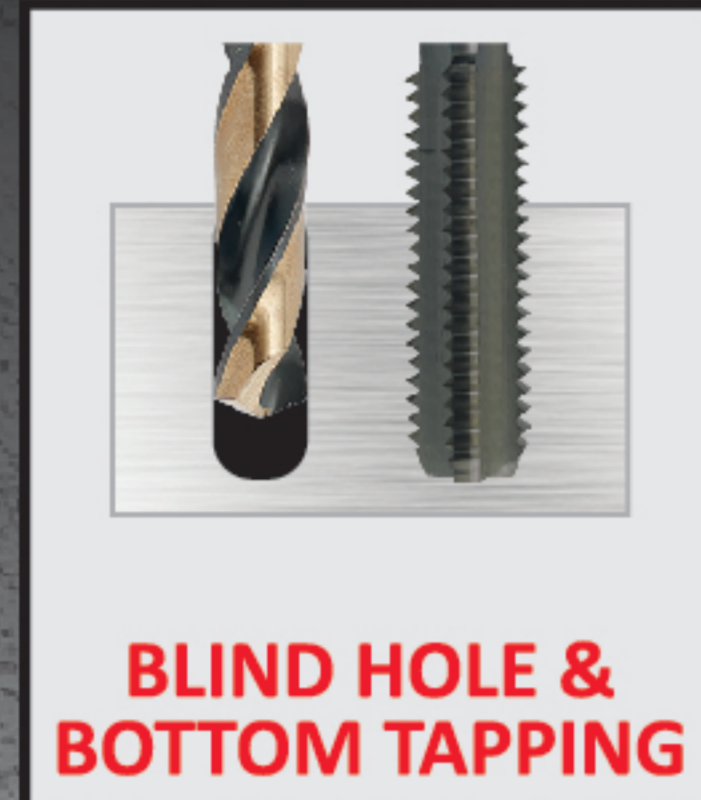
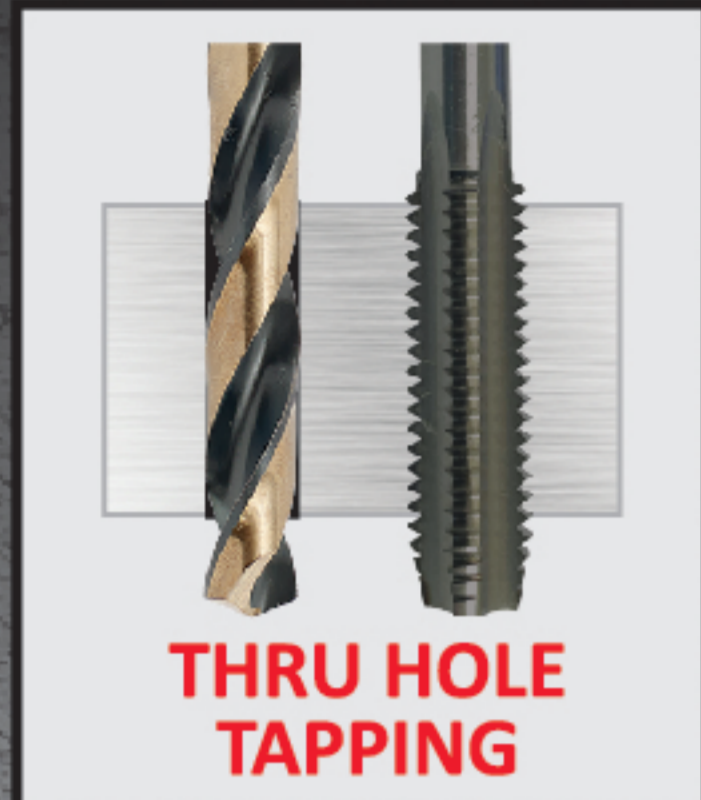




TAP AND DRILL CHART

"ANYTHING THAT MAKES A HOLE"[®]



NF = National Fine
NC = National Course

TAPER

8 to 10 threads chamfered for easy thread starting in tough materials.

PLUG

3 to 5 threads chamfered for general use in thru holes or when tapping to bottom of hole is not critical.
MOST POPULAR STYLE TAP.

BOTTOM

1-1/2 threads chamfered for use after threads have been started. Use for blind holes or clean tapping to bottom of holes.

