

DECIMAL INCHES	SIZES	DECIMAL INCHES	SIZES	DECIMAL INCHES	SIZES
0135	80	.1299	3.30mm	.3160	0
0138	35mm	.1339	3.40mm	.3189	8.10mm
0145	79	.1360	29	.3228	8.10mm
0156	1/64	.1378	3.50mm	.3230	P
0157	40mm	.1405	28	.3248	8.25mm
0160	78	.1406	9/64	.3268	8.30mm
0177	45mm	.1417	3.60mm	.3281	21/64
0180	77	.1440	27	.3307	8.40mm
0197	50mm	.1457	3.70mm	.3320	0
0200	76	.1470	26	.3346	8.50mm
0210	75	.1476	3.75mm	.3386	8.60mm
0217	55mm	.1495	25	.3390	R
0225	74	.1496	3.80mm	.3425	8.70mm
0236	60mm	.1520	24	.3438	11/32
0240	73	.1535	3.90mm	.3445	8.75mm
0250	72	.1540	23	.3465	8.80mm
0256	65mm	.1562	5/32	.3480	S
0260	71	.1570	22	.3504	8.90mm
0276	70mm	.1575	4.00mm	.3543	9.00mm
0280	70	.1590	21	.3580	T
0292	69	.1610	20	.3583	9.10mm
0295	75mm	.1614	4.10mm	.3594	23/64
0310	68	.1654	4.20mm	.3622	9.20mm
0312	1/32	.1660	19	.3642	9.25mm
0315	80mm	.1673	4.25mm	.3661	9.30mm
0320	67	.1693	4.30mm	.3680	U
0330	66	.1695	18	.3701	9.40mm
0335	85mm	.1719	11/64	.3740	9.50mm
0350	65	.1730	17	.3750	3/8
0354	90mm	.1732	4.40mm	.3770	V
0360	64	.1770	16	.3780	9.60mm
0370	63	.1772	4.50mm	.3819	9.70mm
0374	95mm	.1800	15	.3839	9.75mm
0380	62	.1811	4.60mm	.3858	9.80mm
0390	61	.1820	14	.3860	W
0394	1.00mm	.1850	13	.3898	9.90mm
0400	60	.1850	4.70mm	.3906	25/64
0410	59	.1870	4.75mm	.3937	10.00mm
0413	1.05mm	.1875	3/16	.3970	X
0420	58	.1890	12	.4016	10.20mm
0430	57	.1890	4.80mm	.4040	Y
0433	1.10mm	.1910	11	.4062	13/32
0453	1.15mm	.1929	4.90mm	.4130	Z
0465	56	.1935	10	.4134	10.50mm
0469	3/64	.1960	9	.4219	27/64
0472	1.20mm	.1969	5.00mm	.4232	10.75mm
0492	1.25mm	.1990	8	.4331	11.00mm
0512	1.30mm	.2008	5.10mm	.4375	7/16
0520	55	.2010	7	.4528	11.50mm
0531	1.35mm	.2031	13/64	.4531	29/64
0550	54	.2040	6	.4688	15/32
0551	1.40mm	.2047	5.20mm	.4724	12.00mm
0571	1.45mm	.2055	5	.4844	31/64
0591	1.50mm	.2067	5.25mm	.4921	12.50mm
0595	53	.2087	5.30mm	.5000	1/2
0610	1.55mm	.2090	4	.5118	13.00mm
0625	1/16	.2126	5.40mm	.5156	33/64
0630	1.60mm	.2130	3	.5312	17/32
0635	52	.2165	5.50mm	.5315	13.50mm
0650	1.65mm	.2188	7/32	.5469	35/64
0669	1.70mm	.2205	5.60mm	.5512	14.00mm
0670	51	.2210	2	.5625	9/16
0689	1.75mm	.2244	5.70mm	.5709	14.50mm
0700	50	.2264	5.75mm	.5781	37/64
0709	1.80mm	.2280	1	.5906	15.00mm
0728	1.85mm	.2283	5.80mm	.5938	19/32
0730	49	.2323	5.90mm	.6094	39/64
0748	1.90mm	.2340	A	.6102	15.50mm
0760	48	.2344	15/64	.6250	5/8
0768	1.95mm	.2362	6.00mm	.6299	16.00mm
0781	5/64	.2380	B	.6406	41/64
0785	47	.2402	6.10mm	.6496	16.50mm
0787	2.00mm	.2420	C	.6562	21/32
0807	2.05mm	.2441	6.20mm	.6693	17.00mm
0810	46	.2460	D	.6719	43/64
0820	45	.2461	6.25mm	.6875	11/16
0827	2.10mm	.2480	6.30mm	.6890	17.50mm
0846	2.15mm	.2500	E	.7031	45/64
0860	44	.2500	1/4	.7087	18.00mm
0866	2.20mm	.2520	6.40mm	.7188	23/32
0886	22.5mm	.2559	6.50mm	.7283	18.50mm
0890	43	.2570	F	.7344	47/64
0906	2.30mm	.2598	6.60mm	.7480	19.00mm
0925	2.35mm	.2610	G	.7500	3/4
0935	42	.2638	6.70mm	.7656	49/64
0938	3.32	.2656	17/64	.7677	19.50mm
0945	2.40mm	.2657	6.76mm	.7812	25/32
0960	41	.2660	H	.7874	20.00mm
0965	2.45mm	.2677	6.80mm	.7969	51/64
0980	40	.2717	6.90mm	.8071	20.50mm
0984	2.50mm	.2720	I	.8125	13/16
0995	39	.2756	7.00mm	.8268	21.00mm
1015	38	.2770	J	.8281	53/64
1024	2.60mm	.2795	7.10mm	.8438	27/32
1040	37	.2810	K	.8465	21.50mm
1063	2.70mm	.2812	9/32	.8594	55/64
1065	36	.2835	7.20mm	.8661	22.00mm
1083	2.75mm	.2854	7.25mm	.8750	7/8
1094	7/64	.2874	7.30mm	.8858	22.50mm
1100	35	.2900	L	.8906	57/64
1102	2.80mm	.2913	7.40mm	.9055	23.00mm
1110	34	.2950	M	.9062	29/32
1130	33	.2953	7.50mm	.9219	59/64
1142	2.90mm	.2969	19/64	.9252	23.50mm
1160	32	.2992	7.60mm	.9375	15/16
1181	3.00mm	.3020	N	.9449	24.00mm
1200	31	.3031	7.70mm	.9531	61/64
1220	3.10mm	.3051	7.75mm	.9646	24.50mm
1250	1/8	.3071	7.80mm	.9688	31/32
1260	3.20mm	.3110	7.90mm	.9843	25.00mm
1280	3.25mm	.3125	5/16	.9844	63/64
1285	30	.3150	8.00mm	1.0000	25.00mm

