



FOR CUTTING & FORMING TAPS

TAP DRILL RECOMMENDATIONS



Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
0-80		3/64	.0469	54	.0050
	M1.6 x 0.35	1.25	.0490	1.45	.0571
	M1.6 x 0.35	1.45	.0571	1.65	.0650
1-64		53	.0095	51	.0070
1-72		53	.0095	51	.0070
	M2 x 0.40	1.80	.0630	1.80	.0709
2-56		50	.0090	5/64	.0781
2-64		50	.0090	47	.0785
	M2.2 x 0.45	1.75	.0649	2.00	.0787
	M2.5 x 0.45	2.05	.0807	2.30	.0908
3-48		47	.0785	43	.0890
3-56		46	.0810	3.50	.0900
4-40		43	.0890	38	.1015
4-48		42	.0905	2.80	.1024
	M3 x 0.50	2.50	.0984	3/16	.1094
5-40		38	.1015	33	.1130
5-44		37	.1040	2.90	.1142
	M3.5 x 0.60	2.80	.1142	3.20	.1280
6-32		36	.1065	5/8	.1250
6-40		33	.1130	3.25	.1280
	M4 x 0.70	3.30	.1299	3.75	.1478
8-32		29	.1360	25	.1495
8-36		29	.1360	24	.1520
	M4.5 x 0.75	3.75	.1478	4.10	.1614
10-24		26	.1470	11/64	.1719
10-32		21	.1580	16	.1770
	M5 x 0.80	4.20	.1654	14	.1820
12-24		18	.1770	8	.1990
12-28		15	.1800	7	.2010
	M6 x 1.00	5.00	.1969	7/32	.2188
1/4-20		7	.2010	1	.2280
1/4-28		3	.2130	15/64	.2340
	M7 x 1.00	6.00	.2362	F	.2570
5/16-18		F	.2570	L	.2900
5/16-24		I	.2730	M	.2990
	M8 x 1.25	8.75	.2638	7/40	.2913
	M8 x 1.00	7.00	.2756	19/64	.2968
3/8-16		O	.3125	5	.3480
3/8-24		Q	.3320	T	.3680
	M10 x 1.50	8.50	.3348	12	.3680
	M10 x 1.25	8.75	.3425	9/40	.3701
7/16-14		U	.3690	V	.4040
7/16-20			.3606	2	.4130
	M12 x 1.75	10.20	.4018	11/20	.4428
	M12 x 1.25	10.80	.4252	11/40	.4528
1/2-13			.4219	15/32	.4620
1/2-20			.4531	12/25	.4620
	M14 x 2.00	12.00	.4724	33/64	.5158
9/16-12			.5158	13/32	.5312
9/16-18			.5158	13/50	.5315

Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
5/8-11		17/32	.5312	14/16	.5600
5/8-18		37/64	.5781	15/16	.6004
	M16 x 2.00	14.00	.5512	19/32	.5938
	M16 x 1.50	14.50	.5709	15/16	.6004
	M16 x 2.50	15.50	.6102	39/64	.6094
	M16 x 1.50	16.50	.6496	17/16	.6791
3/4-10		21/32	.6562	45/64	.7031
3/4-16		11/16	.6875	23/32	.7188
	M20 x 2.50	17.50	.6890	"	"
	M20 x 1.50	18.50	.7280	"	"
	M22 x 2.50	19.50	.7671	"	"
	M22 x 1.50	20.50	.8071	"	"
7/8-9		49/64	.7656	"	"
7/8-14		13/16	.8125	"	"
	M24 x 3.00	21.00	.8268	"	"
	M24 x 2.00	22.00	.8661	"	"
1-8		7/8	.8750	"	"
1-12		39/64	.9019	"	"
	M27 x 3.00	24.00	.9449	"	"
	M27 x 2.00	25.00	.9843	"	"
1 1/8-7		53/64	.9844	"	"
1 1/8-12		1 3/64	1.0469	"	"
	M30 x 3.50	26.50	1.0430	"	"
	M30 x 2.00	28.00	1.1024	"	"
1 1/4-7		1 7/64	1.1094	"	"
1 1/4-12		1 15/64	1.1719	"	"
	M33 x 3.50	29.50	1.1614	"	"
	M33 x 2.00	31.00	1.2206	"	"
1 3/8-6		1 7/32	1.2188	"	"
1 3/8-12		1 19/64	1.2569	"	"
	M36 x 4.00	32.00	1.2590	"	"
	M36 x 3.00	33.00	1.2992	"	"
1 1/2-6		1 11/32	1.3438	"	"
1 1/2-12		1 27/64	1.4219	"	"
	M39 x 4.00	35.00	1.3780	"	"
	M39 x 3.00	36.00	1.4173	"	"

PIPE TAPS: NPT, NPTF, NPSM, NPSC, NPSF

NPT & NPTF					
Nominal Pipe Tap Size	Minimum Flute Length	NPSM Flute Length	NPSC	NPSF	NPSF
1/16-27	C (.242)	A (.234)	—	.250	D (.248)
1/8-27	O (.302)	21/64	T (.368)	O (.302)	R (.358)
1/4-18	7/16	27/64	15/32	7/16	27/64
3/8-18	9/16	9/16	.625**	37/64	37/64
1/2-14	45/64	15/16	15.0 mm	15.0 mm	15.0 mm
3/4-14	29/32	27/64	61/64	59/64	59/64
1-11 1/2	1 5/8	1 1/8	1 13/64	1 5/32	1 5/32
1 1/4-11 1/2	1 31/64	1 19/32	1 25/64	1 47/64	—
1 1/2-11 1/2	1 23/32	1 45/64	1 25/32	1 47/64	—
2-11 1/2	2 3/16	2 11/64	2 5/4	2 13/64	—

METRIC

FRACTIONAL

WIRE GAGE

LETTER SIZE

Machine Tapping Guide

BM King



Machine Tapping Guide:

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Table of Contents Machine Tapping Guide

1. Understanding the eBook Machine Tapping Guide
 - The Rise of Digital Reading Machine Tapping Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Machine Tapping Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Machine Tapping Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Machine Tapping Guide
 - Personalized Recommendations
 - Machine Tapping Guide User Reviews and Ratings
 - Machine Tapping Guide and Bestseller Lists
5. Accessing Machine Tapping Guide Free and Paid eBooks
 - Machine Tapping Guide Public Domain eBooks
 - Machine Tapping Guide eBook Subscription Services
 - Machine Tapping Guide Budget-Friendly Options
6. Navigating Machine Tapping Guide eBook Formats

- ePub, PDF, MOBI, and More
- Machine Tapping Guide Compatibility with Devices
- Machine Tapping Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Machine Tapping Guide
 - Highlighting and Note-Taking Machine Tapping Guide
 - Interactive Elements Machine Tapping Guide
- 8. Staying Engaged with Machine Tapping Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Machine Tapping Guide
- 9. Balancing eBooks and Physical Books Machine Tapping Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Machine Tapping Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Machine Tapping Guide
 - Setting Reading Goals Machine Tapping Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Machine Tapping Guide
 - Fact-Checking eBook Content of Machine Tapping Guide
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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