

Drill Selection for forming taps and Decimal Equivalents

Tap Size		75% Thread			70% Thread			65% Thread			60% Thread			55% Thread			50% Thread		
		Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent	Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent	Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent	Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent	Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent	Theoretical Hole Core Size	Nearest Drill Size	Decimal Equivalent
0	80	.0536	1.35mm	.0531	.0540	1.35mm	.0531	.0545			.0549	54	.0550	.0554	54	.0550	.0558	1.4mm	.0551
1	64	.0650	1.65mm	.0650	.0655	1.65mm	.0650	.0661			.0666			.0672	51	.0670	.0677	51	.0670
	72	.0659	1.65mm	.0650	.0663			.0669	1.7mm	.0669	.0673	51	.0670	.0679	51	.0670	.0683		
2	56	.0769	1.95mm	.0768	.0774	1.95mm	.0768	.0781	5/64	.0781	.0787	47	.0785	.0794	2.0mm	.0787	.0799	2.05mm	.0808
	64	.0780	5/64	.0781	.0785	47	.0785	.0791	2.0mm	.0787	.0796	2.0mm	.0787	.0802		.0807			
3	48	.0884	2.25mm	.0886	.0890	43	.0890	.0898	43	.0890	.0905	2.3mm	.0906	.0913	2.3mm	.0906	.0919	2.35mm	.0925
	56	.0899	43	.0890	.0904			.0911	2.3mm	.0906	.0917	2.3mm	.0906	.0924	2.35mm	.0925	.0929		
4	40	.0993	2.5mm	.0984	.1000	39	.0995	.1010	39	.0995	.1018	38	.1015	.1028	2.6mm	.1024	.1035	2.6mm	.1024
	48	.1014	38	.1015	.1020	38	.1015	.1028	2.6mm	.1024	.1035	2.6mm	.1024	.1043	37	.1040	.1049	37	.1040
5	40	.1123	34	.1110	.1130	33	.1130	.1140	33	.1130	.1148	2.9mm	.1142	.1158	32	.1160	.1165	32	.1160
	44	.1134	33	.1130	.1141	2.9mm	.1142	.1150	2.9mm	.1142	.1157	2.9mm	.1142	.1166	32	.1160	.1173	32	.1160
6	32	.1221	3.1mm	.1220	.1230	3.1mm	.1220	.1243			.1252	1/8	.1250	.1264	3.2mm	.1260	.1274	30	.1285
	40	.1253	1/8	.1250	.1260	3.2mm	.1260	.1270	3.2mm	.1260	.1278	3.25mm	.1280	.1288	30	.1285	.1295		
8	32	.1481	3.75mm	.1476	.1490			.1503	25	.1495	.1512	3.8mm	.1496	.1524	24	.1520	.1534	3.9mm	.1535
	36	.1498	25	.1495	.1507	3.8mm	.1496	.1518	24	.1520	.1526	24	.1520	.1537	3.9mm	.1535	.1546	23	.1540
10	24	.1688			.1700	18	.1695	.1717	11/64	.1719	.1729	11/64	.1719	.1746	17	.1730	.1758		
	32	.1741	17	.1730	.1750			.1763			.1772	16	.1770	.1784	4.5mm	.1772	.1794		
12	24	.1948	10	.1935	.1960	9	.1960	.1977	5.0mm	.1968	.1989	8	.1990	.2006	5.1mm	.2008	.2018	7	.2010
	28	.1978	5.0mm	.1968	.1990	8	.1990	.2006	8	.1990	.2014	7	.2010	.2028		.2039	.2039	13/64	.2031
1/4	20	.2245	5.7mm	.2244	.2260			.2280	1	.2280	.2295	1	.2280	.2315		.2330	5.9mm	.2323	
	28	.2318			.2329	5.9mm	.2323	.2343	A	.2340	.2354	15/64	.2344	.2389	6.0mm	.2362	.2379	B	.2380
5/16	18	.2842	7.2mm	.2835	.2861	7.25mm	.2854	.2879	7.3mm	.2874	.2898	L	.2900	.2917	7.4mm	.2913	.2936		
	24	.2912	7.4mm	.2913	.2927			.2941	M	.2950	.2955	7.5mm	.2953	.2969	19/64	.2969	.2983	7.6mm	.2992
3/8	16	.3431	11/32	.3437	.3452	8.75mm	.3445	.3474	S	.3480	.3495	8.9mm	.3480	.3516		.3537	9.0mm	.3543	
	24	.3537	9.0mm	.3543	.3552	9.0mm	.3543	.3566			.3580	T	.3504	.3594	23/64	.3594	.3608		
7/16	14	.4011			.4035	Y		.4059	13/32		.4084			.4108			.4132	Z	
	20	.4120	Z		.4137	10.5mm		.4154			.4171			.4188			.4205		
1/2	13	.4608			.4634			.4660			.4686			.4712	12mm		.4738	12mm	
	20	.4745			.4762			.4779			.4796	15/32		.4813			.4830	31/64	
9/16	12	.5200			.5229			.5257			.5285			.5313	17/32	.5312	.5342	17/32	.5312
	18	.5342	13.5mm	.5315	.5361			.5380			.5398			.5417			.5436	35/64	.5469
5/8	11	.5787	37/64	.5781	.5817	37/64		.5848			.5879			.5910	15mm	.5906	.5941	19/32	.5937
	18	.5967	19/32	.5937	.5986		.5781	.6004			.6023			.6042			.6061		
3/4	10	.6990			.7024			.7058	45/64	.7031	.7092	18mm	.7031	.7126			.7160		
	16	.7181	23/32	.7181	.7202	23/32	.7187	.7224			.7245			.7266			.7287	18.5mm	.7283