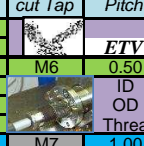
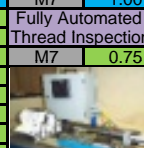



| max OD of tap | Imperial cut Tap | Pitch | Drill | Inches | MM | Metric cut Tap | mm Pitch |
|---|------------------|-------|-------|--------|-------|---|----------|
|  | #1 NF | 80 | #80 | 0.0135 | 0.343 |  | M1.6 |
| | | | #79 | 0.0145 | 0.368 | | |
| | | | 1/64 | 0.0156 | 0.396 | | |
| | | | #78 | 0.0160 | 0.406 | | |
| | | | #77 | 0.0180 | 0.457 | | |
| | | | #76 | 0.0200 | 0.508 | | |
| | | | #75 | 0.0210 | 0.533 | | |
| | | | #74 | 0.0225 | 0.572 | | |
| | | | #73 | 0.0240 | 0.610 | | |
| | | | #72 | 0.0250 | 0.635 | | |
| | | | #71 | 0.0260 | 0.660 | | |
| | | | #70 | 0.0278 | 0.706 | | |
| | | | #69 | 0.0292 | 0.742 | | |
| | | | #68 | 0.0310 | 0.787 | | |
| | | | 1/32 | 0.0313 | 0.795 | | |
| #67 | 0.0320 | 0.813 | | | | | |
| #66 | 0.0330 | 0.838 | | | | | |
| #65 | 0.0350 | 0.889 | | | | | |
| #64 | 0.0360 | 0.914 | | | | | |
| #63 | 0.0370 | 0.940 | | | | | |
| #62 | 0.0380 | 0.965 | | | | | |
| #61 | 0.0390 | 0.991 | | | | | |
| #60 | 0.0400 | 1.016 | | | | | |
| #59 | 0.0410 | 1.041 | | | | | |
| #58 | 0.0420 | 1.067 | | | | | |
| #57 | 0.0430 | 1.092 | | | | | |
| #56 | 0.0465 | 1.181 | | | | | |
| #55 | 0.0520 | 1.321 | | | | | |
| #54 | 0.0550 | 1.397 | | | | | |
| #53 | 0.0595 | 1.511 | | | | | |
| 1/16 | 0.0625 | 1.588 | | | | | |
| #52 | 0.0635 | 1.613 | | | | | |
| #51 | 0.0670 | 1.702 | | | | | |
| #50 | 0.0700 | 1.778 | | | | | |
| #49 | 0.0730 | 1.854 | | | | | |
| #48 | 0.0760 | 1.930 | | | | | |
| 5/64 | 0.0781 | 1.984 | | | | | |
| #47 | 0.0785 | 1.994 | | | | | |
| #46 | 0.0810 | 2.057 | | | | | |
| #45 | 0.0820 | 2.083 | | | | | |
| #44 | 0.0860 | 2.184 | | | | | |
| #43 | 0.0890 | 2.261 | | | | | |
| #42 | 0.0935 | 2.375 | | | | | |
| 3/32 | 0.0937 | 2.380 | | | | | |
| #41 | 0.0960 | 2.438 | | | | | |
| #40 | 0.0980 | 2.489 | | | | | |
| #39 | 0.0995 | 2.527 | | | | | |
| #38 | 0.1015 | 2.578 | | | | | |
| #37 | 0.1040 | 2.642 | | | | | |
| #36 | 0.1065 | 2.705 | | | | | |
| 7/64 | 0.1093 | 2.776 | | | | | |
| #35 | 0.1100 | 2.794 | | | | | |
| #34 | 0.1110 | 2.819 | | | | | |
| #33 | 0.1130 | 2.870 | | | | | |
| #32 | 0.1160 | 2.946 | | | | | |
| #31 | 0.1200 | 3.048 | | | | | |
| 1/8 | 0.1250 | 3.175 | | | | | |
| #30 | 0.1285 | 3.264 | | | | | |
| #29 | 0.1360 | 3.454 | | | | | |
| #29 | 0.1360 | 3.454 | | | | | |
| #28 | 0.1405 | 3.569 | | | | | |
| 9/64 | 0.1406 | 3.571 | | | | | |
| #27 | 0.1440 | 3.658 | | | | | |
| #27 | 0.1440 | 3.658 | | | | | |
| #27 | 0.1440 | 3.658 | | | | | |
| #26 | 0.1470 | 3.734 | | | | | |
| #25 | 0.1495 | 3.797 | | | | | |
| #24 | 0.1520 | 3.861 | | | | | |
| #23 | 0.1540 | 3.912 | | | | | |
| 5/32 | 0.1563 | 3.970 | | | | | |
| #22 | 0.1570 | 3.988 | | | | | |
| #21 | 0.1590 | 4.039 | | | | | |
| #20 | 0.1610 | 4.089 | | | | | |
| #19 | 0.1660 | 4.216 | | | | | |
| #18 | 0.1695 | 4.305 | | | | | |
| #18 | 0.1695 | 4.305 | | | | | |
| #18 | 0.1695 | 4.305 | | | | | |
| 11/64 | 0.1719 | 4.366 | | | | | |
| #17 | 0.1730 | 4.394 | | | | | |
| #16 | 0.1770 | 4.496 | | | | | |
| #15 | 0.1800 | 4.572 | | | | | |
| #14 | 0.1820 | 4.623 | | | | | |
| #13 | 0.1850 | 4.699 | | | | | |
| 3/16 | 0.1875 | 4.763 | | | | | |
| #12 | 0.1890 | 4.801 | | | | | |
| #11 | 0.1910 | 4.851 | | | | | |
| #10 | 0.1935 | 4.915 | | | | | |
| #9 | 0.1960 | 4.978 | | | | | |
| #9 | 0.1960 | 4.978 | | | | | |
| #8 | 0.1990 | 5.055 | | | | | |
| #7 | 0.2010 | 5.105 | | | | | |
| 13/64 | 0.2031 | 5.159 | | | | | |
| #6 | 0.2040 | 5.182 | | | | | |
| #5 | 0.2055 | 5.220 | | | | | |

