

Tap Drill Sizes

(Drill sizes based on approximate 72-77% full thread)

Tap Size	Pitch Form	Tap Drill Size	Alt. Tap Drill	Tap Size	Pitch Form	Tap Drill Size	Alt. Tap Drill	Tap Size	Pitch Form	Tap Drill Size	Alt. Tap Drill
Unified Taps				Taper Pipe Taps - NPT				27	3.00	24.00	61/64
0	80 UNF	3/64	1.25	1/16	27	D	6.30	30	3.50	26.50	1-3/64
1	64 UNC	53	1.55	1/8	27	R	8.70	33	3.50	29.50	1-5/32
	72 UNF	53	1.55	1/4	18	7/16	11.10	36	4.00	32.00	1-1/4
2	56 UNC	50	1.85	3/8	18	37/64	14.50	39	4.00	35.00	1-3/8
	64 UNF	50	1.90	1/2	14	23/32	18.00	I.S.O. Metric Fine			
3	48 UNC	47	2.10	3/4	14	59/64	23.25	3	0.35	2.65	37
	56 UNF	45	2.15	1	11-1/2	1-5/32	29.00	4	0.35	3.65	27
4	40 UNC	43	2.35	1-1/4	11-1/2	1-1/2	38.00	4	0.50	3.50	29
	48 UNF	42	2.40	1-1/2	11-1/2	1-47/64	44.00	4.5	0.45	4.05	21
5	40 UNC	38	2.65	2	11-1/2	2-7/32	57.00	5	0.50	4.50	16
	44 UNF	37	2.70	2-1/2	8	2-5/8	67.00	5	0.70	4.30	18
6	32 UNC	36	2.85	3	8	3-1/4	82.50	5	0.75	4.25	18
	40 UNF	33	2.95	Straight Pipe Taps - NPS				5.5	0.50	5.00	9
8	32 UNC	29	3.50	1/8	27	S	8.80	6	0.50	5.50	7/32
	36 UNF	29	3.50	1/4	18	29/64	11.50	6	0.75	5.25	5
10	24 UNC	25	3.90	3/8	18	19/32	15.00	7	0.75	6.25	D
	32 UNF	21	4.10	1/2	14	47/64	18.50	8	0.50	7.50	M
12	24 UNC	16	4.50	3/4	14	15/16	23.75	8	1.00	7.00	J
	28 UNF	14	4.70	1	11-1/2	1-3/16	30.25	9	0.50	8.50	Q
1/4	20 UNC	7	5.10	1-1/4	11-1/2	1-33/64	38.50	9	1.00	8.00	O
	28 UNF	3	5.50	1-1/2	11-1/2	1-3/4	44.50	10	0.50	9.50	3/8
5/16	18 UNC	F	6.60	2	11-1/2	2-7/32	57.00	10	0.75	9.25	U
	24 UNF	I	6.90	I.S.O. Metric Coarse				10	1.00	9.00	T
3/8	16 UNC	5/16	8.00	1.6	0.35	1.25	3/64	10	1.25	8.75	11/32
	24 UNF	Q	8.50	1.7	0.35	1.35	55	11	1.00	10.00	X
7/16	14 UNC	U	9.40	1.8	0.35	1.45	54	12	1.00	11.00	7/16
	20 UNF	25/64	9.90	2	0.40	1.60	1/16	12	1.25	10.75	27/64
1/2	13 UNC	27/64	10.80	2.2	0.45	1.75	50	12	1.50	10.50	Z
	20 UNF	29/64	11.50	2.3	0.40	1.90	49	13	1.50	11.50	29/64
9/16	12 UNC	31/64	12.20	2.5	0.45	2.05	46	13	1.75	11.25	7/16
	18 UNF	33/64	12.90	2.6	0.45	2.15	44	14	1.25	12.75	1/2
5/8	11 UNC	17/32	13.50	3	0.50	2.50	40	14	1.50	12.50	31/64
	18 UNF	37/64	14.50	3.5	0.60	2.90	33	15	1.50	13.50	17/32
3/4	10 UNC	21/32	16.50	4	0.70	3.30	30	16	1.00	15.00	19/32
	16 UNF	11/16	17.50	4.5	0.75	3.70	27	16	1.25	14.75	37/64
7/8	9 UNC	49/64	19.50	5	0.80	4.20	19	16	1.50	14.50	9/16
	14 UNF	13/16	20.40	5.5	0.90	4.60	15	18	1.00	17.00	43/64
1	8 UNC	7/8	22.25	6	1.00	5.00	9	18	1.25	16.75	21/32
	12 UNF	59/64	23.25	7	1.00	6.00	15/64	18	1.50	16.50	41/64
1	14 UNS	15/16	23.50	8	1.25	6.80	H	18	2.00	16.00	5/8
1-1/8	7 UNC	63/64	25.00	9	1.25	7.80	5/16	20	1.00	19.00	3/4
	12 UNF	1-3/64	26.50	10	1.50	8.50	Q	20	1.50	18.50	47/64
1-1/4	7 UNC	1-7/64	28.00	11	1.50	9.50	3/8	20	2.00	18.00	45/64
	12 UNF	1-11/64	29.50	12	1.75	10.20	Y	22	1.00	21.00	53/64
1-3/8	6 UNC	1-7/32	30.75	14	2.00	12.00	15/32	22	1.50	20.50	13/16
	12 UNF	1-19/64	32.75	16	2.00	14.00	35/64	22	2.00	20.00	25/32
1-1/2	6 UNC	1-11/32	34.00	18	2.50	15.50	39/64	24	1.00	23.00	29/32
	12 UNF	1-27/64	36.00	20	2.50	17.50	11/16	24	1.50	22.50	7/8
1-3/4	5 UNC	1-9/16	39.50	22	2.50	19.50	49/64	24	2.00	22.00	55/64
2	4-1/2 UNC	1-25/32	45.00	24	3.00	21.00	53/64	24	2.50	21.50	27/32



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