

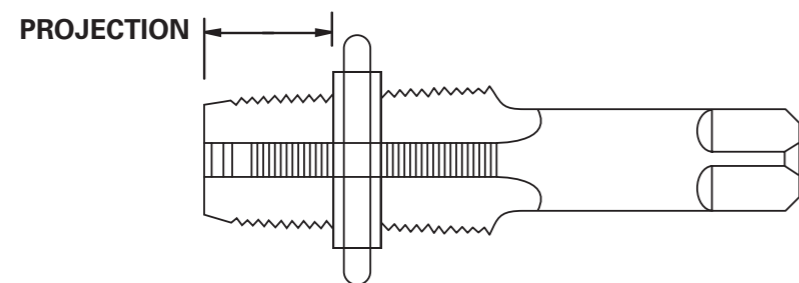


Pipe Tap (Limit)

Nominal Size Inches	Threads per Inch	Projection* Inches	Projection Tolerance + or -	Taper per Foot Limits		Reference Dimensions	
				Min.	Max.	Length (L ₁)	Tap Drill Size** NPT, ANPT, NPTF
1/16	27	.312	.063	.719	.781	.160	C
1/8	27	.312	.063	.719	.781	.1615	Q
1/8	18	.459	.063	.719	.781	.2278	7/16
3/8	18	.454	.063	.719	.781	.240	9/16
1/2	14	.579	.063	.719	.781	.320	45/64
3/4	14	.565	.063	.719	.781	.339	29/32
1"	11-1/2	.678	.094	.719	.781	.400	1-9/64
1-1/4	11-1/2	.686	.094	.719	.781	.420	1-31/64
1-1/2	11-1/2	.699	.094	.719	.781	.420	1-23/32
2"	11-1/2	.667	.094	.719	.781	.436	2-3/16
2-1/2	8	.925	.094	.734	.781	.682	2-39/64
3"	8	.925	.094	.734	.781	.766	3-15/64
3-1/2	8	.938	.125	.734	.781	.821	...
4"	8	.950	.125	.734	.781	.844	...

* Distance small end of tap projects through L1 Taper Thread Ring Gage.

** Recommended size given permit direct tapping without reaming the hole, but only give a full thread for approx. the L1 length.



15 TAP DRILL SIZES - UNIFIED THREAD

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
#0	-	80	-	-	.0465	.0514	.0514	.0470	.0478	.0486	.0494	.0503
#1	64	-	-	-	.0561	.0623	.0623	.0568	.0578	.0588	.0598	.0608
	-	72	-	-	.0580	.0635	.0635	.0586	.0595	.0604	.0613	.0622
#2	56	-	-	-	.0667	.0737	.0737	.0674	.0686	.0698	.0709	.0721
	-	64	-	-	.0691	.0753	.0753	.0698	.0708	.0718	.0728	.0738
#3	48	-	-	-	.0764	.0845	.0845	.0774	.0787	.0801	.0814	.0828
	-	56	-	-	.0797	.0865	.0865	.0804	.0816	.0828	.0839	.0851
#4	40	-	-	-	.0849	.0939	.0939	.0860	.0876	.0893	.0909	.0925
	-	48	-	-	.0894	.0968	.0968	.0904	.0917	.0931	.0944	.0958
#5	40	-	-	-	.0979	.1062	.1062	.0990	.1006	.1023	.1039	.1055
	-	44	-	-	.1004	.1079	.1079	.1014	.1029	.1043	.1058	.1073
#6	32	-	-	-	.1040	.1140	.1140	.1055	.1076	.1096	.1116	.1136
	-	40	-	-	.1110	.1190	.1186	.1120	.1136	.1153	.1169	.1185
#8	32	-	-	-	.1300	.1390	.1389	.1315	.1336	.1356	.1376	.1396
	-	36	-	-	.1340	.1420	.1416	.1351	.1369	.1387	.1405	.1424
#10	24	-	-	-	.1450	.1560	.1555	.1467	.1494	.1521	.1548	.1575
	-	32	-	-	.1560	.1640	.1641	.1575	.1596	.1616	.1636	.1656
#12	24	-	-	-	.1710	.1810	.1807	.1727	.1754	.1781	.1808	.1835
	-	28	-	-	.1770	.1860	.1857	.1789	.1812	.1835	.1858	.1882
1/4	-	-	32	-	.1820	.1900	.1895	.1835	.1856	.1876	.1896	.1916
	20	-	-	-	.1960	.2070	.2067	.1980	.2013	.2045	.2078	.2110
5/16	-	28	-	-	.2110	.2200	.2190	.2129	.2152	.2175	.2198	.2222
	-	-	32	-	.2160	.2240	.2229	.2175	.2196	.2216	.2236	.2256
3/8	18	-	-	-	.2520	.2650	.2630	.2548	.2584	.2620	.2656	.2692
	-	-	-	20	.2580	.2700	.2680	.2605	.2638	.2670	.2703	.2735
7/16	-	24	-	-	.2670	.2770	.2754	.2692	.2719	.2746	.2773	.2800
	-	-	-	28	.2740	.2820	.2807	.2754	.2777	.2800	.2823	.2847
1/2	-	-	32	-	.2790	.2860	.2847	.2800	.2821	.2841	.2861	.2881
	16	-	-	-	.3070	.3210	.3182	.3101	.3141	.3182	.3222	.3263
9/16	-	-	-	20	.3210	.3320	.3297	.3230	.3263	.3295	.3328	.3360
	-	24	-	-	.3300	.3400	.3372	.3317	.3344	.3371	.3398	.3425
5/8	-	-	32	-	.3410	.3490	.3469	.3425	.3446	.3466	.3486	.3506
	14	-	-	-	.3600	.3760	.3717	.3633	.3679	.3726	.3772	.3818
1 1/8	-	-	-	16	.3700	.3840	.3800	.3726	.3766	.3807	.3847	.3888
	-	20	-	-	.3830	.3950	.3916	.3855	.3888	.3920	.3953	.3985
1 1/4	-	-	28	-	.3990	.4070	.4051	.4004	.4027	.4050	.4073	.4097
	-	-	-	32	.4040	.4110	.4094	.4050	.4071	.4091	.4111	.4131
1 3/8	13	-	-	-	.4170	.4340	.4284	.4201	.4251	.4301	.4351	.4400
	-	-	-	16	.4320	.4460	.4419	.4351	.4391	.4432	.4472	.4513
1 1/2	-	20	-	-	.4460	.4570	.4537	.4480	.4513	.4545	.4578	.4610
	-	-	28	-	.4610	.4700	.4676	.4629	.4652	.4675	.4698	.4722
1 7/8	-	-	-	32	.4660	.4740	.4719	.4675	.4696	.4716	.4736	.4756
	12	-	-	-	.4720	.4900	.4843	.4759	.4813	.4867	.4921	.4976
2	-	-	-	16	.4950	.5090	.5040	.4976	.5016	.5057	.5097	.5138
	-	18	-	-	.5020	.5150	.5106	.5048	.5084	.5120	.5156	.5192
2 1/4	-	-	-	20	.5080	.5200	.5162	.5105	.5138	.5170	.5203	.5235
	-	-	24	-	.5170	.5270	.5244	.5192	.5219	.5246	.5273	.5300
2 3/8	-	-	-	28	.5240	.5320	.5301	.5254	.5277	.5300	.5323	.5347
	-	-	-	32	.5290	.5360	.5344	.5300	.5321	.5341	.5361	.5381
5/8	11	-	-	-	.5270	.5460	.5391	.5305	.5364	.5423	.5482	.5541



Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
5/8	-	-	-	12	.5350	.5530	.5463	.5384	.5438	.5492	.5546	.5601
	-	-	-	16	.5570	.5710	.5662	.5601	.5641	.5682	.5722	.5763
	-	18	-	-	.5650	.5780	.5730	.5673	.5709	.5745	.5781	.5817
	-	-	-	20	.5710	.5820	.5787	.5730	.5763	.5795	.5828	.5860
	-	-	24	-	.5800	.5900	.5869	.5817	.5844	.5871	.5898	.5925
	-	-	-	28	.5860	.5950	.5926	.5879	.5902	.5925	.5948	.5972
11/16	-	-	-	32	.5910	.5980	.5969	.5925	.5946	.5966	.5986	.6006
	-	-	-	12	.5970	.6150	.6085	.6009	.6063	.6117	.6171	.6226
	-	-	-	16	.6200	.6340	.6284	.6226	.6266	.6307	.6347	.6388
	-	-	-	20	.6330	.6450	.6412	.6355	.6388	.6420	.6453	.6485
	-	-	24	-	.6420	.6520	.6494	.6442	.6469	.6496	.6523	.6550
	-	-	-	28	.6490	.6570	.6551	.6504	.6527	.6550	.6573	.6597
3/4	-	-	-	32	.6540	.6610	.6594	.6550	.6571	.6591	.6611	.6631
	10	-	-	-	.6420	.6630	.6545	.6461	.6526	.6591	.6656	.6721
	-	-	-	12	.6600	.6780	.6707	.6634	.6688	.6742	.6796	.6851
	-	16	-	-	.6820	.6960	.6908	.6851	.6891	.6932	.6972	.7013
	-	-	20	-	.6960	.7070	.7037	.6980	.7013	.7045	.7078	.7110
	-	-	-	28	.7110	.7200	.7176	.7129	.7152	.7175	.7198	.7222
13/16	-	-	-	32	.7160	.7240	.7219	.7175	.7196	.7216	.7236	.7256
	-	-	-	12	.7220	.7400	.7329	.7259	.7313	.7367	.7421	.7476
	-	-	-	16	.7450	.7590	.7533	.7476	.7516	.7557	.7597	.7638
	-	-	20	-	.7580	.7700	.7662	.7605	.7638	.7670	.7703	.7735
	-	-	-	28	.7740	.7820	.7801	.7754	.7777	.7800	.7823	.7847
	-	-	-	32	.7790	.7860	.7844	.7800	.7821	.7841	.7861	.7881
7/8	9	-	-	-	.7550	.7780	.7681	.7595	.7668	.7740	.7812	.7884
	-	-	-	12	.7850	.8030	.7948	.7884	.7938	.7992	.8046	.8101
	-	14	-	-	.7980	.8140	.8068	.8008	.8054	.8101	.8147	.8193
	-	-	-	16	.8070	.8210	.8158	.8101	.8141	.8182	.8222	.8263
	-	-	20	-	.8210	.8320	.8287	.8230	.8263	.8295	.8328	.8360
	-	-	-	28	.8360	.8450	.8426	.8379	.8402	.8425	.8448	.8472
15/16	-	-	-	32	.8410	.8490	.8469	.8425	.8446	.8466	.8486	.8506
	-	-	-	12	.8470	.8650	.8575	.8509	.8563	.8617	.8671	.8726
	-	-	-	16	.8700	.8840	.8783	.8726	.8766	.8807	.8847	.8888
	-	-	20	-	.8830	.8950	.8912	.8855	.8888	.8920	.8953	.8985
	-	-	-	28	.8990	.9070	.9051	.9004	.9027	.9050	.9073	.9097
	-	-	-	32	.9040	.9110	.9094	.9050	.9071	.9091	.9111	.9131
1"	8	-	-	-	.8650	.8900	.8797	.8701	.8782	.8863	.8945	.9026
	-	12	-	-	.9100	.9280	.9198	.9134	.9188	.9242	.9296	.9351
	-	-	-	16	.9320	.9460	.9408	.9351	.9391	.9432	.9472	.9513
	-	-	20	-	.9460	.9570	.9537	.9480	.9513	.9545	.9578	.9610
	-	-	-	28	.9610	.9700	.9676	.9629	.9652	.9675	.9698	.9722
	-	-	-	32	.9660	.9740	.9719	.9675	.9696	.9716	.9736	.9756
1*1/16	-	-	-	8	.9270	.9520	.9422	.9326	.9407	.9488	.9570	.9651
	-	-	-	12	.9720	.9900	.9823	.9759	.9813	.9867	.9921	.9976
	-	-	-	16	.9950	1.0090	1.0033	.9976	1.0016	1.0057	1.0097	1.0138
	-	-	18	-	1.0020	1.0150	1.0105	1.0048	1.0084	1.0120	1.0156	1.0192
	-	-	-	20	1.0080	1.0200	1.0162	1.0105	1.0138	1.0170	1.0203	1.0235
	-	-	-	28	1.0240	1.0320	1.0301	1.0254	1.0277	1.0300	1.0323	1.0347
1*1/8	7	-	-	-	.9700	.9980	.9875	.9765	.9858	.9951	1.0044	1.0137
	-	-	-	8	.9900	1.0150	1.0047	.9951	1.0032	1.0113	1.0195	1.0276
	-	12	-	-	1.0350	1.0530	1.0448	1.0384	1.0438	1.0492	1.0546	1.0601
	-	-	-	16	1.0570	1.0710	1.0658	1.0601	1.0641	1.0682	1.0722	1.0763
	-	-	18	-	1.0650	1.0780	1.0730	1.0673	1.0709	1.0745	1.0781	1.0817
	-	-	-	20	1.0710	1.0820	1.0787	1.0730	1.0763	1.0795	1.0828	1.0860

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
1*1/8	-	-	-	28	1.0860	1.0950	1.0926	1.0879	1.0902	1.0925	1.0948	1.0972
1*3/16	-	-	-	8	1.0520	1.0770	1.0672	1.0576	1.0657	1.0738	1.0820	1.0901
	-	-	-	12	1.0970	1.1150	1.1073	1.1009	1.1063	1.1117	1.1171	1.1226
	-	-	-	16	1.1200	1.1340	1.1283	1.1226	1.1266	1.1307	1.1347	1.1388
	-	-	18	-	1.1270	1.1400	1.1355	1.1298	1.1334	1.1370	1.1406	1.1442
	-	-	-	20	1.1330	1.1450	1.1412	1.1355	1.1388	1.1420	1.1453	1.1485
	-	-	-	28	1.1490	1.1570	1.1551	1.1504	1.1527	1.1550	1.1573	1.1597
1*1/4	7	-	-	-	1.0950	1.1230	1.1125	1.1015	1.1108	1.1201	1.1294	1.1387
	-	-	-	8	1.1150	1.1400	1.1297	1.1201	1.1282	1.1363	1.1445	1.1526
	-	12	-	-	1.1600	1.1780	1.1698	1.1634	1.1688	1.1742	1.1796	1.1851
	-	-	-	16	1.1820	1.1960	1.1908	1.1851	1.1891	1.1932	1.1972	1.2013
	-	-	18	-	1.1900	1.2030	1.1980	1.1923	1.1959	1.1995	1.2031	1.2067
	-	-	-	20	1.1960	1.2070	1.2037	1.1980	1.2013	1.2045	1.2078	1.2110
1*5/16	-	-	-	28	1.2110	1.2200	1.2176	1.2129	1.2152	1.2175	1.2198	1.2222
	-	-	-	8	1.1770	1.2020	1.2176	1.1826	1.1907	1.1988	1.2070	1.2151
	-	-	-	12	1.2220	1.2400	1.2323	1.2259	1.2313	1.2367	1.2421	1.2476
	-	-	-	16	1.2450	1.2590	1.2533	1.2476	1.2516	1.2557	1.2597	1.2638
	-	-	18	-	1.2520	1.2650	1.2605	1.2548	1.2584	1.2620	1.2656	1.2692
	-	-	-	20	1.2580	1.2700	1.2662	1.2605	1.2638	1.2670	1.2703	1.2735
1*3/8	-	-	-	28	1.2740	1.2820	1.2801	1.2754	1.2777	1.2800	1.2823	1.2847
	6	-	-	-	1.1950	1.2250	1.2146	1.2018	1.2126	1.2235	1.2343	1.2451
	-	-	-	8	1.2400	1.2650	1.2547	1.2451	1.2532	1.2613	1.2695	1.2776
	-	12	-	-	1.2850	1.3030	1.2948	1.2884	1.2938	1.2992	1.3046	1.3101
	-	-	-	16	1.3070	1.3210	1.3158	1.3101	1.3141	1.3182	1.3222	1.3263
	-	-	18	-	1.3150	1.3280	1.3230	1.3173	1.3209	1.3245	1.3281	1.3317
1*7/16	-	-	-	20	1.3210	1.3320	1.3287	1.3230	1.3263	1.3295	1.3328	1.3360
	-	-	-	28	1.3360	1.3450	1.3426	1.3379	1.3402	1.3425	1.3448	1.3472
	-	-	-	6	1.2570	1.2880	1.2770	1.2643	1.2751	1.2860	1.2968	1.3076
	-	-	-	8	1.3020	1.3270	1.3172	1.3076	1.3157	1.3238	1.3320	1.3401
	-	-	-	12	1.3470	1.3650	1.3573	1.3509	1.3563	1.3617	1.3671	1.3726
	-	-	-	16	1.3700	1.3840	1.3783	1.3726	1.3766	1.3807	1.3847	1.3888
1*1/2	-	-	18	-	1.3770	1.3900	1.3855	1.3798	1.3834	1.3870	1.3906	1.3942
	-	-	-	20	1.3830	1.3950	1.3912	1.3855	1.3888	1.3920	1.3953	1.3985
	-	-	-	28	1.3990	1.4070	1.4051	1.4004	1.4027	1.4050	1.4073	1.4097
	6	-	-	-	1.3200	1.3500	1.3396	1.3268	1.3376	1.3485	1.3593	1.3701
	-	-	-	8	1.3650	1.3900	1.3797	1.3701	1.3782	1.3863	1.3945	1.4026
	-	12	-	-	1.4100	1.4280	1.4198	1.4134	1.4188	1.4242	1.4296	1.4351
1*9/16	-	-	-	16	1.4320	1.4460	1.4408	1.4351	1.4391	1.4432	1.4472	1.4513
	-	-	18	-	1.4400	1.4520	1.4480	1.4423	1.4459	1.4495	1.4531	1.4567
	-	-	-	20	1.4460	1.4570	1.4537	1.4480	1.4513	1.4545	1.4578	1.4610
	-	-	-	28	1.4610	1.4700	1.4676	1.4629	1.4652	1.4675	1.4698	1.4722
	-	-	-	6	1.3820	1.4130	1.4021	1.3893	1.4001	1.4110	1.4218	1.4326
	-	-	-	8	1.4270	1.4520	1.4422	1.4326	1.4407	1.4488	1.4570	1.4651
1*5/8	-	-	-	12	1.4720	1.4900	1.4823	1.4759	1.4813	1.4867	1.4921	1.4976
	-	-	-	16	1.4950	1.5090	1.5033	1.4976	1.5			



