC-UNC	2-1/4	2.2500
2-3/4 - 4	NC-UNC	2-1/2	2.5000
3-4	NC-UNC	2-3/4	2.7500
3-1/4 - 4	NC-UNC	3	3.0000
3-1/4 - 4	NC-UNC	3-1/4	3.2500
3-3/4 - 4	NC-UNC	3-1/2	3.5000
4-4	NC-UNC	3-3/4	3.7500

Metric Threads

French International Standard (D.I.N.)

Tap Size	Std.	Drill Size	Drill Decimal Inches
2.5-.45	French	5/64	.0781
2.6-.45	D.I.N.	#45	.0820
3-.50	D.I.N.	#40	.0980
3-.60	French	#39	.0995
3-.75	Optional	#43	.0890
3.5-.60	French & D.I.N.	#33	.1130
4-.70	D.I.N.	1/8	.1250
4-.75	French	1/8	.1250
4.5-.75	French & D.I.N.	#26	.1470
5-.75	Optional	#19	.1660
5-.80	D.I.N.	11/64	.1719
5-.90	French	#20	.1610
5-1.00	Optional	5/32	.1563
5.5-.75	Optional	3/16	.1875
5.5-.90	French & D.I.N.	#14	.1820
6-1.00	French & D.I.N.	13/64	.2031
6-1.25	Optional	3/16	.1875
7-1.00	French & D.I.N.	15/64	.2344
7-1.25	Optional	#1	.2280
8-1.00	French	J	.2770
8-1.25	D.I.N.	17/64	.2656
9-1.00	French	5/16	.3125
9-1.25	D.I.N.	5/16	.3125
10-1.00	Optional	23/64	.3594
10-1.25	Optional	11/32	.3437
10-1.50	French & D.I.N.	11/32	.3437
11-1.50	D.I.N.	3/8	.3750
12-1.25	Optional	7/16	.4375
12-1.50	French	13/32	.4063
12-1.75	D.I.N.	27/64	.4219
12-1.75	Optional	29/64	.4531
13-1.50	Optional	29/64	.4531
13-2.00	Optional	7/16	.4375
14-1.25	Optional	33/64	.5156
14-1.75	Optional	1/2	.5000
14-2.00	French & D.I.N.	15/32	.4687
15-1.75	Optional	17/32	.5313
15-2.00	Optional	33/64	.5156
16-1.50	Optional	37/64	.5781
16-2.00	French & D.I.N.	35/64	.5469
17-2.00	Optional	19/32	.5937
18-1.50	Optional	21/32	.6563

Taper Pipe - for tapping w/out reaming

Thread	Drill	Thread	Drill	Thread	Drill
1/16	D	3/4	59/64	2-1/2	2-5/8
1/8	R	1	1-5/32	3	3-1/4
1/4	7/16	1-1/4	1-1/2	3-1/2	3-3/4
3/8	37/64	1-1/2	1-47/64	4	4-1/4
1/2	45/64	2	2-7/32		

Straight Pipe

Thread	Drill	Thread	Drill	Thread	Drill
1/16	1/4	1/2	23/32	1-1/2	1-3/4
1/8	11/32	3/4	59/64	2	2-7/32
1/4	7/16	1	1-5/32	2-1/2	2-21/32
3/8	37/64	1-1/4	1-1/2		