

## TAP DRILL SIZES

Cutting Taps based  
on approx.  
75% thread

Forming Taps  
based on approx.  
65% thread

TAP SIZE	CUTTING TAP DRILL SIZE	FORMING TAP DRILL SIZE
0-80	3/64	No. 54
1-64	No. 53	1.65mm
1-72	No. 53	1.7mm
2-56	No. 50	5/64
2-64	No. 50	2.0mm
3-48	No. 47	No. 43
3-56	No. 46	2.3mm
4-40	No. 43	No. 39
4-48	No. 42	2.6mm
5-40	No. 39	No. 33
5-44	No. 38	2.9mm
6-32	No. 36	1/8
6-40	No. 33	3.2mm
8-32	No. 29	No. 25
8-36	No. 29	No. 24
10-24	No. 25	11/64
10-32	No. 21	No. 16
12-24	No. 17	5mm
12-28	No. 15	No. 8
1/4-20	No. 7	No. 1
1/4-28	No. 3	A
5/16-18	F	7.3mm
5/16-24	I	M
3/8-16	5/16	S
3/8-24	Q	T
7/16-14	U	13/32
7/16-20	W	10.5mm
1/2-13	27/64	11.8mm
1/2-20	29/64	12mm
9/16-12	31/64	17/32
9/16-18	33/64	13.5mm
5/8-11	17/32	14.75mm
5/8-18	37/64	16.25mm
3/4-10	21/32	45/64
3/4-16	11/16	23/32
7/8-9	49/64	
7/8-14	13/16	
1-8	7/8	
1-12	59/64	
1-14	15/16	

## METRIC TAP DRILL SIZES

Cutting Taps based  
on approx.  
75% thread

Forming Taps  
based on approx.  
65% thread

TAP SIZE	CUTTING TAP DRILL SIZE	FORMING TAP DRILL SIZE
M1.6 x 0.35	1.25mm	1.45mm
M1.8 x 0.35	1.45mm	1.716
M2 x 0.4	1.60mm	No. 49
M2.2 x 0.45	1.75mm	No. 42
M2.5 x 0.45	2.05mm	No. 41
M3 x 0.5	2.5mm	No. 34
M3.5 x 0.5	2.9mm	3.3mm
M4 x 0.7	3.3mm	3.7mm
M4.5 x 0.75	3.75mm	4.2mm
M5 x 0.8	No. 19	No. 13
M6 x 1	5mm	No. 2
M7 x 1	6mm	6.5mm
M8 x 1.25	H	M
M9 x 1	J	19/64
M10 x 1.5	6.5mm	U
M10 x 1.25	8.75mm	9.5mm
M12 x 1.75	13/32	7/16
M12 x 1.25	10.75mm	11.5mm
M14 x 2	12mm	33/64
M14 x 1.5	12.5mm	17/32
M16 x 2	14mm	19/32
M16 x 1.5	14.5mm	39/64
M18 x 2.5	16.5mm	17mm
M18 x 1.5	16.5mm	11/16
M20 x 2.5	17.5mm	18.75mm
M20 x 1.5	18.5mm	49/64
M22 x 2.5	19.5mm	21mm
M22 x 1.5	20.5mm	27/32
M24 x 3	53/64	57/64
M24 x 2	22mm	* Reaming Recommended
M27 x 3	24mm	
M27 x 2	63/64	
M30 x 3.5	1-3/64"	
M30 x 2	1-7/64"	
M33 x 3.5	1-11/64"	
M33 x 2	31mm*	
M36 x 4	32mm*	
M36 x 3	33mm*	
M39 x 4	35mm*	
M39 x 3	36mm*	



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**Morgan Lakeland**



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