SOLID CARBIDE THREAD MILLS

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COMBO TAPS

COMBO TAPS

SPIRAL FLUTE TAPS

SPIRAL FLUTE TAPS

SPIRAL POINT TAPS

SPIRAL POINT TAPS

STRAIGHT FLUTE TAPS

STRAIGHT FLUTE TAPS

FORMING TAPS

FORMING TAPS

SCREW THREAD INSERT TAPS

SCREW THREAD INSERT TAPS

PIPE TAPS

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TECHNICAL DATA

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Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
1*11/16	-	-	-	8	1.5520	1.5770	1.5672	1.5576	1.5657	1.5738	1.5820	1.5901
	-	-	-	12	1.5970	1.6150	1.6073	1.6009	1.6063	1.6117	1.6171	1.6226
	-	-	-	16	1.6200	1.6340	1.6283	1.6226	1.6266	1.6307	1.6347	1.6388
	-	-	18	-	1.6270	1.6400	1.6355	1.6298	1.6334	1.6370	1.6406	1.6442
1*3/4	-	-	-	20	1.6330	1.6450	1.6412	1.6355	1.6388	1.6420	1.6453	1.6485
	5	-	-	-	1.5340	1.5680	1.5575	1.5422	1.5552	1.5681	1.5811	1.5941
	-	-	-	6	1.5700	1.6000	1.5896	1.5768	1.5876	1.5985	1.6093	1.6201
	-	-	-	8	1.6150	1.6400	1.6297	1.6201	1.6282	1.6363	1.6445	1.6526
1*13/16	-	-	-	12	1.6600	1.6780	1.6698	1.6634	1.6688	1.6742	1.6796	1.6851
	-	-	-	16	1.6820	1.6960	1.6908	1.6851	1.6891	1.6932	1.6972	1.7013
	-	-	-	20	1.6960	1.7070	1.7037	1.6980	1.7013	1.7045	1.7078	1.7110
	-	-	-	6	1.6320	1.6630	1.6521	1.6393	1.6501	1.6610	1.6718	1.6826
1*7/8	-	-	-	8	1.6770	1.7020	1.6922	1.6826	1.6907	1.6988	1.7070	1.7151
	-	-	-	12	1.7220	1.7400	1.7323	1.7259	1.7313	1.7367	1.7421	1.7476
	-	-	-	16	1.7450	1.7590	1.7533	1.7476	1.7516	1.7557	1.7597	1.7638
	-	-	-	20	1.7580	1.7700	1.7662	1.7605	1.7638	1.7670	1.7703	1.7735
1*15/16	-	-	-	6	1.6950	1.7250	1.7146	1.7018	1.7126	1.7235	1.7343	1.7451
	-	-	-	8	1.7400	1.7650	1.7547	1.7451	1.7532	1.7613	1.7695	1.7776
	-	-	-	12	1.7850	1.8030	1.7948	1.7884	1.7938	1.7992	1.8046	1.8101
	-	-	-	16	1.8070	1.8210	1.8158	1.8101	1.8141	1.8182	1.8222	1.8263
2"	-	-	-	20	1.8210	1.8320	1.8287	1.8230	1.8263	1.8295	1.8328	1.8360
	-	-	-	6	1.7570	1.7880	1.7771	1.7643	1.7751	1.7860	1.7968	1.8076
	-	-	-	8	1.8020	1.8270	1.8172	1.8076	1.8157	1.8238	1.8320	1.8401
	-	-	-	12	1.8470	1.8650	1.8573	1.8509	1.8563	1.8617	1.8671	1.8726
2*1/8	-	-	-	16	1.8700	1.8840	1.8783	1.8726	1.8766	1.8807	1.8847	1.8888
	-	-	-	20	1.8830	1.8950	1.8912	1.8855	1.8888	1.8920	1.8953	1.8985
	4 1/2	-	-	-	1.7590	1.7950	1.7861	1.7691	1.7835	1.7979	1.8124	1.8268
	-	-	-	6	1.8200	1.8500	1.8396	1.8268	1.8376	1.8485	1.8593	1.8701
2*1/4	-	-	-	8	1.8650	1.8900	1.8797	1.8701	1.8782	1.8863	1.8945	1.9026
	-	-	-	12	1.9100	1.9280	1.9198	1.9134	1.9188	1.9242	1.9296	1.9351
	-	-	-	16	1.9320	1.9460	1.9408	1.9351	1.9391	1.9432	1.9472	1.9513
	-	-	-	20	1.9460	1.9570	1.9537	1.9480	1.9513	1.9545	1.9578	1.9610
2*3/8	-	-	-	6	1.9450	1.9750	1.9646	1.9518	1.9626	1.9735	1.9843	1.9951
	-	-	-	8	1.9900	2.0150	2.0047	1.9951	2.0032	2.0113	2.0195	2.0276
	-	-	-	12	2.0350	2.0530	2.0448	2.0384	2.0438	2.0492	2.0546	2.0601
	-	-	-	16	2.0570	2.0710	2.0658	2.0601	2.0641	2.0682	2.0722	2.0763
2*1/2	-	-	-	20	2.0710	2.0820	2.0787	2.0730	2.0763	2.0795	2.0828	2.0860
	4 1/2	-	-	-	2.0090	2.0450	2.0361	2.0191	2.0335	2.0479	2.0624	2.0768
	-	-	-	6	2.0700	2.1000	2.0896	2.0768	2.0876	2.0985	2.1093	2.1201
	-	-	-	8	2.1150	2.1400	2.1297	2.1201	2.1282	2.1363	2.1445	2.1526
2*3/4	-	-	-	12	2.1600	2.1780	2.1698	2.1634	2.1688	2.1742	2.1796	2.1851
	-	-	-	16	2.1820	2.1960	2.1908	2.1851	2.1891	2.1932	2.1972	2.2013
	-	-	-	20	2.1960	2.2070	2.2037	2.1980	2.2013	2.2045	2.2078	2.2110
	-	-	-	6	2.1950	2.2260	2.2146	2.2018	2.2126	2.2235	2.2343	2.2451
2*1/8	-	-	-	8	2.2400	2.2650	2.2547	2.2451	2.2532	2.2613	2.2695	2.2776
	-	-	-	12	2.2850	2.3030	2.2948	2.2884	2.2938	2.2992	2.3046	2.3101
	-	-	-	16	2.3070	2.3210	2.3158	2.3101	2.3141	2.3182	2.3222	2.3263
	-	-	-	20	2.3210	2.3320	2.3287	2.3230	2.3263	2.3295	2.3328	2.3360
2*3/8	4	-	-	-	2.2290	2.2670	2.2594	2.2402	2.2564	2.2727	2.2889	2.3052
	-	-	-	6	2.3200	2.3500	2.3396	2.3268	2.3376	2.3485	2.3593	2.3701
	-	-	-	8	2.3650	2.3900	2.3797	2.3701	2.3782	2.3863	2.3945	2.4026
	-	-	-	12	2.4100	2.4280	2.4198	2.4134	2.4188	2.4242	2.4296	2.4351
2*1/2	-	-	-	16	2.4320	2.4460	2.4408	2.4351	2.4391	2.4432	2.4472	2.4513
	-	-	-	20	2.4460	2.4570	2.4537	2.4480	2.4513	2.4545	2.4578	2.4610

16 TAP DRILL SIZES - METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M1	0.25	-	.729	.798	0.74	.0291	0.76	.0298	0.77	.0304	0.79	.0311	0.81	.0317
	-	0.2	.783	.841	0.79	.0312	0.81	.0317	0.82	.0322	0.83	.0327	0.84	.0332
M1.1	0.25	-	.829	.898	0.84	.0331	0.86	.0337	0.87	.0344	0.89	.0350	0.91	.0356
	-	0.2	.883	.941	0.89	.0351	0.91	.0356	0.92	.0361	0.93	.0367	0.94	.0372
M1.2	0.25	-	.929	.998	0.94	.0370	0.96	.0377	0.97	.0383	0.99	.0389	1.01	.0396
	-	0.2	.983	1.041	0.99	.0391	1.01	.0396	1.02	.0401	1.03	.0406	1.04	.0411
M1.4	0.3	-	1.075	1.159	1.09	.0428	1.11	.0436	1.13	.0444	1.15	.0451	1.17	.0459
	-	0.2	1.183	1.241	1.19	.0469	1.21	.0474	1.22	.0480	1.23	.0485	1.24	.0490
M1.6	0.35	-	1.221	1.321	1.24	.0487	1.26	.0496	1.28	.0505	1.30	.0514	1.33	.0523
	-	0.2	1.383	1.441	1.39	.0548	1.41	.0553	1.42	.0558	1.43	.0563	1.44	.0569
M1.7	0.35	-	1.321	1.421	1.34	.0526	1.36	.0535	1.38	.0544	1.40	.0553	1.43	.0562
	-	0.3	1.375	1.459	1.39	.0547	1.41	.0554	1.43	.0562	1.45	.0570	1.47	.0577
	-	0.25	1.429	1.498	1.44	.0567	1.46	.0573	1.47	.0580	1.49	.0586	1.51	.0593
M1.8	-	0.2	1.483	1.541	1.49	.0587	1.51	.0593	1.52	.0598	1.53	.0603	1.54	.0608
	0.35	-	1.421	1.521	1.44	.0565	1.46	.0574	1.48	.0583	1.50	.0592	1.53	.0601
M2	-	0.2	1.583	1.641	1.59	.0627	1.61	.0632	1.62	.0637	1.63	.0642	1.64	.0647
	0.4	-	1.567	1.679	1.58	.0624	1.61	.0634	1.64	.0644	1.66	.0654	1.69	.0665
M2.2	-	0.25	1.729	1.798	1.74	.0685	1.76	.0692	1.77	.0698	1.79	.0704	1.81	.0711
	0.45	-	1.713	1.838	1.73	.0682	1.76	.0694	1.79	.0705	1.82	.0717	1.85	.0728
M2.3	-	0.25	1.929	1.998	1.94	.0764	1.96	.0770	1.97	.0777	1.99	.0783	2.01	.0789
	0.4	-	1.867	1.979	1.88	.0742	1.91	.0752	1.94	.0762	1.96	.0773	1.99	.0783
M2.5	-	0.35	1.921	2.021	1.94	.0762	1.96	.0771	1.98	.0780	2.00	.0789	2.03	.0798
	-	0.25	2.029	2.098	2.04	.0803	2.06	.0810	2.07	.0816	2.09	.0822	2.11	.0829
M2.6	0.45	-	2.013	2.138	2.03	.0800	2.06	.0812	2.09	.0823	2.12	.0835	2.15	.0846
	-	0.35	2.121	2.221	2.14	.0841	2.16	.0850	2.18	.0859	2.20	.0868	2.23	.0877
M3	0.45	-	2.113	2.238	2.13	.0840	2.16	.0851	2.19	.0863	2.22	.0874	2.25	.0886
	-	0.35	2.221	2.321	2.24	.0880	2.26	.0889	2.28	.0898	2.30	.0907	2.33	.0916
M3.5	0.5	-	2.459	2.599	2.48	.0977	2.51	.0989	2.55	.1002	2.58	.1015	2.61	.1028
	-	0.35	2.621	2.721	2.64	.1038	2.66	.1047	2.68	.1056	2.70	.1065	2.73	.1074
M4	0.6	-	2.850	3.010	2.88	.1132	2.92	.1148	2.95	.1163	2.99	.1178	3.03	.1194
	-	0.35	3.121	3.221	3.14	.1235	3.16	.1244	3.18	.1253	3.20	.1262	3.23	.1271
M4.5	0.7	-	3.242	3.422	3.27	.1288	3.32	.1306	3.36	.1324	3.41	.1342	3.45	.1360
	-	0.5	3.459	3.599	3.48	.1370	3.51	.1383	3.55	.1396	3.58	.1409	3.61	.1421
M5	0.75	-	3.688	3.878	3.72	.1465								

