

DECIMAL EQUIVALENTS

Size	Decimal Inches	Size	Decimal Inches	Size	Decimal Inches	Size	Decimal Inches	Size	Decimal Inches
0.25	.0098	2.05	.0807	4.70	.1850	8.40	.3307	14.25	.5610
0.30	.0118	#46	.0810	#13	.1850	Q	.3320	9/16	.5625
#80	.0135	#45	.0820	3/16	.1875	8.50	.3346	14.50	.5709
0.35	.0138	2.10	.0827	4.80	.1890	8.60	.3386	37/64	.5781
#79	.0145	2.15	.0846	#12	.1890	R	.3390	14.75	.5807
1/64	.0156	#44	.0860	#11	.1910	8.70	.3425	15.00	.5906
0.40	.0157	2.20	.0866	4.90	.1929	11/32	.3437	19/32	.5937
#78	.0160	2.25	.0886	#10	.1935	8.80	.3465	15.25	.6004
0.45	.0177	#43	.0890	#9	.1960	S	.3480	39/64	.6094
#77	.0180	2.30	.0905	5.00	.1968	8.90	.3504	15.50	.6102
0.50	.0197	2.35	.0925	#8	.1990	9.00	.3543	15.75	.6201
#76	.0200	#42	.0935	5.10	.2008	T	.3580	5/8	.6250
#75	.0210	3/32	.0937	#7	.2010	9.10	.3583	16.00	.6299
0.55	.0217	2.40	.0945	13/64	.2031	23/64	.3594	16.25	.6398
#74	.0225	#41	.0960	#6	.2040	9.20	.3622	41/64	.6406
0.60	.0236	2.45	.0965	5.20	.2047	9.30	.3661	16.50	.6496
#73	.0240	#40	.0980	#5	.2055	U	.3680	21/32	.6562
#72	.0250	2.50	.0984	5.30	.2087	9.40	.3701	16.75	.6594
0.65	.0256	#39	.0995	#4	.2090	9.50	.3740	17.00	.6693
#71	.0260	2.55	.1004	5.40	.2126	3/8	.3750	43/64	.6719
0.70	.0276	#38	.1015	#3	.2130	V	.3770	17.25	.6791
#70	.0280	2.60	.1024	5.50	.2165	9.60	.3780	11/16	.6875
#69	.0292	#37	.1040	7/32	.2187	9.70	.3819	17.50	.6890
0.75	.0295	2.65	.1043	5.60	.2205	9.80	.3858	17.75	.6988
#68	.0310	2.70	.1063	#2	.2210	W	.3860	45/64	.7031
1/32	.0313	#36	.1065	5.70	.2244	9.90	.3898	18.00	.7087
0.80	.0315	2.75	.1083	#1	.2280	25/64	.3906	18.25	.7185
#67	.0320	7/64	.1093	5.80	.2283	10.00	.3937	23/32	.7187
#66	.0330	#35	.1100	5.90	.2323	X	.3970	18.50	.7283
0.85	.0335	2.80	.1102	A	.2340	10.10	.3976	47/64	.7344
#65	.0350	#34	.1110	15/64	.2344	10.20	.4016	18.75	.7382
0.90	.0354	2.85	.1122	6.00	.2362	Y	.4040	19.00	.7480
#64	.0360	#33	.1130	B	.2380	10.30	.4055	3/4	.7500
#63	.0370	2.90	.1142	6.10	.2401	13/32	.4062	19.25	.7579
0.95	.0374	#32	.1160	C	.2420	10.40	.4094	49/64	.7656
#62	.0380	2.95	.1161	6.20	.2441	Z	.4130	19.50	.7677
#61	.0390	3.00	.1181	D	.2460	10.50	.4134	19.75	.7776
