

CONVERSION CHART

TAP SIZE	DRILL SIZE	THEORETICAL % THREAD	PROBABLE % THREAD
0-80	56 .0465	83	74
	3/64 .0469	81	71
1-64	54 .0550	89	81
	53 .0595	67	59
1-72	53 .0595	75	67
	1/16 .0625	58	50
2-56	51 .0670	82	74
	50 .0700	69	62
	49 .0730	56	49
2-64	50 .0700	79	70
	49 .0730	54	56
3-48	48 .0760	85	78
	5/64 .0781	77	70
	47 .0785	76	69
	46 .0810	67	60
3-56	45 .0820	63	56
	46 .0810	78	69
	45 .0820	73	65
4-40	44 .0860	80	74
	43 .0890	71	65
	42 .0935	57	51
4-48	3/32 .0938	56	50
	42 .0935	68	61
	3/32 .0938	68	60
5-40	41 .0960	59	52
	40 .0980	83	76
	39 .0995	79	71
5-44	38 .1015	72	65
	37 .1040	65	58
	36 .1065	63	55
6-32	37 .1040	84	78
	36 .1065	78	71
	7/64 .1094	70	64
6-40	35 .1100	69	63
	34 .1110	67	60
	33 .1130	62	55
6-40	34 .1110	83	75
	33 .1130	77	69
	32 .1160	68	60

TAP SIZE	DRILL SIZE	THEORETICAL % THREAD	PROBABLE % THREAD
8-32	29 .1360	69	62
	28 .1405	58	51
8-36	29 .1360	78	70
	28 .1405	68	57
	9/64 .1406	68	57
10-24	27 .1440	85	79
	26 .1470	79	74
	25 .1495	75	69
	24 .1520	70	64
10-32	23 .1540	67	61
	5/32 .1563	62	56
	22 .1570	83	75
	21 .1590	81	73
12-24	20 .1610	71	64
	19 .1660	59	51
	11/64 .1719	82	75
	17 .1730	79	73
12-28	16 .1770	72	66
	15 .1800	67	60
	14 .1820	63	56
	16 .1770	84	77
14-20	15 .1800	78	70
	14 .1820	73	66
	13 .1850	67	59
	3/16 .1875	61	54
1/4-20	9 .1960	83	77
	8 .1990	79	73
	7 .2010	75	70
	13/64 .2031	72	66
1/4-28	6 .2040	71	65
	5 .2055	69	63
	4 .2090	63	57
	3 .2130	80	72
5/16-18	7/32 .2188	67	59
	2 .2210	63	55
	F .2570	77	72
	G .2610	71	66
5/16-18	17/64 .2656	65	59
	H .2660	64	59
	28 .1405	58	51
	28 .1405	58	51

TAP SIZE	DRILL SIZE	THEORETICAL % THREAD	PROBABLE % THREAD
5/16-24	H .2660	86	78
	I .2720	75	67
	J .2770	86	58
3/8-16	5/16 .3125	77	72
	O .3160	73	68
	P .3230	64	59
	21/64 .3281	87	79
3/8-24	Q .3320	79	71
	R .3390	67	58
	T .3580	86	81
7/16-14	23/64 .3594	84	79
	U .3680	75	70
	3/8 .3750	67	62
	V .3770	65	60
7/16-20	W .3860	79	72
	25/64 .3906	72	65
1/2-13	X .3970	62	55
	27/64 .4219	78	73
1/2-20	7/16 .4375	63	58
	29/64 .4531	72	65
9/16-12	15/32 .4688	87	82
	31/64 .4844	72	68
9/16-18	1/2 .5000	87	80
	33/64 .5156	65	58
5/8-11	17/32 .5313	79	75
	35/64 .5469	66	62
5/8-18	9/16 .5625	87	80
	37/64 .5781	65	58
3/4-10	41/64 .6406	84	80
	21/32 .6563	72	68
3/4-16	11/16 .6875	77	71
	49/64 .7656	76	72
7/8-9	25/32 .7812	65	61
	51/64 .7969	84	79
7/8-14	13/16 .8125	67	62
	55/64 .8594	87	83
1-8	7/8 .8750	77	73
	57/64 .8906	67	64
	29/32 .9063	58	54
	29/32 .9063	87	81
1-12	59/64 .9219	72	67
	15/16 .9375	58	52
1-14	59/64 .9219	84	78
	15/16 .9375	67	61