Y/G TECHNICAL DATA

Y/G TECHNICAL DATA

SOLID CARBIDE THREAD MILLS

SOLID CARBIDE THREAD MILLS

COMBO TAPS

COMBO TAPS

SPIRAL FLUTE TAPS

SPIRAL FLUTE TAPS

SPIRAL POINT TAPS

SPIRAL POINT TAPS

STRAIGHT FLUTE TAPS

STRAIGHT FLUTE TAPS

FORMING TAPS

FORMING TAPS

SCREW THREAD INSERT TAPS

SCREW THREAD INSERT TAPS

PIPE TAPS

PIPE TAPS

TECHNICAL DATA

TECHNICAL DATA

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M9	1.25	-	7.647	7.912	7.70	.3032	7.78	.3064	7.86	.3096	7.94	.3128	8.03	.3160
	-	1	7.917	8.153	7.96	.3134	8.03	.3160	8.09	.3185	8.16	.3211	8.22	.3236
	-	0.75	8.188	8.378	8.22	.3236	8.27	.3256	8.32	.3275	8.37	.3294	8.42	.3313
M10	-	0.5	8.459	8.599	8.48	.3339	8.51	.3352	8.55	.3364	8.58	.3377	8.61	.3390
	1.5	-	8.376	8.676	8.44	.3323	8.54	.3362	8.64	.3400	8.73	.3438	8.83	.3477
	-	1.25	8.647	8.912	8.70	.3426	8.78	.3458	8.86	.3490	8.94	.3521	9.03	.3553
M11	-	1	8.917	9.153	8.96	.3528	9.03	.3553	9.09	.3579	9.16	.3605	9.22	.3630
	-	0.75	9.188	9.378	9.22	.3630	9.27	.3649	9.32	.3669	9.37	.3688	9.42	.3707
	-	0.5	9.459	9.599	9.48	.3732	9.51	.3745	9.55	.3758	9.58	.3771	9.61	.3784
M12	1.5	-	9.376	9.676	9.44	.3717	9.54	.3755	9.64	.3794	9.73	.3832	9.83	.3870
	-	1	9.917	10.153	9.96	.3922	10.03	.3947	10.09	.3973	10.16	.3998	10.22	.4024
	-	0.75	10.188	10.378	10.22	.4024	10.27	.4043	10.32	.4062	10.37	.4081	10.42	.4101
M13	-	0.5	10.459	10.599	10.48	.4126	10.51	.4139	10.55	.4152	10.58	.4164	10.61	.4177
	1.75	-	10.106	10.441	10.18	.4008	10.30	.4053	10.41	.4098	10.52	.4143	10.64	.4187
	-	1.5	10.376	10.676	10.44	.4111	10.54	.4149	10.64	.4187	10.73	.4226	10.83	.4264
M14	-	1.25	10.647	10.912	10.70	.4213	10.78	.4245	10.86	.4277	10.94	.4309	11.03	.4341
	-	1	10.917	11.153	10.96	.4315	11.03	.4341	11.09	.4366	11.16	.4392	11.22	.4418
	-	0.75	11.188	11.378	11.22	.4418	11.27	.4437	11.32	.4456	11.37	.4475	11.42	.4494
M15	-	0.5	11.459	11.599	11.48	.4520	11.51	.4533	11.55	.4545	11.58	.4558	11.61	.4571
	-	1.75	11.106	11.441	11.18	.4402	11.30	.4447	11.41	.4492	11.52	.4536	11.64	.4581
	-	1.5	11.376	11.676	11.44	.4504	11.54	.4543	11.64	.4581	11.73	.4619	11.83	.4658
M16	-	1.25	11.647	11.912	11.70	.4607	11.78	.4639	11.86	.4671	11.94	.4703	12.03	.4735
	-	1	11.917	12.153	11.96	.4709	12.03	.4735	12.09	.4760	12.16	.4786	12.22	.4811
	-	0.75	12.188	12.378	12.22	.4811	12.27	.4830	12.32	.4850	12.37	.4869	12.42	.4888
M17	-	0.5	12.459	12.599	12.48	.4914	12.51	.4926	12.55	.4939	12.58	.4952	12.61	.4965
	2	-	11.835	12.210	11.92	.4694	12.05	.4745	12.18	.4796	12.31	.4847	12.44	.4898
	-	1.5	12.376	12.676	12.44	.4898	12.54	.4936	12.64	.4975	12.73	.5013	12.83	.5052
M18	-	1.25	12.647	12.912	12.70	.5000	12.78	.5032	12.86	.5064	12.94	.5096	13.03	.5128
	-	1	12.917	13.153	12.96	.5103	13.03	.5128	13.09	.5154	13.16	.5179	13.22	.5205
	-	0.75	13.188	13.378	13.22	.5205	13.27	.5224	13.32	.5243	13.37	.5262	13.42	.5282
M19	-	0.5	13.459	13.599	13.48	.5307	13.51	.5320	13.55	.5333	13.58	.5346	13.61	.5358
	-	2	12.835	13.210	12.92	.5087	13.05	.5138	13.18	.5190	13.31	.5241	13.44	.5292
	-	1.5	13.376	13.676	13.44	.5292	13.54	.5330	13.64	.5369	13.73	.5407	13.83	.5445
M20	-	1.25	13.647	13.912	13.70	.5394	13.78	.5426	13.86	.5458	13.94	.5490	14.03	.5522
	-	1	13.917	14.153	13.96	.5496	14.03	.5522	14.09	.5548	14.16	.5573	14.22	.5599
	-	0.75	14.188	14.378	14.22	.5599	14.27	.5618	14.32	.5637	14.37	.5656	14.42	.5675
M21	-	0.5	14.459	14.599	14.48	.5701	14.51	.5714	14.55	.5727	14.58	.5739	14.61	.5752
	2	-	13.835	14.210	13.92	.5481	14.05	.5532	14.18	.5583	14.31	.5634	14.44	.5685
	-	1.5	14.376	14.676	14.44	.5685	14.54	.5724	14.64	.5762	14.73	.5801	14.83	.5839
M22	-	1	14.917	15.153	14.96	.5890	15.03	.5916	15.09	.5941	15.16	.5967	15.22	.5992
	-	2	14.835	15.210	14.92	.5875	15.05	.5926	15.18	.5977	15.31	.6028	15.44	.6079
	-	1.5	15.376	15.676	15.44	.6079	15.54	.6118	15.64	.6156	15.73	.6194	15.83	.6233
M23	-	1.25	15.647	15.912	15.70	.6181	15.78	.6213	15.86	.6245	15.94	.6277	16.03	.6309
	-	1	15.917	16.153	15.96	.6284	16.03	.6309	16.09	.6335	16.16	.6360	16.22	.6386
	-	0.75	16.188	16.378	16.22	.6386	16.27	.6405	16.32	.6424	16.37	.6444	16.42	.6463
M24	-	0.5	16.459	16.599	16.48	.6488	16.51	.6501	16.55	.6514	16.58	.6527	16.61	.6539
	2.5	-	15.294	15.744	15.40	.6064	15.56	.6128	15.73	.6192	15.89	.6256	16.05	.6319
	-	2	15.835	16.210	15.92	.6268	16.05	.6319	16.18	.6371	16.31	.6422	16.44	.6473
M25	-	1.5	16.376	16.676	16.44	.6473	16.54	.6511	16.64	.6550	16.73	.6588	16.83	.6626
	-	1	16.917	17.153	16.96	.6677	17.03	.6703	17.09	.6729	17.16	.6754	17.22	.6780
	-	2.5	16.294	16.744	16.40	.6457	16.56	.6521	16.73	.6585	16.89	.6649	17.05	.6713
M26	-	2	16.835	17.210	16.92	.6662	17.05	.6713	17.18	.6764	17.31	.6815	17.44	.6867