1.00	.0394	#31	.1200	6.30	.2480	10.60	.4173	25/32	.7812
#60	.0400	3.10	.1220	E-1/4	.2500	10.70	.4213	20.00	.7874
#59	.0410	1/8	.1250	6.40	.2520	27/64	.4219	51/64	.7969
1.05	.0413	3.20	.1260	6.50	.2559	10.80	.4252	20.25	.7972
#58	.0420	#30	.1285	F	.2570	10.90	.4291	20.50	.8071
#57	.0430	3.30	.1299	6.60	.2598	11.00	.4330	13/16	.8125
1.10	.0433	3.40	.1339	G	.2610	11.10	.4370	20.75	.8169
1.15	.0453	#29	.1360	6.70	.2638	7/16	.4375	21.00	.8268
#56	.0465	3.50	.1378	17/64	.2656	11.20	.4409	53/64	.8281
3/64	.0469	#28	.1405	H	.2660	11.30	.4449	21.25	.8366
1.20	.0472	9/64	.1406	6.80	.2677	11.40	.4488	27/32	.8437
1.25	.0492	3.60	.1417	6.90	.2716	11.50	.4528	21.50	.8465
1.30	.0512	#27	.1440	I	.2720	29/64	.4531	21.75	.8563
#55	.0520	3.70	.1457	7.00	.2756	11.60	.4567	55/64	.8594
1.35	.0531	#26	.1470	J	.2770	11.70	.4606	22.00	.8661
1.40	.0550	#25	.1495	7.10	.2795	11.80	.4646	7/8	.8750
#54	.0550	3.80	.1496	K	.2810	11.90	.4685	22.25	.8760
1.45	.0571	#24	.1520	9/32	.2812	15/32	.4687	22.50	.8858
1.50	.0591	3.90	.1535	7.20	.2835	12.00	.4724	57/64	.8906
#53	.0595	#23	.1540	7.30	.2874	12.10	.4764	22.75	.8957
1.55	.0610	5/32	.1562	L	.2900	12.20	.4803	23.00	.9055
1/16	.0625	#22	.1570	7.40	.2913	12.30	.4843	29/32	.9062
1.60	.0629	4.00	.1575	M	.2950	31/64	.4843	23.25	.9154
#52	.0635	#21	.1590	7.50	.2953	12.40	.4882	59/64	.9219
1.65	.0650	#20	.1610	19/64	.2968	12.50	.4921	23.50	.9252
1.70	.0669	4.10	.1614	7.60	.2992	12.60	.4961	23.75	.9350
#51	.0670	4.20	.1654	N	.3020	12.70	.5000	15/16	.9375
1.75	.0689	#19	.1660	7.70	.3031	1/2	.5000	24.00	.9449
#50	.0700	4.30	.1693	7.80	.3071	12.80	.5039	61/64	.9531
1.80	.0709	#18	.1695	7.90	.3110	12.90	.5079	24.25	.9547
1.85	.0730	11/64	.1719	5/16	.3125	13.00	.5118	24.50	.9646
#49	.0730	#17	.1730	8.00	.3150	33/64	.5156	31/32	.9688
1.90	.0748	4.40	.1732	O	.3160	13.20	.5197	24.75	.9744
#48	.0760	#16	.1770	8.10	.3189	17/32	.5313	25.00	.9843
1.95	.0768	4.50	.1771	8.20	.3228	13.50	.5315	63/64	.9844
5/64	.0781	#15	.1800	P	.3230	13.80	.5433	1"	1.0000
#47	.0785	4.60	.1811	8.30	.3268	35/64	.5469		
2.00	.0787	#14	.1820	21/64	.3281	14.00	.5512		

