



FOR CUTTING & FORMING TAPS TAP DRILL RECOMMENDATIONS



| Tap Size & Pitch | | Cutting Taps | | Forming Taps | |
|------------------|-------------|--------------|-------------|--------------|-------------|
| Inch | Metric | Drill Size | Dec. Equiv. | Drill Size | Dec. Equiv. |
| 0-80 | | 3/64 | 0.469 | 54 | 0.650 |
| | M1.6 x 0.35 | 1.25 | 0.492 | 1.45 | 0.671 |
| | M1.6 x 0.35 | 1.45 | 0.671 | 1.65 | 0.650 |
| 1-64 | | 53 | 0.695 | 51 | 0.670 |
| 1-72 | | 53 | 0.695 | 51 | 0.670 |
| | M2 x 0.40 | 1.60 | 0.630 | 1.80 | 0.709 |
| 2-56 | | 50 | 0.700 | 48 | 0.751 |
| 2-64 | | 50 | 0.700 | 47 | 0.735 |
| | M2.2 x 0.45 | 1.75 | 0.649 | 2.00 | 0.787 |
| | M2.5 x 0.45 | 2.05 | 0.807 | 2.30 | 0.908 |
| 3-48 | | 47 | 0.785 | 43 | 0.890 |
| 3-56 | | 46 | 0.810 | 3.30 | 0.900 |
| 4-40 | | 43 | 0.890 | 39 | 1.015 |
| 4-48 | | 42 | 0.905 | 2.80 | 1.024 |
| | M3 x 0.50 | 2.50 | 0.954 | 2.84 | 1.094 |
| 5-40 | | 38 | 1.015 | 33 | 1.130 |
| 5-44 | | 37 | 1.040 | 2.90 | 1.142 |
| | M3.5 x 0.60 | 2.80 | 1.142 | 3.20 | 1.260 |
| 6-32 | | 36 | 1.065 | 3.8 | 1.250 |
| 6-40 | | 33 | 1.130 | 3.25 | 1.280 |
| | M4 x 0.70 | 3.30 | 1.299 | 3.70 | 1.478 |
| 8-32 | | 29 | 1.360 | 29 | 1.495 |
| 8-36 | | 29 | 1.360 | 24 | 1.520 |
| | M4.5 x 0.75 | 3.75 | 1.478 | 4.10 | 1.614 |
| 10-24 | | 26 | 1.470 | 11.64 | 1.719 |
| 10-32 | | 21 | 1.580 | 16 | 1.770 |
| | M5 x 0.80 | 4.20 | 1.654 | 14 | 1.820 |
| 12-24 | | 18 | 1.770 | 8 | 1.990 |
| 12-28 | | 18 | 1.800 | 7 | 2.010 |
| | M6 x 1.00 | 5.00 | 1.969 | 7.02 | 2.188 |
| 1/4-20 | | 7 | 2.010 | 1 | 2.080 |
| 1/4-28 | | 3 | 2.130 | 15.64 | 2.340 |
| | M7 x 1.00 | 6.00 | 2.362 | F | 2.570 |
| 5/16-18 | | F | 2.570 | L | 2.900 |
| 5/16-24 | | L | 2.720 | M | 2.900 |
| | M8 x 1.25 | 6.75 | 2.638 | 7.40 | 2.913 |
| | M8 x 1.00 | 7.00 | 2.756 | 16.64 | 2.969 |
| 3/8-16 | | 9.75 | 3.125 | S | 3.480 |
| 3/8-24 | | O | 3.320 | T | 3.680 |
| | M10 x 1.50 | 8.50 | 3.348 | 9.40 | 3.701 |
| | M10 x 1.25 | 8.75 | 3.425 | 9.40 | 4.040 |
| | | U | 3.690 | V | 4.130 |
| 7/16-14 | | 11.00 | 3.608 | 2 | 4.130 |
| 7/16-20 | | 11.00 | 3.608 | 11.20 | 4.429 |
| | M12 x 1.75 | 10.25 | 4.018 | 11.50 | 4.529 |
| | M12 x 1.25 | 10.80 | 4.252 | 11.50 | 4.692 |
| | | 23.64 | 4.219 | 13.25 | 4.620 |
| 1/2-13 | | 20.64 | 4.531 | 13.25 | 5.158 |
| 1/2-20 | | 12.00 | 4.724 | 13.64 | 5.312 |
| 9/16-12 | | 13.64 | 4.844 | 13.62 | 5.312 |
| 9/16-18 | | 13.64 | 5.158 | 13.50 | 5.315 |