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M19	-	1.5	17.376	17.676	17.44	.6867	17.54	.6905	17.64	.6943	17.73	.6982	17.83	.7020
	-	1.25	17.647	17.912	17.70	.6969	17.78	.7001	17.86	.7033	17.94	.7065	18.03	.7097
	-	1	17.917	18.153	17.96	.7071	18.03	.7097	18.09	.7122	18.16	.7148	18.22	.7173
M20	-	0.75	18.188	18.378	18.22	.7173	18.27	.7193	18.32	.7212	18.37	.7231	18.42	.7250
	-	0.5	18.459	18.599	18.48	.7276	18.51	.7289	18.55	.7301	18.58	.7314	18.61	.7327
	2.5	-	17.294	17.744	17.40	.6851	17.56	.6915	17.73	.6979	17.89	.7043	18.05	.7107
M21	-	2	17.835	18.210	17.92	.7056	18.05	.7107	18.18	.7158	18.31	.7209	18.44	.7260
	-	1.5	18.376	18.676	18.44	.7260	18.54	.7299	18.64	.7337	18.73	.7375	18.83	.7414
	-	1	18.917	19.153	18.96	.7465	19.03	.7490	19.09	.7516	19.16	.7542	19.22	.7567
M22	-	2.5	18.294	18.744	18.40	.7245	18.56	.7309	18.73	.7373	18.89	.7437	19.05	.7501
	-	1.5	19.376	19.676	19.44	.7654	19.54	.7692	19.64	.7731	19.73	.7769	19.83	.7807
	-	1	19.917	20.153	19.96	.7859	20.03	.7884	20.09	.7910	20.16	.7935	20.22	.7961
M23	2.5	-	19.294	19.744	19.40	.7639	19.56	.7702	19.73	.7766	19.89	.7830	20.05	.7894
	-	2	19.835	20.210	19.92	.7843	20.05	.7894	20.18	.7945	20.31	.7997	20.44	.8048
	-	1.5	20.376	20.676	20.44	.8048	20.54	.8086	20.64	.8124	20.73	.8163	20.83	.8201
M24	-	1	20.917	21.153	20.96	.8252	21.03	.8278	21.09	.8303	21.16	.8329	21.22	.8355
	-	2.5	20.294	20.744	20.40	.8032	20.56	.8096	20.73	.8160	20.89	.8224	21.05	.8288
	-	2	20.835	21.210	20.92	.8237	21.05	.8288	21.18	.8339	21.31	.8390	21.44	.8441
M25	-	1.5	21.376	21.676	21.44	.8441	21.54	.8480	21.64	.8518	21.73	.8556	21.83	.8595
	-	1	21.917	22.153	21.96	.8646	22.03	.8672	22.09	.8697	22.16	.8723	22.22	.8748
	3	-	20.752	21.252	20.88	.8221	21.08	.8298	21.27	.8375	21.47	.8452	21.66	.8528
M26	-	2	21.835	22.210	21.92	.8631	22.05	.8682	22.18	.8733	22.31	.8784	22.44	.8835
	-	1.5	22.376	22.676	22.44	.8835	22.54	.8873	22.64	.8912	22.73	.8950	22.83	.8989
	-	1	22.917	23.153	22.96	.9040	23.03	.9065	23.09	.9091	23.16	.9116	23.22	.9142
M27	-	3	21.752	22.252	21.88	.8615	22.08	.8692	22.27	.8769	22.47	.8845	22.66	.8922
	-	2	22.835	23.210	22.92	.9024	23.05	.9075	23.18	.9127	23.31	.9178	23.44	.9229
	-	1.5	23.376	23.676	23.44	.9229	23.54	.9267	23.64	.9306	23.			

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M34	-	3	30.752	31.252	30.88	1.2158	31.08	1.2235	31.27	1.2312	31.47	1.2389	31.66	1.2465
	-	2	31.835	32.210	31.92	1.2568	32.05	1.2619	32.18	1.2670	32.31	1.2721	32.44	1.2772
	-	1.5	32.376	32.676	32.44	1.2772	32.54	1.2810	32.64	1.2849	32.73	1.2887	32.83	1.2926
M35	-	3	31.752	32.252	31.88	1.2552	32.08	1.2629	32.27	1.2706	32.47	1.2782	32.66	1.2859
	-	1.5	33.376	33.676	33.44	1.3166	33.54	1.3204	33.64	1.3243	33.73	1.3281	33.83	1.3319
	-	1	33.917	34.153	33.96	1.3370	34.03	1.3396	34.09	1.3422	34.16	1.3447	34.22	1.3473
M36	4	-	31.670	32.270	31.84	1.2537	32.10	1.2639	32.36	1.2741	32.62	1.2844	32.88	1.2946
	-	3	32.752	33.252	32.88	1.2946	33.08	1.3023	33.27	1.3099	33.47	1.3176	33.66	1.3253
	-	2	33.835	34.210	33.92	1.3355	34.05	1.3406	34.18	1.3457	34.31	1.3508	34.44	1.3560
	-	1.5	34.376	34.676	34.44	1.3560	34.54	1.3598	34.64	1.3636	34.73	1.3675	34.83	1.3713
M37	-	1	34.917	35.153	34.96	1.3764	35.03	1.3790	35.09	1.3815	35.16	1.3841	35.22	1.3866
	-	1.5	35.376	35.676	35.44	1.3953	35.54	1.3992	35.64	1.4030	35.73	1.4068	35.83	1.4107
	-	1	35.917	36.153	35.96	1.4158	36.03	1.4183	36.09	1.4209	36.16	1.4234	36.22	1.4260
M38	-	4	33.670	34.270	33.84	1.3324	34.10	1.3426	34.36	1.3529	34.62	1.3631	34.88	1.3733
	-	3	34.752	35.252	34.88	1.3733	35.08	1.3810	35.27	1.3887	35.47	1.3963	35.66	1.4040
	-	2	35.835	36.210	35.92	1.4142	36.05	1.4193	36.18	1.4245	36.31	1.4296	36.44	1.4347
	-	1.5	36.376	36.676	36.44	1.4347	36.54	1.4385	36.64	1.4424	36.73	1.4462	36.83	1.4500
M39	4	-	34.670	35.270	34.84	1.3718	35.10	1.3820	35.36	1.3922	35.62	1.4025	35.88	1.4127
	-	3	35.752	36.252	35.88	1.4127	36.08	1.4204	36.27	1.4280	36.47	1.4357	36.66	1.4434
	-	2	36.835	37.210	36.92	1.4536	37.05	1.4587	37.18	1.4638	37.31	1.4689	37.44	1.4741
	-	1.5	37.376	37.676	37.44	1.4741	37.54	1.4779	37.64	1.4817	37.73	1.4856	37.83	1.4894
M40	-	1	37.917	38.153	37.96	1.4945	38.03	1.4971	38.09	1.4996	38.16	1.5022	38.22	1.5047
	-	4	35.670	36.270	35.84	1.4111	36.10	1.4214	36.36	1.4316	36.62	1.4418	36.88	1.4521
	-	3	36.752	37.252	36.88	1.4521	37.08	1.4597	37.27	1.4674	37.47	1.4751	37.66	1.4827
	-	2	37.835	38.210	37.92	1.4930	38.05	1.4981	38.18	1.5032	38.31	1.5083	38.44	1.5134
	-	1.5	38.376	38.676	38.44	1.5134	38.54	1.5173	38.64	1.5211	38.73	1.5249	38.83	1.5288
M42	-	1	38.917	39.153	38.96	1.5339	39.03	1.5364	39.09	1.5390	39.16	1.5416	39.22	1.5441
	4.5	-	37.129	37.799	37.32	1.4694	37.62	1.4809	37.91	1.4924	38.20	1.5039	38.49	1.5155
	-	4	37.670	38.270	37.84	1.4899	38.10	1.5001	38.36	1.5103	38.62	1.5206	38.88	1.5308
	-	3	38.752	39.252	38.88	1.5308	39.08	1.5385	39.27	1.5461	39.47	1.5538	39.66	1.5615
	-	2	39.835	40.210	39.92	1.5717	40.05	1.5768	40.18	1.5819	40.31	1.5871	40.44	1.5922
M45	-	1.5	40.376	40.676	40.44	1.5922	40.54	1.5960	40.64	1.5998	40.73	1.6037	40.83	1.6075
	4.5	-	40.129	40.799	40.32	1.5875	40.62	1.5990	40.91	1.6106	41.20	1.6221	45.00	1.7717
	-	4	40.670	41.270	40.84	1.6080	41.10	1.6182	41.36	1.6285	41.62	1.6387	41.88	1.6489
	-	3	41.752	42.252	41.88	1.6489	42.08	1.6566	42.27	1.6643	42.47	1.6719	42.66	1.6796
	-	2	42.835	43.210	42.92	1.6898	43.05	1.6949	43.18	1.7001	43.31	1.7052	43.44	1.7103
	-	1.5	43.376	43.676	43.44	1.7103	43.54	1.7141	43.64	1.7180	43.73	1.7218	43.83	1.7256
M48	-	1	43.917	44.153	43.96	1.7307	44.03	1.7333	44.09	1.7359	44.16	1.7384	44.22	1.7410
	-	1.5	44.376	44.676	44.44	1.7497	44.54	1.7535	44.64	1.7573	44.73	1.7612	44.83	1.7650
	5	-	42.587	43.297	42.80	1.6852	43.13	1.6980	43.45	1.7108	43.78	1.7235	44.10	1.7363
	-	4	43.670	44.270	43.84	1.7261	44.10	1.7363	44.36	1.7466	44.62	1.7568	44.88	1.7670
	-	3	44.752	45.252	44.88	1.7670	45.08	1.7747	45.27	1.7824	45.47	1.7900	45.66	1.7977
	-	2	45.835	46.210	45.92	1.8079	46.05	1.8130	46.18	1.8182	46.31	1.8233	46.44	1.8284
M50	-	1.5	46.376	46.676	46.44	1.8284	46.54	1.8322	46.64	1.8361	46.73	1.8399	46.83	1.8437
	-	1	46.917	47.153	46.96	1.8488	47.03	1.8514	47.09	1.8540	47.16	1.8565	47.22	1.8591
	-	5	44.587	45.297	44.80	1.7639	45.13	1.7767	45.45	1.7895	45.78	1.8023	46.10	1.8151
	-	3	46.752	47.252	46.88	1.8458	47.08	1.8534	47.27	1.8611	47.47	1.8688	47.66	1.8764
	-	2	47.835	48.210	47.92	1.8867	48.05	1.8918	48.18	1.8969	48.31	1.9020	48.44	1.9071
M50	-	1.5	48.376	48.676	48.44	1.9071	48.54	1.9110	48.64	1.9148	48.73	1.9186	48.83	1.9225
	-	1	48.917	49.153	48.96	1.9276	49.03	1.9301	49.09	1.9327	49.16	1.9353	49.22	1.9378