DECIMAL EQUIVALENTS	MM CONV.
1/64	.015625
1/32	.03125
3/64	.046875
1/16	.0625
5/64	.078125
3/32	.09375
7/64	.109375
1/8	.125
9/64	.140625
5/32	.15625
11/64	.171875
3/16	.1875
13/64	.203125
7/32	.21875
15/64	.234375
1/4	.250
17/64	.265625
9/32	.28125
19/64	.296875
5/16	.3125
21/64	.328125
11/32	.34375
23/64	.359375
3/8	.375
25/64	.390625
13/32	.40625
27/64	.421875
7/16	.4375
29/64	.453125
15/32	.46875
31/64	.484375
1/2	.5000
33/64	.515625
17/32	.53125
35/64	.546875
9/16	.5625
37/64	.578125
19/32	.59375
39/64	.609375
5/8	.625
41/64	.640625
21/32	.65625
43/64	.671875
11/16	.6875
45/64	.703125
23/32	.71875
47/64	.734375
3/4	.750
49/64	.765625
25/32	.78125
51/64	.796875
13/16	.8125
53/64	.828125
27/32	.84375
55/64	.859375
7/8	.875
57/64	.890625
29/32	.90625
59/64	.921875
15/16	.9375
61/64	.953125
31/32	.96875
63/64	.984375
1	1.000

MM TO INCHES	MM's	INCHES
.05	.00197	
.1	.00394	
.2	.00787	
.3	.01181	
.4	.01575	
.5	.01969	
.6	.02362	
.7	.02756	
.8	.03150	
.9	.03543	
1	.03937	
2	.07874	
3	.11811	
4	.15748	
5	.19685	
6	.23622	
7	.27559	
8	.31496	
9	.35433	
10	.39370	

TAP DRILL SIZES & % OF THREAD FOR ISO METRIC TAPS									
MM TAP SIZE	DRILL SIZE	EQUIVALENT IN INCHES	THEORETICAL % THREAD	PROBABLE % THREAD	MM TAP SIZE	DRILL SIZE	EQUIVALENT IN INCHES	THEORETICAL % THREAD	PROBABLE % THREAD
2.5 x 0.45	2.05 MM	.0807	77	69	7 x 1.00	"A"	.2340	81	74
	#46	.0810	76	67		15/64	.2344	81	73
	#45	.0820	71	63		6.00 MM	.2362	77	70
3 x 0.50	#40	.0980	79	70	8 x 1.25	"B"	.2380	74	66
	2.50 MM	.0984	77	68		6.70 MM	.2638	80	74
	#39	.0995	73	64		17/64	.2656	77	71
3.5 x 0.60	#33	.1130	81	72	10 x 1.50	"H"	.2660	77	70
	2.90 MM	.1142	77	68		6.80 MM	.2677	74	68
	#32	.1160	71	63		8.40 MM	.3307	82	76
4 x 0.70	3.20 MM	.1260	88	80	12 x 1.75	"Q"	.3320	80	75
	#30	.1285	81	73		8.50 MM	.3346	77	71
	3.30 MM	.1299	77	69		10.20 MM	.4016	79	74
4.5 x 0.75	3.70 MM	.1457	82	74	14 x 2.00	"Y"	.4040	76	71
	#26	.1470	79	70		13/32	.4062	74	69
	3.80 MM	.1496	72	64		15/32	.4688	81	76
5 x 0.80	#25	.1495	72	64	16 x 2.00	12.00 MM	.4724	77	72
	4.20 MM	.1654	77	69		35/64	.5469	81	76
	#19	.1660	75	68		14.00 MM	.5512	77	72
6 x 1.00	4.25 MM	.1674	66	60	18 x 2.50	20 x 2.50	.6875	78	74
	#10	.1935	84	76		39/64	.6094	78	74
	#9	.1960	79	71		15.50 MM	.6102	77	73
	5.00 MM	.1968	77	70		11/16	.6875	78	74
#8	.1990	73	65	17.50 MM	.6890	77	73		

TAP DRILL SIZES FOR PIPE TAPS		
TAP	NPT	NPS
1/16-27	D	1/4
1/8-27	R	S
1/4-18	7/16	29/64
3/8-18	37/64	19/32
1/2-14	45/64	47/64
3/4-14	59/64	15/16
1-11-1/2	1 5/32	1 3/16
1-1/4-11-1/4	1 1/2	1 33/64
1-1/2-11-1/2	1 47/64	1 3/4
2-11-1/2	2 7/32	2 7/32