Tap Drill Sizes

(Drill sizes based on approximate 72-77% full thread)

Tap Size/ Pitch Form	Tap Drill Size	Alt. Tap Drill	Tap Size/ Pitch Form	Tap Drill Size	Alt. Tap Drill	Tap Size/ Pitch Form	Tap Drill Size	Alt. Tap Drill
Unified Taps			Taper Pipe Taps - NPT			27 - 3.00	61/64	24.00
0 - 80	3/64	1.25	1/16 - 27	D	6.30	30 - 3.50	1-3/64	26.50
1 - 64 UNC	53	1.55	1/8 - 27	R	8.70	33 - 3.50	1-5/32	29.50
1 - 72 UNF	53	1.55	1/4 - 18	7/16	11.10	36 - 4.00	1-1/4	32.00
2 - 56 UNC	51	1.85	3/8 - 18	37/64	14.50	39 - 4.00	1-3/8	35.00
2 - 64 UNF	50	1.90	1/2 - 14	23/32	18.00	I.S.O. Metric Fine		
3 - 48 UNC	47	2.10	3/4 - 14	59/64	23.25	3 - 0.35	37	2.65
3 - 56 UNF	46	2.15	1 - 11.5	1.5/32	29.00	4 - 0.35	27	3.65
4 - 40 UNC	43	2.35	1.1/4 - 11.5	1.1/2	38.00	4 - 0.50	29	3.50
4 - 48 UNF	42	2.40	1.1/2 - 11.5	1.47/64	44.00	4.5 - 0.45	21	4.05
5 - 40 UNC	39	2.65	2" - 11.5	2.7/32	57.00	5 - 0.50	16	4.50
5 - 44 UNF	37	2.70	2.1/2 - 8	2.5/8	67.00	5 - 0.70	18	4.30
6 - 32 UNC	36	2.85	3" - 8	3.1/4	82.50	5 - 0.75	18	4.25
6 - 40 UNF	33	2.95	Straight Pipe Taps - NPS			5.5 - 0.5	9	5.00
8 - 32 UNC	29	3.50	1/8 - 27	S	8.80	6 - 0.50	7/32	5.50
8 - 36 UNF	29	3.50	1/4 - 18	29/64	11.50	6 - 0.75	5	5.25
10 - 24 UNC	25	3.90	3/8 - 18	19/32	15.00	7 - 0.75	D	6.25
10 - 32 UNF	21	4.10	1/2 - 14	47/64	18.50	8 - 0.50	M	7.50
12 - 24 UNC	17	4.50	3/4 - 14	15/16	23.75	8 - 1.00	J	7.00
12 - 28 UNF	15	4.70	1 - 11.5	1.3/16	30.25	9 - 0.50	Q	8.50
1/4 - 20 UNC	7	5.10	1.1/4 - 11.5	1.33/64	38.50	9 - 1.00	O	8.00
1/4 - 28 UNF	3	5.50	1.1/2 - 11.5	1.3/4	44.50	10 - 0.50	3/8	9.50
5/16 - 18 UNC	F	6.60	2" - 11.5	2.7/32	57.00	10 - 0.75	U	9.25
5/16 - 24 UNF	I	6.90	I.S.O. Metric Coarse			10 - 1.00	T	9.00
3/8 - 16 UNC	5/16	8.00	1.6 - 0.35	3/64	1.25	10 - 1.25	11/32	8.75
3/8 - 24 UNF	Q	8.50	1.7 - 0.35	55	1.35	11 - 1.00	X	10.00
7/16 - 14 UNC	U	9.40	1.8 - 0.35	54	1.45	12 - 1.00	7/16	11.00
7/16 - 20 UNF	W	9.90	2 - 0.40	1/16	1.60	12 - 1.25	27/64	10.75
1/2 - 13 UNC	27/64	10.80	2.2 - 0.45	50	1.75	12 - 1.50	Z	10.50
1/2 - 20 UNF	29/64	11.50	2.3 - 0.40	49	1.90	13 - 1.50	29/64	11.50
9/16 - 12 UNC	31/64	12.20	2.5 - 0.45	46	2.05	13 - 1.75	7/16	11.25
9/16 - 18 UNF	33/64	12.90	2.6 - 0.45	44	2.15	14 - 1.25	1/2	12.75
5/8 - 11 UNC	17/32	13.50	3 - 0.50	40	2.50	14 - 1.50	31/64	12.50
5/8 - 18 UNF	37/64	14.50	3.5 - 0.60	33	2.90	15 - 1.50	17/32	13.50
3/4 - 10 UNC	21/32	16.50	4 - 0.70	30	3.30	16 - 1.00	19/32	15.00
3/4 - 16 UNF	11/16	17.50	4.5 - 0.75	27	3.70	16 - 1.25	37/64	14.75
7/8 - 9 UNC	49/64	19.50	5.0 - 0.80	19	4.20	16 - 1.50	9/16	14.50
7/8 - 14 UNF	13/16	20.40	5.5 - 0.90	15	4.60	18 - 1.00	43/64	17.00
1 - 8 UNC	7/8	22.25	6 - 1.00	9	5.00	18 - 1.25	21/32	16.75
1 - 12 UNF	59/64	23.25	7 - 1.00	15/64	6.00	18 - 1.50	41/64	16.50
1 - 14 UNS	15/16	23.50	8 - 1.25	H	6.80	18 - 2.00	5/8	16.00
1.1/8 - 7 UNC	63/64	25.00	9 - 1.25	5/16	7.80	20 - 1.00	3/4	19.00
1.1/8 - 12 UNF	1.3/64	26.50	10 - 1.50	Q	8.50	20 - 1.50	47/64	18.50
1.1/4 - 7 UNC	1.7/64	28.00	11 - 1.50	3/8	9.50	20 - 2.00	45/64	18.00
1.1/4 - 12 UNF	1.11/64	29.50	12 - 1.75	Y	10.20	22 - 1.00	53/64	21.00
1.3/8 - 6 UNC	1.7/32	30.75	14 - 2.00	15/32	12.00	22 - 1.50	13/16	20.50
1.3/8 - 12 UNF	1.19/64	32.75	16 - 2.00	35/64	14.00	22 - 2.00	25/32	20.00
1.1/2 - 6 UNC	1.11/32	34.00	18 - 2.50	39/64	15.50	24 - 1.00	29/32	23.00
1.1/2 - 12 UNF	1.27/64	36.00	20 - 2.50	11/16	17.50	24 - 1.50	7/8	22.50
1.3/4 - 5 UNC	1.9/16	39.50	22 - 2.50	49/64	19.50	24 - 2.00	55/64	22.00
2" - 4.1/2 UNC	1.25/32	45.00	24 - 3.00	53/64	21.00	24 - 2.50	27/32	21.50

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