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M52	5	-	46.587	47.297	46.80	1.8427	47.13	1.8555	47.45	1.8682	47.78	1.8810	48.10	1.8938
	-	4	47.670	48.270	47.84	1.8836	48.10	1.8938	48.36	1.9040	48.62	1.9143	48.88	1.9245
	-	3	48.752	49.252	48.88	1.9245	49.08	1.9322	49.27	1.9398	49.47	1.9475	49.66	1.9552
	-	2	49.835	50.210	49.92	1.9654	50.05	1.9705	50.18	1.9756	50.31	1.9808	50.44	1.9859
M55	-	1.5	50.376	50.676	50.44	1.9859	50.54	1.9897	50.64	1.9935	50.73	1.9974	50.83	2.0012
	-	4	50.670	51.270	50.84	2.0017	51.10	2.0119	51.36	2.0222	51.62	2.0324	51.88	2.0426
	-	3	51.752	52.252	51.88	2.0426	52.08	2.0503	52.27	2.0580	52.47	2.0656	52.66	2.0733
	-	2	52.835	53.210	52.92	2.0835	53.05	2.0886	53.18	2.0938	53.31	2.0989	53.44	2.1040
M56	-	1.5	53.376	53.676	53.44	2.1040	53.54	2.1078	53.64	2.1117	53.73	2.1155	53.83	2.1193
	5.5	-	50.046	50.796	50.28	1.9797	50.64	1.9938	51.00	2.0078	51.36	2.0219	51.71	2.0360
	-	4	51.670	52.270	51.84	2.0411	52.10	2.0513	52.36	2.0615	52.62	2.0718	52.88	2.0820
	-	3	52.752	53.252	52.88	2.0820	53.08	2.0897	53.27	2.0973	53.47	2.1050	53.66	2.1127
M58	-	2	53.835	54.210	53.92	2.1229	54.05	2.1280	54.18	2.1331	54.31	2.1382	54.44	2.1434
	-	1.5	54.376	54.676	54.44	2.1434	54.54	2.1472	54.64	2.1510	54.73	2.1549	54.83	2.1587
	-	4	53.670	54.270	53.84	2.1198	54.10	2.1300	54.36	2.1403	54.62	2.1505	54.88	2.1607
	-	3	54.752	55.252	54.88	2.1607	55.08	2.1684	55.27	2.1761	55.47	2.1837	55.66	2.1914
M60	-	2	55.835	56.210	55.92	2.2016	56.05	2.2067	56.18	2.2119	56.31	2.2170	56.44	2.2221
	-	1.5	56.376	56.676	56.44	2.2221	56.54	2.2259	56.64	2.2298	56.73	2.2336	56.83	2.2374
	5.5	-	54.046	54.796	54.28	2.1372	54.64	2.1512	55.00	2.1653	55.36	2.1794	55.71	2.1934
	-	4	55.670	56.270	55.84	2.1985	56.10	2.2088	56.36	2.2190	56.62	2.2292	56.88	2.2395
	-	3	56.752	57.252	56.88	2.2395	57.08	2.2471	57.27	2.2548	57.47	2.2625	57.66	2.2701
M62	-	2	57.835	58.210	57.92	2.2804	58.05	2.2855	58.18	2.2906	58.31	2.2957	58.44	2.3008
	-	1.5	58.376	58.676	58.44	2.3008	58.54	2.3047	58.64	2.3085	58.73	2.3123	58.83	2.3162
	-	4	57.670	58.270	57.84	2.2773	58.10	2.2875	58.36	2.2977	58.62	2.3080	58.88	



TAP DRILL SIZES - UNIFIED THREAD / FORMING TAPS

Size	Threads Per Inch			Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	Min. 2B&3B	Max. 2B	Max. 3B	75% Thread	70% Thread	65% Thread	60% Thread	55% Thread
#0	-	80	-	.0465	.0514	.0514	.0536	.0541	.0545	.0549	.0553
	64	-	-	.0561	.0623	.0623	.0650	.0656	.0661	.0666	.0672
#1	-	72	-	.0580	.0635	.0635	.0659	.0664	.0669	.0673	.0678
	56	-	-	.0667	.0737	.0737	.0769	.0775	.0781	.0787	.0793
#2	-	64	-	.0691	.0753	.0753	.0780	.0786	.0791	.0796	.0802
	48	-	-	.0764	.0845	.0845	.0884	.0891	.0898	.0905	.0912
#3	-	56	-	.0797	.0865	.0865	.0899	.0905	.0911	.0917	.0923
	40	-	-	.0849	.0939	.0939	.0993	.1001	.1010	.1018	.1027
#4	-	48	-	.0894	.0968	.0968	.1014	.1021	.1028	.1035	.1042
	40	-	-	.0979	.1062	.1062	.1123	.1131	.1140	.1148	.1157
#5	-	44	-	.1004	.1079	.1079	.1134	.1142	.1150	.1157	.1165
	32	-	-	.1040	.1140	.1140	.1221	.1231	.1242	.1253	.1263
#6	-	40	-	.1110	.1190	.1186	.1253	.1261	.1270	.1278	.1287
	32	-	-	.1300	.1390	.1389	.1481	.1491	.1502	.1513	.1523
#8	-	36	-	.1340	.1420	.1416	.1498	.1508	.1517	.1527	.1536
	24	-	-	.1450	.1560	.1555	.1688	.1702	.1716	.1730	.1744
#10	-	32	-	.1560	.1640	.1641	.1741	.1751	.1762	.1773	.1783
	24	-	-	.1710	.1810	.1807	.1948	.1962	.1976	.1990	.2004
#12	-	28	-	.1770	.1860	.1857	.1978	.1990	.2002	.2014	.2026
	-	-	32	.1820	.1900	.1895	.2001	.2011	.2022	.2033	.2043
1/4	20	-	-	.1960	.2070	.2067	.2245	.2262	.2279	.2296	.2313
	-	28	-	.2110	.2200	.2190	.2318	.2330	.2342	.2354	.2366
5/16	-	-	32	.2160	.2240	.2229	.2341	.2351	.2362	.2373	.2383
	18	-	-	.2520	.2650	.2630	.2842	.2861	.2879	.2898	.2917
3/8	-	24	-	.2670	.2770	.2754	.2913	.2927	.2941	.2955	.2969
	-	-	-	.2740	.2820	.2807	.2943	.2955	.2967	.2979	.2991
7/16	-	-	32	.2790	.2860	.2847	.2966	.2976	.2987	.2998	.3008
	16	-	-	.3070	.3210	.3182	.3431	.3453	.3474	.3495	.3516
1/2	-	24	-	.3300	.3400	.3372	.3538	.3552	.3566	.3580	.3594
	-	-	-	.3360	.3450	.3426	.3568	.3580	.3592	.3604	.3616
9/16	-	-	32	.3410	.3490	.3469	.3591	.3601	.3612	.3623	.3633
	14	-	-	.3600	.3760	.3717	.4011	.4035	.4059	.4084	.4108
5/8	-	20	-	.3830	.3950	.3916	.4120	.4137	.4154	.4171	.4188
	-	-	28	.3990	.4070	.4051	.4193	.4205	.4217	.4229	.4241
3/4	13	-	-	.4170	.4340	.4284	.4608	.4634	.4660	.4686	.4712
	-	20	-	.4460	.4570	.4537	.4745	.4762	.4779	.4796	.4813
7/8	-	-	28	.4610	.4700	.4676	.4818	.4830	.4842	.4854	.4866
	12	-	-	.4720	.4900	.4843	.5200	.5228	.5257	.5285	.5313
1"	-	18	-	.5020	.5150	.5106	.5342	.5361	.5379	.5398	.5417
	-	-	24	.5170	.5270	.5244	.5413	.5427	.5441	.5455	.5469
1 1/8	11	-	-	.5270	.5460	.5391	.5786	.5817	.5848	.5879	.5910
	-	-	-	.5570	.5710	.5662	.5931	.5953	.5974	.5995	.6016
1 1/4	-	18	-	.5650	.5780	.5730	.5967	.5986	.6004	.6023	.6042
	-	-	24	.5800	.5900	.5869	.6038	.6052	.6066	.6080	.6094
1 3/4	10	-	-	.6420	.6630	.6545	.6990	.7024	.7058	.7092	.7126
	-	16	-	.6820	.6960	.6908	.7181	.7203	.7224	.7245	.7266
2"	-	-	20	.6960	.7070	.7037	.7245	.7262	.7279	.7296	.7313



