

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 1½ 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	7.20mm
		1.95mm			11/64			7.25mm
		5/64			17			7.30mm
		47			4.40mm			L
	3-48	2.00mm		12-24	16			7.40mm
	M2.5x.45	2.05mm			4.50mm			M
		46			15			7.50mm
3-48	3-56	45		M5.5x.9	4.60mm			19/64
		2.10mm		12-28	14			7.60mm
M2.5x.45	M2.6x.45	2.15mm			13			N
3-56	4-36	44		M5.5x.9	4.70mm		M9x1.25	7.70mm
		2.20mm		12-28	4.75mm			7.75mm
M2.6x.45		2.25mm			3/16			7.80mm
4-36		43			12			7.90mm
	4-40	2.30mm			4.80mm		M9x1.25	5/16
		2.35mm			11			8.00mm
4-40		42			4.90mm		M9x1	O
	4-48	3/32			10			8.10mm
		2.40mm			9			8.20mm
4-48		41		M6x1	5.00mm			P
	M3x.6	2.45mm			8			8.25mm
		40			5.10mm			8.30mm
	M3x.5	2.50mm		1/4-20	7		3/8-16	21/64
M3x.5		39			13/64			8.40mm
5-40	5-40	38		M6x1	6		1/8-27NPT	Q
5-40		2.60mm			5.20mm			8.50mm
	5-44	37			5		3/8-24	8.60mm
5-44		2.70mm		M6x.75	5.25mm		M10x1.5	R
	6-32	36			5.30mm			8.70mm
		2.75mm		1/4-20	4		M10x1.25	11/32
		7/64		M6x.75	5.40mm			8.75mm
		35			3		M10x1.5	8.80mm
		2.80mm			5.50mm			S
		34			7/32		M10x1.25	8.90mm
6-32	6-40	33		1/4-28	5.60mm			9.00mm
	M3.5x.6	2.90mm			2		M10x1	T
		32			5.70mm			9.10mm
M3.5x.6		3.00mm			5.75mm			23/64
6-40		31			1			9.20mm
		3.10mm			5.80mm			9.30mm
		1/8			5.90mm			U
		3.20mm			A		7/16-14	9.40mm
		3.25mm			15/64			9.50mm
	M4x.75	30			6.00mm		M11x1.5	3/8
		3.30mm		M7x1	B			V
	M4x.7	3.40mm			6.10mm			9.60mm
M4x.75		29			C			9.70mm
M4x.7	8-32	3.50mm		M7x1	6.20mm			9.75mm
		28			D		M11x1.5	9.80mm
8-32		9/64			6.25mm			W
		3.60mm			6.30mm			9.90mm
8-36		27			E		7/16-20	25/64
		3.70mm			1/4			10.00mm
		26		M7x.75	6.40mm		7/16-20	X
		3.75mm			6.50mm			10.20mm
	M4.5x.75	25			F		M12x1.75	Y
	10-24	3.80mm			6.60mm			13/32
		24			G		M12x1.75	Z
M4.5x.75		3.90mm			6.70mm			10.50mm
		23			17/64		M12x1.5	27/64
		5/32			6.75mm		1/2-13	10.75mm
10-24		22		5/16-18	H		M12x1.25	11.00mm
		4.00mm			6.80mm			7/16
	M5x1	21			6.90mm			11.50mm
	10-32	20			I		1/2-20	29/64
		4.10mm		M8x1.25	7.00mm			15/32
	M5x.9	4.20mm			J			12.00mm
M5x.9	M5x.8	19			7.10mm			31/64
M5x.8		4.25mm		5/16-24	K			12.50mm
		4.30mm			9/32			1/2

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