

TAP-DRILL SELECTOR

NOTE ON SELECTING TAP-DRILL SIZES: The tap drill sizes shown on this card give the theoretical tap drill size for approximately 60% and 75% of full thread depth. Generally, it is recommended that drill sizes be selected in the 60% range as these sizes will provide about 90% of the potential holding power. Drill sizes in the 75% range are recommended for shallow hole tapping (less than 1 1/2 times the hole diameter in soft metals and mild steel).

FOR 60% THREAD—SELECT DRILL OPPOSITE BLUE TAP SIZE
FOR 75% THREAD—SELECT DRILL OPPOSITE RED TAP SIZE

TAP SIZE		DRILL SIZE	TAP SIZE		DRILL SIZE	TAP SIZE		DRILL SIZE
60%	75%		60%	75%		60%	75%	
		48			18	M8x1		7.0mm
		1.95mm			11/64			7.25mm
		5/64			17			7.30mm
	3-48	47			4.40mm			L
	M2.5x.45	2.00mm		12-24	16			7.40mm
		2.05mm			4.50mm			M
		46			15			7.50mm
3-48	3-56	45		M5.5x.9	4.60mm			19/64
M2.5x.45	M2.6x.45	2.10mm	12-24	12-28	14			7.60mm
3-56	4-36	2.15mm			13			N
		44			4.70mm		M9x1.25	7.70mm
M2.6x.45		2.20mm	M5.5x.9		4.75mm			7.75mm
4-36	4-40	2.25mm	12-28		3/16			7.80mm
		43			12			7.90mm
		2.30mm			4.80mm		3/8-16	5/16
		2.35mm			11	M9x1.25	M9x1	8.00mm
4-40	4-48	42			4.90mm			O
		3/32			10			8.10mm
	M3x.6	2.40mm		M6x1	9	M9x1		8.20mm
4-48		41			5.00mm			P
		2.45mm			8			8.25mm
		40		1/4-20	5.10mm			8.30mm
M3x.6	M3x.5	2.50mm			7	3/8-16	1/8-27NPT	21/64
	5-40	39			13/64			8.40mm
		38			6		3/8-24	O
M3x.5	5-44	2.60mm	M6x1		5.20mm		M10x1.5	8.50mm
5-40		37		M6x.75	5			8.60mm
		2.70mm			5.25mm			R
5-44	6-32	36			5.30mm	3/8-24		8.70mm
		7/64	1/4-20		4	1/8-27NPT		11/32
		35	M6x.75	1/4-28	5.40mm		M10x1.25	8.75mm
		2.80mm			3	M10x1.5		8.80mm
		34			5.50mm			S
6-32	6-40	33			7/32		M10x1	8.90mm
	M3.5x.6	2.90mm	1/4-28		5.60mm	M10x1.25		9.00mm
		32			2			T
M3.5x.6		3.00mm			5.70mm			9.10mm
6-40		31			5.75mm			23/64
		1/8			1	M10x1		9.20mm
		3.20mm			5.80mm			9.30mm
	M4x.75	3.25mm			5.90mm		7/16-14	U
		30		M7x1	A		M11x1.5	9.40mm
	M4x.7	3.30mm			15/64			9.50mm
M4x.75		3.40mm			6.00mm			3/8
M4x.7	8-32	29			B			V
		3.50mm			6.10mm			9.60mm
	8-36	28	M7x1		C			9.70mm
8-32		9/64		M7x.75	6.20mm			9.75mm
		3.60mm			D	M11x1.5		9.80mm
8-36		27			6.25mm	7/16-14		W
		3.70mm			6.30mm		7/16-20	9.90mm
		26	M7x.75		E			25/64
	M4.5x.75	3.75mm		5/16-18	1/4			10.00mm
	10-24	25			6.40mm			X
		3.80mm			6.50mm		M12x1.75	10.20mm
		24			F			Y
M4.5x.75		3.90mm			6.60mm			13/32
		23			G	M12x1.75	M12x1.5	10.50mm
		5/32		M8x1.25	17/64		1/2-13	27/64
10-24		22	5/16-18		6.75mm	M12x1.5	M12x1.25	10.75mm
	M5x1	4.00mm			H	M12x1.25		11.00mm
	10-32	21			6.80mm	1/2-13		7/16
		20		5/16-24	6.90mm			11.50mm
	M5x.9	4.10mm	M8x1.25	M8x1	I		1/2-20	29/64
	M5x.8	4.20mm			J			15/32
M5x1		19			7.00mm			12.00mm
M5x.9		4.25mm	5/16-24		K			31/64
M5x.8		4.30mm			9/32			12.50mm
								1/2

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WARNING: Eye protection and appropriate safety equipment recommended with use of these tools.