Size	Threads Per Inch			Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	Min. 2B&3B	Max. 2B	Max. 3B	75% Thread	70% Thread	65% Thread	60% Thread	55% Thread
7/8	9	-	-	.7550	.7780	.7681	.8183	.8221	.8259	.8297	.8334
	-	14	-	.7980	.8140	.8068	.8386	.8410	.8434	.8459	.8483
1"	-	-	20	.8210	.8320	.8287	.8495	.8512	.8529	.8546	.8563
	8	-	-	.8650	.8900	.8797	.9363	.9405	.9448	.9490	.9533
1 1/8	-	12	-	.9100	.9280	.9198	.9575	.9603	.9632	.9660	.9688
	-	-	20	.9460	.9570	.9537	.9745	.9762	.9779	.9796	.9813
1 1/4	7	-	-	.9700	.9980	.9875	1.0521	1.0570	1.0619	1.0667	1.0716
	-	12	-	1.0350	1.0530	1.0448	1.0825	1.0853	1.0882	1.0910	1.0938
1 3/4	-	-	18	1.0650	1.0780	1.0730	1.0967	1.0986	1.1004	1.1023	1.1042
	7	-	-	1.0950	1.1230	1.1125	1.1771	1.1820	1.1869	1.1917	1.1966
2"	-	12	-	1.1600	1.1780	1.1698	1.2075	1.2103	1.2132	1.2160	1.2188
	-	-	18	1.1900	1.2030	1.1980	1.2217	1.2236	1.2254	1.2273	1.2292



18 TAP DRILL SIZES - METRIC THREAD / FORMING TAPS

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	75% Thread		70% Thread		65% Thread		60% Thread		55% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M1	0.25	-	0.729	0.798	0.87	.0344	0.88	.0347	0.89	.0350	0.90	.0354	0.91	.03569
	-	0.2	0.783	0.841	0.90	.0354	0.90	.0356	0.91	.0359	0.92	.0362	0.93	.03643
M1.1	0.25	-	0.829	0.898	0.97	.0383	0.98	.0386	0.99	.0390	1.00	.0393	1.01	.03963
	-	0.2	0.883	0.941	1.00	.0393	1.00	.0396	1.01	.0398	1.02	.0401	1.03	.04036
M1.2	0.25	-	0.929	0.998	1.07	.0422	1.08	.0426	1.09	.0429	1.10	.0432	1.11	.04356
	-	0.2	0.983	1.041	1.10	.0432	1.10	.0435	1.11	.0438	1.12	.0440	1.13	.04430
M1.4	0.3	-	1.075	1.159	1.25	.0491	1.26	.0495	1.27	.0499	1.28	.0503	1.29	.05070
	-	0.2	1.183	1.241	1.30	.0511	1.30	.0514	1.31	.0516	1.32	.0519	1.33	.05217
M1.6	0.35	-	1.221	1.321	1.42	.0560	1.43	.0564	1.45	.0569	1.46	.0574	1.47	.05784
	-	0.2	1.383	1.441	1.50	.0590	1.50	.0592	1.51	.0595	1.52	.0598	1.53	.06005
M1.7	0.35	-	1.321	1.421	1.52	.0599	1.53	.0604	1.55	.0608	1.56	.0613	1.57	.06178
	-	0.3	1.375	1.459	1.55	.0609	1.56	.0613	1.57	.0617	1.58	.0621	1.59	.06251
M1.8	-	0.25	1.429	1.498	1.57	.0619	1.58	.0622	1.59	.0626	1.60	.0629	1.61	.06325
	-	0.2	1.483	1.541	1.60	.0629	1.60	.0632	1.61	.0634	1.62	.0637	1.63	.06398
M2	0.35	-	1.421	1.521	1.62	.0638	1.63	.0643	1.65	.0648	1.66	.0652	1.67	.06571
	-	0.2	1.583	1.641	1.70	.0669	1.70	.0671	1.71	.0674	1.72	.0677	1.73	.06792
M2.2	0.4	-	1.567	1.679	1.80	.0707	1.81	.0712	1.82	.0718	1.84	.0723	1.85	.07285
	-	0.25	1.729	1.798	1.87	.0737	1.88	.0741	1.89	.0744	1.90	.0747	1.91	.07506
M2.3	0.45	-	1.713	1.838	1.97	.0776	1.99	.0782	2.00	.0788	2.02	.0794	2.03	.07999
	-	0.25	1.929	1.998	2.07	.0816	2.08	.0819	2.09	.0823	2.10	.0826	2.11	.08293
M2.5	0.4	-	1.867	1.979	2.10	.0825	2.11	.0831	2.12	.0836	2.14	.0841	2.15	.08466
	-	0.35	1.921	2.021	2.12	.0835	2.13	.0840	2.15	.0845	2.16	.0849	2.17	.08540
M2.6	-	0.25	2.029	2.098	2.17	.0855	2.18	.0859	2.19	.0862	2.20	.0865	2.21	.08687
	0.45	-	2.013	2.138	2.27	.0894	2.29	.0900	2.30	.0906	2.32	.0912	2.33	.09180
M3	-	0.35	2.121	2.221	2.32	.0914	2.33	.0919	2.35	.0923	2.36	.0928	2.37	.09327
	0.45	-	2.113	2.238	2.37	.0933	2.39	.0939	2.40	.0945	2.42	.0951	2.43	.09574
M3.5	-	0.35	2.221	2.321	2.42	.0953	2.43	.0958	2.45	.0963	2.46	.0967	2.47	.09721
	0.5	-	2.459	2.599	2.75	.1081	2.76	.1087	2.78	.1094	2.80	.1101	2.81	.11075
M4	-	0.35	2.621	2.721	2.82	.1111	2.83	.1116	2.85	.1120	2.86	.1125	2.87	.11296
	0.6	-	2.850	3.010	3.19	.1257	3.21	.1266	3.23	.1274	3.26	.1282	3.28	.12896
M4.5	-	0.35	3.121	3.221	3.32	.1308	3.33	.1312	3.35	.1317	3.36	.1322	3.37	.13264
	0.7	-	3.242	3.422	3.64	.1434	3.67	.1444	3.69	.1453	3.71	.1462	3.74	.14717
M5	-	0.5	3.459	3.599	3.75	.1474	3.76	.1481	3.78	.1488	3.80	.1494	3.81	.15012
	0.75	-	3.688	3.878	4.12	.1621	4.14	.1631	4.17	.1641	4.19	.1651	4.22	.16612
M6	-	0.5	3.959	4.099	4.25	.1671	4.26	.1678	4.28	.1685	4.30	.1691	4.31	.16980
	0.9	-	4.026	4.226	4.54	.1788	4.57	.1800	4.60	.1812	4.63	.1824	4.66	.18360
M7	-	0.5	4.134	4.334	4.59	.1808	4.62	.1819	4.65	.1829	4.67	.1840	4.70	.18507
	1	-	4.459	4.599	4.75	.1868	4.76	.1875	4.78	.1881	4.80	.1888	4.81	.18949
M8	-	0.75	4.917	5.153	5.49	.2161	5.52	.2175	5.56	.2188	5.59	.2202	5.63	.22150
	1.25	-	5.188	5.378	5.62	.2212	5.64	.2222	5.67	.2232	5.69	.2242	5.72	.22518
M9	-	0.5	5.459	5.599	5.75	.2262	5.76	.2269	5.78	.2275	5.80	.2282	5.81	.22886
	1	-	5.917	6.153	6.49	.2555	6.52	.2569	6.56	.2582	6.59	.2595	6.63	.26087
M10	-	0.75	6.188	6.378	6.62	.2605	6.64	.2615	6.67	.2625	6.69	.2635	6.72	.26455
	1.25	-	6.459	6.599	6.75	.2656	6.76	.2662	6.78	.2669	6.80	.2676	6.81	.26823
M12	-	1	6.647	6.912	7.36	.2899	7.41	.2915	7.45	.2932	7.49	.2949	7.53	.29656
	1.75	-	6.917	7.153	7.49	.2949	7.52	.2962	7.56	.2976	7.59	.2989	7.63	.30024
M14	-	0.75	7.188	7.378	7.62	.2999	7.64	.3009	7.67	.3019	7.69	.3029	7.72	.30392
	-	0.5	7.459	7.599	7.75	.3049	7.76	.3056	7.78	.3063	7.80	.3069	7.81	.30760
M16	1.25	-	7.647	7.912	8.36	.3292	8.41	.3309	8.45	.3326	8.49	.3343	8.53	.33593
	-	1	7.917	8.153	8.49	.3343	8.52	.3356	8.56	.3369	8.59	.3383	8.63	.33961
M18	-	0.75	8.188	8.378	8.62	.3393	8.64	.3403	8.67	.3413	8.69	.3423	8.72	.34329
	-	0.5	8.459	8.599	8.75	.3443	8.76	.3450	8.78	.3456	8.80	.3463	8.81	.34697