LEGEND

Imperial fractions and standard drills
Standard number drills
Standard imperial decimal conversion
Standard letter drills

| OD Max | Imperial cut Tap | Pitch | Drill | Inches | MM | Metric cut Tap | mm Pitch |
|--------|------------------|--------|---------|--------|--------|---|-------------|
| 0.2500 | 1/4" NF | 28 | #4 | 0.2090 | 5.309 |  | ETV |
| | | | #3 | 0.2130 | 5.410 | | |
| | | | 7/32 | 0.2188 | 5.558 | | |
| | | | #2 | 0.2210 | 5.613 | | |
| | | | #1 | 0.2280 | 5.791 | | |
| | | | A | 0.2340 | 5.944 | | |
| | | | 15/64 | 0.2344 | 5.953 | | |
| | | | B | 0.2380 | 6.045 | | |
| | | | C | 0.2420 | 6.147 | | |
| | | | D | 0.2460 | 6.248 | | |
| | | | 1/4 | 0.2500 | 6.350 | | |
| | | | E | 0.2500 | 6.350 | | |
| | | | F | 0.2570 | 6.528 | | |
| | | | G | 0.2610 | 6.629 | | |
| | | | H | 0.2660 | 6.756 | | |
| 0.3125 | 5/16" NC | 18 | I | 0.2720 | 6.909 |  | ETV Systems |
| | | | J | 0.2770 | 7.036 | | |
| | | | 5/16 | 0.3125 | 7.938 | | |
| | | | K | 0.2811 | 7.140 | | |
| | | | 9/32 | 0.2813 | 7.145 | | |
| | | | L | 0.2900 | 7.366 | | |
| | | | M | 0.2950 | 7.493 | | |
| | | | 19/64 | 0.2969 | 7.541 | | |
| | | | N | 0.3020 | 7.671 | | |
| | | | 5/16 | 0.3125 | 7.938 | | |
| | | | O | 0.3160 | 8.026 | | |
| | | | P | 0.3230 | 8.204 | | |
| | | | 21/64 | 0.3281 | 8.334 | | |
| | | | Q | 0.3320 | 8.433 | | |
| | | | Q | 0.3320 | 8.433 | | |
| Q | 0.3320 | 8.433 | | | | | |
| R | 0.3390 | 8.611 | | | | | |
| 21/64 | 0.3281 | 8.334 | | | | | |
| 11/32 | 0.3438 | 8.733 | | | | | |
| S | 0.3480 | 8.839 | | | | | |
| T | 0.3580 | 9.093 | | | | | |
| 23/64 | 0.3594 | 9.129 | | | | | |
| 0.3750 | 3/8" NC | 16 | U | 0.3680 | 9.347 |  | M8 1.25 |
| | | | M9 0.50 | | | | |
| | | | 3/8 | 0.3750 | 9.525 | | |
| | | | V | 0.3770 | 9.576 | | |
| | | | W | 0.3860 | 9.804 | | |
| | | | 25/64 | 0.3906 | 9.921 | | |
| | | | X | 0.3970 | 10.084 | | |
| | | | Y | 0.4040 | 10.262 | | |
| | | | 13/32 | 0.4063 | 10.320 | | |
| | | | Z | 0.4130 | 10.490 | | |
| | | | 27/64 | 0.4219 | 10.716 | | |
| | | | 7/16 | 0.4375 | 11.113 | | |
| | | | 7/16 | 0.4375 | 11.113 | | |
| | | | 29/64 | 0.4531 | 11.509 | | |
| | | | 15/32 | 0.4688 | 11.906 | | |
| 31/64 | 0.4844 | 12.303 | | | | | |
