



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	1.80	0.630	1.80	0.709
2-56		50	0.700	5/64	0.781
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	0.735	43	0.890
3-56		45	0.710	3.30	0.900
4-40		43	0.690	38	1.015
4-48		42	0.665	2.60	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	2.90	1.142	3.20	1.260
6-32		35	1.065	1.8	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		15	1.800	7	2.010
	M6 x 1.00	5.00	1.969	7/32	2.188
1/4-20		7	2.010	1	2.280
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	19/64	2.969
3/8-16		9/16	3.125	5	3.480
3/8-24		O	3.320	T	3.680
	M10 x 1.50	8.50	3.348	12	3.680
	M10 x 1.25	8.75	3.425	9.40	3.701
				V	4.040
3/16-14		U	3.690	2	4.130
3/16-20		25/64	3.608	2	4.429
				11.20	4.529
	M12 x 1.75	10.25	4.018	11.50	4.529
	M12 x 1.25	10.80	4.252	15/32	4.692
		27/64	4.219	12.25	4.620
1/2-13		29/64	4.531	13.25	5.158
1/2-20			4.724	33/64	5.158
	M14 x 2.00	12.00	4.844	17/32	5.312
9/16-12		31/64	4.844	13.50	5.315
9/16-18		33/64	5.158		

Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
5/8-11		17/32	5.312	14.75	5.607
5/8-18		37/64	5.781	15.25	6.004
	M16 x 2.50	14.00	5.512	19/32	5.628
	M16 x 1.50	14.50	5.709	15.25	6.004
	M16 x 2.50	15.50	6.102	39/64	6.094
	M16 x 1.50	16.50	6.496	17.25	6.791
3/4-10		21/32	6.642	45/64	7.251
3/4-16		11/16	6.875	23/32	7.188
	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		49/64	7.656	"	"
7/8-14		13/16	8.125	"	"
	M24 x 3.00	21.00	8.208	"	"
	M24 x 2.00	22.00	8.661	"	"
1-8		7/8	8.750	"	"
1-12		55/64	8.619	"	"
	M27 x 3.00	24.00	9.449	"	"
	M27 x 2.00	25.00	9.843	"	"
1 1/8-7		63/64	9.844	"	"
1 1/8-12		1 3/64	1.0400	"	"
	M30 x 3.00	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 3.00	29.50	1.1814	"	"
	M33 x 2.00	31.00	1.2206	"	"
1 3/8-6		1 7/32	1.2188	"	"
1 3/8-12		1 19/64	1.2909	"	"
	M36 x 4.00	32.50	1.2990	"	"
	M36 x 3.00	33.50	1.2992	"	"
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, NPSF

Nominal Pipe Tap Size	NPT & NPTF					NPSF
	Metric Equivalent	WSS Equivalent	NPSM	NPSC	NPSF	
1/16-27	C (1.412)	A (1.234)	—	—	290	O (1.248)
1/8-27	O (1.312)	27/64	T (1.365)	O (1.303)	—	R (1.308)
1/4-18	7/16	27/64	15/32	27/64	27/64	27/64
3/8-18	9/16	9/16	400**	27/64	27/64	27/64
1/2-14	45/64	13/16	15.0 mm	15.0 mm	15.0 mm	15.0 mm
3/4-14	29/32	27/64	61/64	59/64	59/64	59/64
1-11 1/2	1 5/64	1 1/8	1 13/64	1 5/32	1 5/32	1 5/32
1 1/2-11 1/2	1 31/64	1 5/16	1 39/64	1 1/2	—	—
1 3/4-11 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

**Fred Herbert Colvin, Lester Gray
French**



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Table of Contents Machine Tapping Guide

1. Understanding the eBook Machine Tapping Guide
 - The Rise of Digital Reading Machine Tapping Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Machine Tapping Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Machine Tapping Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Machine Tapping Guide
 - Personalized Recommendations
 - Machine Tapping Guide User Reviews and Ratings

- Machine Tapping Guide and Bestseller Lists
- 5. Accessing Machine Tapping Guide Free and Paid eBooks
 - Machine Tapping Guide Public Domain eBooks
 - Machine Tapping Guide eBook Subscription Services
 - Machine Tapping Guide Budget-Friendly Options
- 6. Navigating Machine Tapping Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Machine Tapping Guide Compatibility with Devices
 - Machine Tapping Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Machine Tapping Guide
 - Highlighting and Note-Taking Machine Tapping Guide
 - Interactive Elements Machine Tapping Guide
- 8. Staying Engaged with Machine Tapping Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Machine Tapping Guide
- 9. Balancing eBooks and Physical Books Machine Tapping Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Machine Tapping Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Machine Tapping Guide
 - Setting Reading Goals Machine Tapping Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Machine Tapping Guide
 - Fact-Checking eBook Content of Machine Tapping Guide
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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