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	75% Thread		70% Thread		65% Thread		60% Thread		55% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M10	1.5	-	8.376	8.676	9.24	.3636	9.29	.3656	9.34	.3676	9.39	.3696	9.44	.37161
	-	1.25	8.647	8.912	9.36	.3686	9.41	.3703	9.45	.3719	9.49	.3736	9.53	.37530
M12	-	1	8.917	9.153	9.49	.3736	9.52	.3750	9.56	.3763	9.59	.3776	9.63	.37898
	-	0.75	9.188	9.378	9.62	.3786	9.64	.3796	9.67	.3806	9.69	.3817	9.72	.38266
M14	-	0.5	9.459	9.599	9.75	.3837	9.76	.3843	9.78	.3850	9.80	.3857	9.81	.38634
	1.75	-	10.106	10.441	11.11	.4373	11.17	.4396	11.23	.4420	11.29	.4443	11.35	.44667
M16	-	1.5	10.376	10.676	11.24	.4423	11.29	.4443	11.34	.4463	11.39	.4483	11.44	.45035
	-	1.25	10.647	10.912	11.36	.4473	11.41	.4490	11.45	.4507	11.49	.4524	11.53	.45404
M18	-	1	10.917	11.153	11.49	.4524	11.52	.4537	11.56	.4550	11.59	.4564	11.63	.45772
	-	0.75	11.188	11.378	11.62	.4574	11.64	.4584	11.67	.4594	11.69	.4604	11.72	.46140
M20	-	0.5	11.459	11.599	11.75	.4624	11.76	.4631	11.78	.4637	11.80	.4644	11.81	.46508
	2	-	11.835	12.210	12.98	.5110	13.05	.5137	13.12	.5164	13.18	.5191	13.25	.52173
M22	-	1.5	12.376	12.676	13.24	.5211	13.29	.5231	13.34	.5251	13.39	.5271	13.44	.52909
	-	1.25	12.647	12.912	13.36	.5261	13.41	.5278	13.45	.5294	13.49	.5311	13.53	.53278
M24	-	1	12.917	13.153	13.49	.5311	13.52	.5324	13.56	.5338	13.59	.5351	13.63	.53646
	-	0.75	13.188	13.378	13.62	.5361	13.64	.5371	13.67	.5381	13.69	.5391	13.72	.54014
M26	-	0.5	13.459	13.599	13.75	.5411	13.76	.5418	13.78	.5425	13.80	.5431	13.81	.54382
	2	-	13.835	14.210	14.98	.5898	15.05	.5924	15.12	.5951	15.18	.5978	15.25	.60047
M28	-	1.5	14.376	14.676	15.24	.5998	15.29	.6018	15.34	.6038	15.39	.6058	15.44	.60783
	-	1	14.917	15.153	15.49	.6098	15.52	.6112	15.56	.6125	15.59	.6139	15.63	.61520
M30	2.5	-	15.294	15.744	16.73	.6585	16.81	.6618	16.90	.6652	16.98	.6685	17.07	.67185
	-	2	15.835	16.210	16.98	.6685	17.05	.6712	17.12	.6739	17.18	.6765	17.25	.67921
M32	-	1.5	16.376	16.676	17.24	.6785	17.29	.6806	17.34	.6826	17.39	.6846	17.44	.68657
	-	1	16.917	17.153	17.49	.6886	17.52	.6899	17.56	.6913	17.59	.6926	17.63	.69394
M34	2.5	-	17.294	17.744	18.73	.7372	18.81	.7406	18.90	.7439	18.98	.7472	19.07	.75059
	-	2	17.835	18.210	18.98	.7472	19.05	.7499	19.12	.7526	19.18	.7553	19.25	.75795
M36	-	1.5	18.376	18.676	19.24	.7573	19.29	.7593	19.34	.7613	19.39	.7633	19.44	.76531
	-	1	18.917	19.153	19.49	.7673	19.52	.7687	19.56	.7700	19.59	.7713	19.63	.77268
M38	2.5	-	19.294	19.744	20.73	.8159	20.81	.8193	20.90	.8226	20.98	.8260	21.07	.82933
	-	2	19.835	20.210	20.98	.8260	21.05	.8287	21.12	.8313	21.18	.8340	21.25	.83669
M40	-	1.5	20.376	20.676	21.24	.8360	21.29	.8380	21.34	.8400	21.39	.8420	21.44	.84406
	-	1	20.917	21.153	21.49									



19 TAP DRILL SIZES - METRIC THREAD / FORMING TAPS

Metric	Size	RECOMMENDATION		Unified	Size	RECOMMENDATION	
		Drill Size				Drill Size	
		Inch	metric (mm)			Inch	metric (mm)
M2 x 0.4		.0827	2.10	#2 - 56 UNC		.0906	2.30
M2.2 x 0.45		.0906	2.30	#3 - 48 UNC		.1063	2.70
M2.5 x 0.45		.1024	2.60	#3 - 56 UNF		.1043	2.65
M3 x 0.5		.1240	3.15	#4 - 40 UNC		.1181	3.00
M3.5 x 0.6		.1457	3.70	#4 - 48 UNF		.1181	3.00
M4 x 0.7		.1654	4.20	#5 - 40 UNC		.1339	3.40
M5 x 0.8		.2047	5.20	#5 - 44 UNF		.1299	3.30
M6 x 1.0		.2480	6.30	#6 - 32 UNC		.1457	3.70
M7 x 1.0		.2874	7.30	#6 - 40 UNF		.1457	3.70
M8 x 1.0		.3268	8.30	#8 - 32 UNC		.1732	4.40
M8 x 1.25		.3307	8.40	#8 - 36 UNF		.1732	4.40
M9 x 1.25		.3701	9.40	#10 - 24 UNC		.2008	5.10
M10 x 1.25		.4094	10.40	#10 - 32 UNF		.2008	5.10
M10 x 1.5		.4134	10.50	#12 - 24 UNC		.2283	5.80
M11 x 1.5		.4528	11.50	1/4 - 20 UNC		.2638	6.70
M12 x 1.25		.4882	12.40	1/4 - 28 UNF		.2598	6.60
M12 x 1.5		.4921	12.50	5/16 - 18 UNC		.3307	8.40
M12 x 1.75		.4921	12.50	5/16 - 24 UNF		.3228	8.20
M14 x 1.5		.5709	14.50	3/8 - 16 UNC		.3937	10.00
M14 x 2.0		.5709	14.50	3/8 - 24 UNF		.3858	9.80
M16 x 1.5		.6496	16.50	7/16 - 14 UNC		.4528	11.50
M16 x 2.0		.6496	16.50	7/16 - 20 UNF		.4528	11.50
M18 x .5		.7283	18.50	1/2 - 13 UNC		.5236	13.30
M18 x 2.0		.7283	18.50	1/2 - 20 UNF		.5157	13.10
M18 x 2.5		.7382	18.75	9/16 - 12 UNC		.5866	14.90
M20 x 1.5		.8071	20.50	9/16 - 18 UNF		.5787	14.70
M20 x 2.0		.8071	20.50	5/8 - 11 UNC		.6496	16.50
M20 x 2.5		.8169	20.75	5/8 - 18 UNF		.6417	16.30
M22 x 1.5		.8858	22.50	3/4 - 10 UNC		.7795	19.80
M22 x 2.0		.8858	22.50	3/4 - 16 UNF		.7677	19.50
M22 x 2.5		.8957	22.75	7/8 - 9 UNC		.9055	23.00
M24 x 2.0		.9646	24.50	7/8 - 14 UNF		.8858	22.50
M24 x 3.0		.9843	25.00	1 - 8 UNC		1.0433	26.50
M27 x 3.0		1.1024	28.00	1 - 12 UNF		1.0236	26.00
M30 x 3.5		1.2205	31.00	1-1/8 - 7 UNC		1.1713	29.75
				1-1/8 - 8 UN		1.1417	29.00
				1-1/8 - 12 UNF		1.1516	29.25
				1-1/4 - 7 UNC		1.2992	33.00
				1-1/4 - 8 UN		1.2795	32.50
				1-1/4 - 12 UNF		1.2795	32.50
				1-3/8 - 6 UNC		1.4173	36.00
				1-3/8 - 8 UN		1.3976	35.50
				1-3/8 - 12 UNF		1.4173	36.00
				1-1/2 - 6 UNC		1.5354	39.00
				1-1/2 - 8 UN		1.5354	39.00
				1-1/2 - 12 UNF		1.5354	39.00

20 CONVERSION TABLE

SURFACE FEET PER MINUTE TO REVOLUTIONS PER MINUTE

Surface Feet Per Minute	20	25	30	40	50	60	70	80	90	100	110	120	130	140	150
Tap Size	Revolutions Per Minute														
0	1273	1592	1910	2546	3183	3820	4456	5093	5730	6366	7003	7639	8276	8913	9549
1	1047	1308	1570	2093	2617	3140	3663	4186	4710	5233	5756	6279	6808	7326	7849
2	888	1110	1333	1777	2221	2665	3109	3554	3999	4422	4886	5330	5774	6218	6662
3	772	964	1157	1543	1929	2315	2701	3086	3472	3858	4244	4629	5015	5401	5787
4	682	853	1023	1364	1705	2046	2387	2728	3069	3411	3751	4092	4434	4775	5116
5	611	764	917	1222	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	4584
6	553	691	829	1106	1382	1658	1934	2211	2487	2764	3040	3316	3592	3869	4145
8	466	583	699	932	1165	1398	1631	1864	2097	2330	2563	2796	3029	3262	3495
10	402	502	603	804	1005	1205	1406	1607	1808	2009	2210	2411	2612	2813	3014
12	354	442	531	707	884	1061	1238	1415	1592	1769	1945	2122	2300	2476	2653
1/4	306	382	458	611	764	917	1070	1222	1375	1528	1681	1833	1986	2139	2292
5/16	245	306	367	486	611	733	856	978	1100	1222	1345	1467	1589	1711	1833
3/8	204	255	306	407	509	611	713	815	917	1019	1120	1222	1324	1426	1528
7/16	175	219	262	349	437	524	611	698	786	873	960	1048	1135	1222	1310
1/2	153	191	229	306	382	458	535	611	688	764	840	917	993	1070	1146
9/16	137	172	206	275	344	412	481	550	619	687	756	825	893	963	1031
5/8	122	153	183	244	306	367	428	489	550	611	672	733	794	856	917
3/4	102	128	153	203	255	306	357	407	458	509	560	611	662	713	764
7/8	87	109	131	175	218	252	306	350	392	437	480	524	568	611	655
1	76	96	115	153	191	230	268	306	344	382	420	458	497	535	573