



CHALLENGE THE MACHINE.

TAP-DRILL CHART

RECOMMEND TAP DRILL TO USE FOR 75% DEPTH OF THREAD

To Tap This Size Screw Or Bolt:	Use This Drill Bit:	(Closest Fractional:)	Decimal Inches	To Tap This Size Screw Or Bolt:	Use This Drill Bit:	(Closest Fractional:)	Decimal Inches
0-80 NF	3/64"	3/64"	.0469	9mm-1.00mm	8.1mm	-	.3189
1-64 NC	#53	-	.0595	9mm-0.75mm	8.3mm	-	.3268
1-72 NF	#53	1/16"	.0595	3/8-24 NF	Ltr.Q	21/64"	.3320
2-56 NC	#50	-	.0700	10mm-1.50mm	8.7mm	-	.3425
2-64 NF	#50	-	.0700	10mm-1.25mm	8.9mm	11/32"	.3503
3-48 NC	#47	5/64"	.0785	10mm-1.00mm*	9.1mm	-	.3583
3-56 NF	#45	-	.0820	7/16-14 NC	Ltr.U	23/64"	.3680
4-36 NS	#44	-	.0860	11mm-1.50mm	9.7mm	-	.3818
4-40 NC	#43	3/32"	.0890	7/16-20 NF	25/64"	25/64"	.3906
4-48 NF	#42	3/32"	.0935	12mm-1.75mm	10.5mm	-	.4133
3mm-0.60mm	2.5mm	-	.0984	12mm-1.50mm	10.7mm	27/64"	.4212
1/8-40 NS	#38	-	.1015	1/2-13 NC	27/64"	27/64"	.4219
5-40 NC	#38	-	.1015	12mm-1.25mm*	10.9mm	27/64"	.4291
5-44 NF	#37	-	.1040	1/2-20 NF	29/64"	29/64"	.4531
6-32 NC	#35	7/64"	.1100	1/2-24 NS	29/64"	29/64"	.4531
6-36 NS	#34	-	.1110	14mm-2.00mm	12.2mm	-	.4803
6-40 NF	#33	-	.1130	9/16-12 NC	31/64"	31/64"	.4844
6-48 NS	#31	-	.1200	14mm-1.50mm	12.7mm	-	.4999
4mm-0.70mm	3.4mm	-	.1338	14mm-1.25mm*	12.8mm	-	.5039
4mm-0.75mm	3.4mm	-	.1338	9/16-18 NF	33/64"	33/64"	.5156
8-32 NC	#29	-	.1360	5/8-11 NC	17/32"	17/32"	.5312
8-36 NF	#29	9/64"	.1360	16mm-2.00mm	14.2mm	35/64"	.5590
8-40 NS	#28	-	.1405	5/8-18 NF	37/64"	37/64"	.5781
3/16-24 NS	#26	-	.1470	16mm-1.50mm	14.7mm	-	.5787
10-24 NC	#25	5/32"	.1495	11/16-11 NS	19/32"	19/32"	.5938
3/16-32 NS	#22	-	.1570	18mm-2.50mm	15.8mm	39/64"	.6220
10-32 NF	#21	5/32"	.1590	11/16-16 NS	5/8"	5/8"	.6250
5mm-0.90mm	4.2mm	-	.1653	3/4-10 NC	21/32"	21/32"	.6562
5mm-0.80mm	4.3mm	-	.1693	18mm-1.50mm*	16.8mm	-	.6614
12-24 NC	#16	11/64"	.1770	3/4-16 NF	11/16"	11/16"	.6875
12-28 NF	#14	3/16"	.1820	20mm-2.50mm	17.8mm	11/16"	.7008
12-32 NEF	#13	-	.1850	7/8-9 NC	49/64"	49/64"	.7656
14-20 NS	#10	-	.1935	7/8-14 NF	13/16"	13/16"	.8125
1/4-20 NC	#7	13/64"	.2010	22mm-1.50mm	20.9mm	-	.8228
14-24 NS	#7	-	.2010	7/8-18 NS*	53/64"	53/64"	.8281
6mm-1.00mm	5.2mm	-	.2047	24mm-3.00mm	21.4mm	53/64"	.8425
1/4-24 NS	#4	-	.2090	1.8 NC	7/8"	7/8"	.8750
1/4-28 NF	#3	7/32"	.2130	24mm-2.00mm	22.3mm	-	.8779
1/4-32 NEF	7/32"	7/32"	.2188	1.12 NF	59/64"	59/64"	.9219
1/4-40 NS	#1	-	.2280	1-14 NS	15/16"	15/16"	.9375
7mm-1.00mm	6.1mm	15/64"	.2401	1 1/8-7 NC	63/64"	63/64"	.9844
5/16-18 NC	Ltr.F	17/64"	.2570	1 1/8-12 NF	1 3/64"	1 3/64"	1.0469
8mm-1.25mm	6.9mm	17/64"	.2716	1 1/4-7 NC	1 7/64"	1 7/64"	1.1094
5/16-24 NF	Ltr.I	-	.2720	1 1/4-12 NF	1 11/64"	1 11/64"	1.1719
8mm-1.00mm	7.1mm	-	.2795	1 3/8-6 NC	1 7/32"	1 7/32"	1.2188
5/16-32 NEF	9/32"	9/32"	.2812	1 3/8-12 NF	1 19/64"	1 19/64"	1.2969
9mm-1.25mm	7.9mm	-	.3110	1 1/2-6 NC	1 11/32"	1 11/32"	1.3438
3/8-16 NC	5/16"	5/16"	.3125	1 1/2-12 NF	1 27/64"	1 27/64"	1.4219

* These Sizes Are Spark Plug Taps