



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	.0499	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	.0090	51	.0070
1-72		53	.0090	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	2.60	.1024
	M3 x 0.50	2.50	.0964	3/64	.1094
5-40		38	.1015	33	.1130
5-44		37	.1040	2.90	.1142
	M3.5 x 0.60	2.90	.1142	3.20	.1260
6-32		36	.1065	5/8	.1250
6-40		33	.1130	3.25	.1260
	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	.2900
	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	10.25	.4018	11/20	.4828
	M12 x 1.25	10.80	.4252	11.50	.4828
1/2-13			.4219	13/32	.4820
1/2-20			.4531	12.25	.4820
	M14 x 2.00	12.00	.4724	33/64	.5158
9/16-12			.5158	13.50	.5315
9/16-18			.5158		

METRIC

FRACTIONAL

WIRE GAGE

LETTER SIZE

Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
5/8-11		17/32	.5312	14.75	.5600
5/8-18		3/8	.3750	15.25	.6004
	M16 x 2.50	14.00	.5512	19/32	.5938
	M16 x 1.50	14.50	.5709	15.25	.6004
	M16 x 2.50	15.50	.6102	39/64	.6094
	M16 x 1.50	16.50	.6496	17.25	.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	1.2969	"	"
	M36 x 4.00	32.00	1.2990	"	"
	M36 x 3.00	33.00	1.2990	"	"
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, NPSP

NPT & NPTF					
Nominal Pipe Tap Size	Minimum Flute Depth	NPSM Flute Depth	NPSC	NPSC	NPTF
1/16-27	C (.242)	A (.234)	—	.250	D (.248)
1/8-27	O (.302)	21/64	T (.368)	G (.302)	H (.308)
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	59/64	59/64
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 5/8	1 5/8
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	—

Machinists Guide For Taps

Joshua Rose



Machinists Guide For Taps:

Rogers Machinists Guide William Rogers,1913 **Machinist Guide** David B Smith,2015-04-15 This is a Machinist Notebook Reference guide Revised Apr 11 2015 Written for machinist s by a journeymen machinist in a real shop environment With tables charts illustration drawing and Sketch s for machinist gunsmith auto industries With work sheets for none standard threading and gear cutting It also has simple illustration on how to make a few simple tooling and aids in the shop information for machinist As listed Three wire Major Diameter worm DP and MOD Using a Dividing Head How use a Compound Indexing How to make the Smith Compound indexer Rebound Ball Hardness Tester Grinding Lathe Tools bits Speeds and lubrication Rebound Ball Hardness Tester Hardness Chart Roughness Finish Compactor Scale Over the wire dimensions inch bolts in mm Index Table for 40 tooth worm 2 to 540 Compound Indexing on 40 tooth worm 51 250 teeth Index Table for 72 tooth worm Index Table for 90 tooth worm 2 230 Gear cutting and blanks This is book with written for fast reading NOT NOVEL for reading for slow reading **Tool and Manufacturing Engineers Handbook: Machining** Thomas J. Drozda,1983-05-02 Part of the renowned Tool and Manufacturing Engineers Handbook Series the Machining Vol 1 helps you apply cost effective techniques to achieve the best results for over 100 traditional and nontraditional machining processes Chapters include Principles of Metalcutting and Machinability Tolerance Control Cutting Tool Materials Sawing Broaching Planing Shaping and Slotting Turning and Boring Milling Grinding Threading Gear and Spline Production Nontraditional Machining Machine Loading and Unloading Machine Rebuilding and much more **Practical Machinist** Harry H. Kelley,1914 American Machinist & Automated Manufacturing ,1923 Greenfield's Pocket Guide for Machinists Greenfield Tap and Die Corporation,1930 The Complete Practical Machinist Joshua Rose,1895 American Machinist ,1891 **Complete Practical Machinist** Joshua Rose,1920 The New American Machinist's Handbook Rupert Le Grand,1955 **The Complete Practical Machinist: Embracing Lathe Work, Vise Work, Etc** Joshua Rose,1876

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Shipyard Outside Machinist, Instructor's Guide ... Pennsylvania. Department of Public Instruction,1943

Handbook of Small Tools ,1908 **Machinery's Handbook for Machine Shop and Drafting-room** ,1915

Modern Machine-shop Practice Joshua Rose,1887 American Machinist, Metalworking Manufacturing ,1967-07

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