DRILL THIS SIZE HOLE			
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	TO TAP FOR THIS BOLT OR SCREW
.0469"	3/64"	3/64"	0-80 NF
.0595"	No. 53	none	1-64 NC
.0595"	No. 53	1/16"	1-72 NF
.0700"	No. 50	none	2-56 NC
.0700"	No. 50	none	2-64 NF
.0785"	No. 47	5/64"	3-48 NC
.0820"	No. 45	none	3-56 NF
.0860"	No. 44	none	4-36 NS
.0890"	No. 43	3/32"	4-40 NC
.0935"	No. 42	3/32"	4-48 NF
.0984"	2.5mm	none	3mm-0.60mm
.1015"	No. 38	none	1/8"-40 NS
.1015"	No. 38	none	5-40 NC
.1040"	No. 37	none	5-44 NF
.1100"	No. 35	7/64"	6-32 NC
.1110"	No. 34	none	6-36 NS
.1130"	No. 33	none	6-40 NF
.1200"	No. 31	none	6-48 NS
.1338"	3.4mm	none	4mm-0.70mm
.1338"	3.4mm	none	4mm-0.75mm
.1360"	No. 29	none	8-32 NC
.1360"	No. 29	9/64"	8-36 NF
.1405"	No. 28	none	8-40 NS
.1470"	No. 26	none	3/16"-24 NS
.1495"	No. 25	5/32"	10-24 NC
.1570"	No. 22	none	3/16"-32 NS
.1590"	No. 21	5/32"	10-32 NF
.1653"	4.2mm	none	5mm-0.90mm
.1693"	4.3mm	none	5mm-0.80mm
.1770"	No. 16	11/64"	12-24 NC
.1820"	No. 14	3/16"	12-28 NF
.1850"	No. 13	none	12-32 NEF
.1935"	No. 10	none	14-20 NS
.2010"	No. 7	13/64"	1/4"-20 NC
.2010"	No. 7	none	14-24 NS
.2047"	5.2mm	none	6mm-1.00mm
.2090"	No. 4	none	1/4"-24 NS
.2130"	No. 3	7/32"	1/4"-28 NF
.2188"	7/32"	7/32"	1/4"-32 NEF
.2280"	No. 1	none	1/4"-40 NS
.2401"	6.1mm	15/64"	7mm-1.00mm
.2570"	Ltr. F	17/64"	5/16"-18 NC
.2716"	6.9mm	17/64"	8mm-1.25mm
.2720"	Ltr. I	none	5/16"-24 NF
.2795"	7.1mm	none	8mm-1.00mm
.2812"	9/32"	9/32"	5/16"-32 NEF
.3110"	7.9mm	none	9mm-1.25mm
.3125"	5/16"	5/16"	3/8"-16 NC

DRILL THIS SIZE HOLE			
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	TO TAP FOR THIS BOLT OR SCREW
.3189"	8.1mm	none	9mm-1.00mm
.3268"	8.3mm	none	9mm-0.75mm
.3320"	Ltr. Q	21/64"	3/8"-24 NF
.3425"	8.7mm	none	10mm-1.50mm
.3503"	8.9mm	11/32"	10mm-1.25mm
.3583"	9.1mm	none	*10mm-1.00mm
.3680"	Ltr. U	23/64"	7/16"-14 NC
.3818"	9.7mm	none	11mm-1.50mm
.3906"	25/64"	25/64"	7/16"-20 NF
.4133"	10.5mm	none	12mm-1.75mm
.4212"	10.7mm	27/64"	12mm-1.50mm
.4219"	27/64"	27/64"	1/2"-13 NC
.4291"	10.9mm	27/64"	*12mm-1.25mm
.4531"	29/64"	29/64"	1/2"-20 NF
.4531"	29/64"	29/64"	1/2"-24 NS
.4803"	12.2mm	none	14mm-2.00mm
.4844"	31/64"	31/64"	9/16"-12 NC
.4999"	12.7mm	none	14mm-1.50mm
.5039"	12.8mm	none	*14mm-1.25mm
.5156"	33/64"	33/64"	9/16"-18 NF
.5312"	17/32"	17/32"	5/8"-11 NC
.5590"	14.2mm	35/64"	16mm-2.00mm
.5781"	37/64"	37/64"	5/8"-18 NF
.5787"	14.7mm	none	16mm-1.50mm
.5938"	19/32"	19/32"	11/16"-11 NS
.6220"	15.8mm	39/64"	18mm-2.50mm
.6250"	5/8"	5/8"	11/16"-16 NS
.6562"	21/32"	21/32"	3/4"-10 NC
.6614"	16.8mm	none	*18mm-1.50mm
.6875"	11/16"	11/16"	3/4"-16 NF
.7008"	17.8mm	11/16"	20mm-2.50mm
.7656"	49/64"	49/64"	7/8"-9 NC
.8125"	13/16"	13/16"	7/8"-14 NF
.8228"	20.9mm	none	22mm-1.50mm
.8281"	53/64"	53/64"	*7/8"-18 NS
.8425"	21.4mm	53/64"	24mm-3.00mm
.8750"	7/8"	7/8"	1"-8 NC
.8779"	22.3mm	none	24mm-2.00mm
.9219"	59/64"	59/64"	1"-12 NF
.9375"	15/16"	15/16"	1"-14 NS
.9844"	63/64"	63/64"	1-1/8" - 7 NC
1.0469"	1-3/64"	1-3/64"	1-1/8" - 12 NF
1.1094"	1-7/64"	1-7/64"	1-1/4" - 7 NC
1.1719"	1-11/64"	1-11/64"	1-1/4" - 12 NF
1.2188"	1-7/32"	1-7/32"	1-3/8" - 6 NC
1.2969"	1-19/64"	1-19/64"	1-3/8" - 12 NF
1.3468"	1-11/32"	1-11/32"	1-1/2" - 6 NC
1.4219"	1-27/64"	1-27/64"	1-1/2" - 12 NF

* Spark Plug Taps.