

TAP DRILL SIZES

Machine Screws		
Screw Size	Recommended Tap Drill Size	
	Drill	Decimal
	2-56	50
3-48	47	0.0785
3-56	46	0.0810
4-40	43	0.0890
4-48	42	0.0935
5-40	38	0.1015
5-44	37	0.1040
6-32	36	0.1065
6-40	33	0.1130
8-32	29	0.1360
8-36	29	0.1360
10-24	26	0.1470
10-32	21	0.1590
12-24	16	0.1770
12-28	15	0.1800
1/4-20	7	0.2010
1/4-28	3	0.2130
5/16-18	F	0.2570
5/16-24	I	0.2720
3/8-16	5/16	0.3125
3/8-24	Q	0.3320
7/16-14	U	0.3680
7/16-20	25/64	0.3906
1/2-13	27/64	0.4219
1/2-20	29/64	0.4531
9/16-12	31/64	0.4844
9/16-18	33/64	0.5156
5/8-11	17/32	0.5312
5/8-18	37/64	0.5781
3/4-10	21/32	0.6562
3/4-16	11/16	0.6875
7/8-9	49/64	0.7656
7/8-14	13/16	0.8125
1-8	7/8	0.8750
1-12	59/64	0.9219

IPS Pipe		
Nominal Size	NPT, NPTF w/o Reamer	
	Drill	Decimal
	1/16-27	C
1/8-27	Q	0.3320
1/4-18	7/16	0.4375
3/8-18	9/16	0.5625
1/2-14	45/64	0.7031
3/4-14	29/32	0.9063
1-11.5	1-9/64	1.1406
1-1/4-11.5	1-31/64	1.4844
1-1/2-11.5	1-23/32	1.7188

Nominal Size	NPT, NPTF w/ Reamer	
	Drill	Decimal
	1/16-27	A
1/8-27	21/64	0.3281
1/4-18	27/64	0.4219
3/8-18	9/16	0.5625
1/2-14	11/16	0.6875
3/4-14	57/64	0.8906
1-11.5	1-1/8	1.1250
1-1/4-11.5	1-15/32	1.4688
1-1/2-11.5	1-45/64	1.7031

Nominal Size	NPSM	
	Drill	Decimal
1/16-27	---	---
1/8-27	T	0.3580
1/4-18	15/32	0.4688
3/8-18	0.603	0.6030
1/2-14	19MM	0.7480
3/4-14	61/64	0.9531
1-11.5	1-13/64	1.2031
1-1/4-11.5	1-35/64	1.5469
1-1/2-11.5	1-25/32	1.7813

Size of Pipe (inches)	Size of Pipe (inches)
1/8	21/64
1/4	7/16
3/8	9/16
1/2	45/64
3/4	29/32
1	1 9/64
1 1/4	1 31/64
1 1/2	1 47/64
2	2 13/64
2 1/2	2 5/8
3	3 1/4
3 1/2	3 47/64
4	4 15/64