

## INCH/METRIC TAP DRILL SIZES & DECIMAL EQUIVALENTS

DRILL SIZE	DECIMAL EQUIVALENT	TAP SIZE	DRILL SIZE	DECIMAL EQUIVALENT	TAP SIZE	DRILL SIZE	DECIMAL EQUIVALENT	TAP SIZE
1/64	.0156		10	.1935		59	.9219	1 - 12
	.0145		9	.1960		64	.9375	1 - 14
	.0135		8	.1985		61	.9531	
	.0160		7	.2010	1/4 - 20	64	.9688	
	.0180		6	.2031		63	.9844	1 1/8 - 7
	.0200		5	.2040		64	1.0000	
	.0210		4	.2055		1 3/64	1.0469	1 1/8 - 12
	.0225		3	.2090	1/4 - 28	1 7/64	1.1094	1 1/4 - 7
	.0240		2	.2130		1 11/64	1.1250	
	.0250		1	.2188		1 1/32	1.1719	1 1/4 - 12
	.0260		A	.2210		1 1/32	1.2188	1 3/8 - 6
	.0280		B	.2280		1 19/64	1.2500	
	.0292		C	.2340		1 11/32	1.2969	1 3/8 - 12
	.0310		D	.2344		1 11/32	1.3438	1 1/2 - 6
	.0312		E	.2380		1 27/64	1.3750	
	.0320		F	.2420	5/16 - 18		1.4219	1 1/2 - 12
	.0330		G	.2460			1.5000	
	.0350		H	.2500				
	.0360		I	.2570				
	.0370		J	.2610				
	.0380		K	.2656				
	.0390		L	.2660				
	.0400		M	.2720	5/16 - 24			
	.0410		N	.2770				
	.0420		O	.2810				
	.0430		P	.2812				
	.0465		Q	.2900				
	.0469	0 - 80	R	.2950				
	.0520		S	.2969				
	.0550		T	.3020				
	.0595	1 - 64, 72	U	.3125	3/8 - 16			
	.0625		V	.3160				
	.0635		W	.3230				
	.0670		X	.3281	3/8 - 24			
	.0700	2 - 56, 64	Y	.3320				
	.0730		Z	.3390				
	.0760			.3438				
	.0781			.3480				
	.0785	3 - 48		.3580				
	.0810			.3594				
	.0820	3 - 56		.3680	7/16 - 14			
	.0860			.3750				
	.0890	4 - 40		.3770				
	.0935	4 - 48		.3860				
	.0938			.3906	7/16 - 20			
	.0960			.3970				
	.0985			.4040				
	.1015	5 - 40		.4062				
	.1040	5 - 44		.4130				
	.1065	6 - 32		.4219	1/2 - 13			
	.1094			.4375				
	.1100			.4531	1/2 - 20			
	.1110			.4688				
	.1130	6 - 40		.4844	9/16 - 12			
	.1160			.5000				
	.1200			.5156	9/16 - 18			
	.1250			.5312	5/8 - 11			
	.1285			.5469				
	.1360	8 - 32, 36		.5625				
	.1405			.5781	5/8 - 18			
	.1406			.5938				
	.1440			.6094				
	.1470			.6250				
	.1495	10 - 24		.6406				
	.1520			.6562	3/4 - 10			
	.1540			.6719	3/4 - 16			
	.1562			.6875				
	.1570	10 - 32		.7031				
	.1590			.7188				
	.1610			.7344				
	.1650			.7500				
	.1695			.7656	7/8 - 9			
	.1719			.7812				
	.1730			.7969				
	.1770	12 - 24		.8125	7/8 - 14			
	.1800			.8281				
	.1820	12 - 28		.8438				
	.1850			.8594				
	.1875			.8750	1 - 8			
	.1890			.8906				
	.1910			.9062				

METRIC TAP DRILL SIZES		
METRIC TAP	TAP DRILL (mm)	DECIMAL (Inch)
M1.6 x 0.35	1.25	.0492
M1.8 x 0.35	1.45	.0571
M2 x 0.4	1.60	.0630
M2.2 x 0.45	1.75	.0689
M2.5 x 0.45	2.05	.0807
M3 x 0.5	2.50	.0984
M3.5 x 0.6	2.90	.1142
M4 x 0.7	3.30	.1299
M4.5 x 0.75	3.70	.1457
M5 x 0.8	4.20	.1654
M6 x 1	5.00	.1968
M7 x 1	6.00	.2362
M8 x 1.25	6.70	.2638
M8 x 1	7.00	.2756
M10 x 1.5	8.50	.3346
M10 x 1.25	8.70	.3425
M12 x 1.75	10.20	.4016
M12 x 1.25	10.80	.4252
M14 x 2	12.00	.4724
M14 x 1.5	12.50	.4921
M16 x 2	14.00	.5512
M16 x 1.5	14.50	.5709
M18 x 2.5	15.50	.6102
M18 x 1.5	16.50	.6496
M20 x 2.5	17.50	.6890
M20 x 1.5	18.50	.7283
M22 x 2.5	19.50	.7677
M22 x 1.5	20.50	.8071
M24 x 3	21.00	.8268
M24 x 2	22.00	.8661
M27 x 3	24.00	.9449
M27 x 2	25.00	.9843
M30 x 3.5	26.50	1.0433
M30 x 2	28.00	1.1024
M33 x 3.5	29.50	1.1614
M33 x 2	31.00	1.2205
M36 x 4	32.00	1.2598
M36 x 3	33.00	1.2992
M39 x 4	35.00	1.3780
M39 x 3	36.00	1.4173

PIPE THREAD SIZES (NPS)			
THREAD	DRILL	THREAD	DRILL
1/8 - 27	11/32	1 1/2 - 11 1/2	1 3/4
1/4 - 18	7/16	2 - 11 1/2	2 7/32
3/8 - 18	27/64	2 1/2 - 8	2 11/32
1/2 - 14	23/32	3 - 8	3 1/4
3/4 - 14	59/64	3 1/2 - 8	3 3/4
1 - 11 1/2	1 5/32	4 - 8	4 1/4
1 1/4 - 11 1/2	1 1/2		

# Starrett Tap Drill Guide

**LL Leslie**

A red circular graphic with a gradient, appearing as a stylized arrow or a light effect, positioned to the right of the author's name.

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web jun 7 2022 what are r controlled vowels when a vowel is followed by the letter r the r takes control of the vowel the vowel will no longer say its long or short sound but it joins together with the r and a new sound is created this is why it is sometimes called the bossy r the vowel r will come together to make one new sound

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