| Tap Size & Pitch | | Cutting Taps | | Forming Taps | |
|------------------|------------|--------------|-------------|--------------|-------------|
| Inch | Metric | Drill Size | Dec. Equiv. | Drill Size | Dec. Equiv. |
| 5/8-11 | | 17.00 | 5.312 | 14.75 | 5.807 |
| 5/8-18 | | 17.00 | 5.781 | 15.25 | 6.004 |
| | M18 x 2.50 | 14.00 | 5.512 | 15.02 | 5.928 |
| | M18 x 1.50 | 14.50 | 5.709 | 15.25 | 6.004 |
| | M18 x 2.50 | 15.50 | 6.102 | 15.64 | 6.094 |
| | M18 x 1.50 | 16.50 | 6.496 | 17.25 | 6.791 |
| 3/4-10 | | 21.00 | 6.562 | 18.64 | 7.021 |
| 3/4-16 | | 17.75 | 6.875 | 23.02 | 7.168 |
| | M20 x 2.50 | 17.50 | 6.890 | " | " |
| | M20 x 1.50 | 18.50 | 7.283 | " | " |
| | M20 x 2.50 | 19.50 | 7.677 | " | " |
| | M22 x 1.50 | 20.50 | 8.071 | " | " |
| 7/8-9 | | 19.00 | 7.656 | " | " |
| 7/8-14 | | 19.75 | 8.125 | " | " |
| | M24 x 3.00 | 21.00 | 8.268 | " | " |
| | M24 x 2.00 | 22.00 | 8.661 | " | " |
| 1-8 | | 21.8 | 8.750 | " | " |
| 1-12 | | 20.64 | 9.019 | " | " |
| | M27 x 3.00 | 24.00 | 9.449 | " | " |
| | M27 x 2.00 | 25.00 | 9.843 | " | " |
| 1 1/8-7 | | 25.64 | 9.844 | " | " |
| 1 1/8-12 | | 1 3/64 | 1.0480 | " | " |
| | M30 x 3.50 | 26.50 | 1.0430 | " | " |
| | M30 x 2.00 | 28.50 | 1.1024 | " | " |
| 1 1/4-7 | | 1 7/64 | 1.1094 | " | " |
| 1 1/4-12 | | 1 15/64 | 1.1719 | " | " |
| | M33 x 3.50 | 29.50 | 1.1614 | " | " |
| | M33 x 2.00 | 31.00 | 1.2206 | " | " |
| 1 3/8-6 | | 1 7/32 | 1.2188 | " | " |
| 1 3/8-12 | | 1 19/64 | 1.2969 | " | " |
| | M36 x 4.00 | 32.50 | 1.2990 | " | " |
| | M36 x 3.00 | 33.50 | 1.2990 | " | " |
| 1 1/2-6 | | 1 11/32 | 1.3438 | " | " |
| 1 1/2-12 | | 1 27/64 | 1.4219 | " | " |
| | M39 x 4.00 | 35.00 | 1.3780 | " | " |
| | M39 x 3.00 | 36.00 | 1.4173 | " | " |

PIPE TAPS: NPT, NPTF, NPSM, NPSC, NPSP

| Nominal Pipe Tap Size | NPT & NPTF | | | | | NPSM |
|-----------------------|-------------------|----------------|-----------|-----------|---------|-----------|
| | Metric Equivalent | WSS Equivalent | NPSM | NPSC | NPSP | |
| 1/16-27 | C (1.412) | A (1.234) | — | — | 290 | C (1.248) |
| 1/8-27 | C (1.332) | 2.184 | T (1.368) | C (1.302) | — | H (1.308) |
| 1/4-18 | 7.18 | 2.784 | 7.532 | 7.18 | — | 7.18 |
| 3/8-18 | 9.78 | 9.78 | 9.52 | 9.78 | — | 9.78 |
| 1/2-14 | 12.54 | 13.18 | 13.0 | 13.0 mm | 13.0 mm | 13.0 mm |
| 3/4-14 | 16.52 | 17.64 | 17.64 | 17.64 | 17.64 | 17.64 |
| 1-11 1/2 | 1 6/64 | 1.58 | 1 13/64 | 1 5/32 | 1 5/32 | 1 5/32 |
| 1 1/4-11 1/2 | 1 31/64 | 1 39/32 | 1 39/32 | 1 39/32 | — | — |
| 1 1/2-11 1/2 | 1 23/32 | 1 45/64 | 1 25/32 | 1 47/64 | — | — |
| 2-11 1/2 | 2 3/16 | 2 1/8 | 2 1/4 | 2 13/64 | — | — |

■ METRIC
 ■ FRACTIONAL
 ■ WIRE GAGE
 ■ LETTER SIZE

Machine Tapping Guide

D Keegan



Machine Tapping Guide:

The Enigmatic Realm of **Machine Tapping Guide**: Unleashing the Language is Inner Magic

In a fast-paced digital era where connections and knowledge intertwine, the enigmatic realm of language reveals its inherent magic. Its capacity to stir emotions, ignite contemplation, and catalyze profound transformations is nothing short of extraordinary. Within the captivating pages of **Machine Tapping Guide** a literary masterpiece penned with a renowned author, readers set about a transformative journey, unlocking the secrets and untapped potential embedded within each word. In this evaluation, we shall explore the book's core themes, assess its distinct writing style, and delve into its lasting effect on the hearts and minds of those that partake in its reading experience.

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