

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