| 1/2 | 0.5000 | 12.700 | | | | | |
| 33/64 | 0.5156 | 13.097 | | | | | |
| 17/32 | 0.5313 | 13.494 | | | | | |
| 35/64 | 0.5469 | 13.891 | | | | | |
| 9/16 | 0.5625 | 14.288 | | | | | |
| 37/64 | 0.5781 | 14.684 | | | | | |
| 19/32 | 0.5938 | 15.081 | | | | | |
| 39/64 | 0.6094 | 15.479 | | | | | |
| 5/8 | 0.6250 | 15.875 | | | | | |
| 41/64 | 0.6406 | 16.271 | | | | | |
| 21/32 | 0.6563 | 16.669 | | | | | |
| 43/64 | 0.6719 | 17.066 | | | | | |
| 11/16 | 0.6875 | 17.463 | | | | | |
| 45/64 | 0.7031 | 17.859 | | | | | |
| 23/32 | 0.7188 | 18.256 | | | | | |
| 47/64 | 0.7344 | 18.653 | | | | | |
| 3/4 | 0.7500 | 19.050 | | | | | |
| 49/64 | 0.7656 | 19.447 | | | | | |
| 25/32 | 0.7813 | 19.844 | | | | | |
| 51/64 | 0.7969 | 20.241 | | | | | |
| 13/16 | 0.8125 | 20.638 | | | | | |
| 53/64 | 0.8281 | 21.034 | | | | | |
| 53/64 | 0.8281 | 21.034 | | | | | |
| 27/32 | 0.8438 | 21.431 | | | | | |
| 55/64 | 0.8594 | 21.828 | | | | | |
| 1.0000 | 1" NC | 8 | 7/8 | 0.8750 | 22.225 | M24 | 1.50 |
| 57/64 | 0.8906 | 22.622 | M24 | 1.00 | | | |
| 29/32 | 0.9063 | 23.019 | M24 | 1.00 | | | |
| 1.0000 | 1" NF | 12 | 59/64 | 0.9219 | 23.416 | Precision Welding | |
| 1.0000 | 1" NS | 14 | 15/16 | 0.9375 | 23.813 | MIG | TIG |
| | | | 61/64 | 0.9532 | 24.212 | | |
| | | | 31/32 | 0.9688 | 24.606 | | |
| 1.1250 | 1-1/8" NC | 7 | 63/64 | 0.9844 | 25.003 | | |
| 1.2500 | 1-1/4" NC | 7 | 1 7/64 | 1.1094 | 28.178 | | |
| 1.2500 | 1-1/4" NF | 12 | 1 11/64 | 1.1719 | 29.766 | | |
| 1.2500 | 1-1/8" NF | 12 | 1 19/64 | 1.2969 | 32.941 | | |
| 1.3750 | 1-3/8" NC | 6 | 1 7/32 | 1.2188 | 30.956 | | |
| 1.3750 | 1-3/8" NF | 12 | 1 19/64 | 1.2969 | 32.941 | | |
| 1.5000 | 1-1/2" NC | 6 | 1 11/32 | 1.3438 | 34.131 | | |
| 1.5000 | 1-1/2" NF | 12 | 1 27/64 | 1.4219 | 36.116 | | |
| 1.7500 | 1-3/4" NC | 5 | 1 9/16 | 1.5625 | 39.688 | | |
| 2.0000 | 2" NC | 4.5 | 1 25/32 | 1.7813 | 45.244 | | |

Metric tap size, conversion, metric coarse tap, pitch
Metric tap size, conversion, metric fine tap, pitch
Imperial max tap diameter, Imperial National Coarse tap - threads per inch
Imperial max tap diameter, Imperial National Fine tap - threads per inch
Imperial max tap diameter, Imperial National Special tap - threads per inch