TAP-DRILL CHART

Recommended tap drill to use for 75% depth of thread

DRILL THIS SIZE HOLE			TO TAP FOR THIS SIZE BOLT OR SCREW	DRILL THIS SIZE HOLE			TO TAP FOR THIS SIZE BOLT OR SCREW
DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION		DECIMAL INCHES	DRILL SIZE	NEAREST FRACTION	
.0469"	3/64"	3/64"	0-80 NF	.3583"	9.1mm	none	*10mm-1.00mm
.0595	No. 53	none	1-64-NC	.3680	Ltr. U	23/64"	7/16-14 NC
.0595	No. 53	1/16	1-72-NF	.3818	9.7mm	none	11mm-1.50mm
.0700	No. 50	none	2-56-NC	.3906	25/64"	25/64	7/16-20 NF
.0700	No. 50	none	2-64 NF	.4133	10.5mm	none	12mm-1.75mm
.0785	No. 47	5/64	3-48 NC	.4212	10.7mm	27/64	12mm-1.50mm
.0820	No. 45	none	3-56 NF	.4219	27/64"	27/64	1/2-13 NC
.0860	No. 44	none	4-36 NS	.4291	10.9mm	27/64	*12mm-1.25mm
.0890	No. 43	3/32	4-40 NC	.4531	29/64"	29/64	1/2-20 NF
.0935	No. 42	3/32	4-48 NF	.4531	29/64"	29/64	1/2-24 NS
.0984	2.5mm	none	3mm-0.60mm	.4803	12.2mm	none	14mm-2.00mm
.1015	No. 38	none	1/8-40 NS	.4844	31/64"	31/64	9/16-12 NC
.1015	No. 38	none	5-40 NC	.4999	12.7mm	none	14mm-1.50mm
.1040	No. 37	none	5-44 NF	.5039	12.8mm	none	*14mm-1.25mm
.1100	No. 35	7/64	6-32 NC	.5156	33/64"	33/64	9/16-18 NF
.1110	No. 34	none	6-36 NS	.5312	17/32"	17/32	5/8-11 NC
.1130	No. 33	none	6-40 NF	.5590	14.2mm	35/64	16mm-2.00mm
.1200	No. 31	none	6-48 NS	.5781	37/64"	37/64	5/8-18 NF
.1338	3.4mm	none	4mm-0.70mm	.5787	14.7mm	none	16mm-1.50mm
.1338	3.4mm	none	4mm-0.75mm	.5938	19/32"	19/32	11/16-11 NS
.1360	No. 29	none	8-32 NC	.6220	15.8mm	39/64	18mm-2.50mm
.1360	No. 29	9/64	8-36 NF	.6250	5/8"	5/8	11/16-16 NS
.1405	No. 28	none	8-40 NS	.6562	21/32"	21/32	3/4-10 NC
.1470	No. 26	none	3/16-24 NS	.6614	16.8mm	none	*18mm-1.50mm
.1495	No. 25	5/32	10-24 NC	.6875	11/16"	11/16	3/4-16 NF
.1570	No. 22	none	3/16-32 NS	.7008	17.8mm	11/16	20mm-2.50mm
.1590	No. 21	5/32	10-32 NF	.7656	49/64"	49/64	7/8-9 NC
.1653	4.2mm	none	5mm-0.90mm	.8125	13/16"	13/16	7/8-14 NF
.1693	4.3mm	none	5mm-0.80mm	.8228	20.9mm	none	22mm-1.50mm
.1770	No. 16	11/64	12-24 NC	.8281	53/64"	53/64	*7/8-18 NS
.1820	No. 14	3/16	12-28 NF	.8425	21.4mm	53/64	24mm-3.00mm
.1850	No. 13	none	12-32 NEF	.8750	7/8"	7/8	1-8 NC
.1935	No. 10	none	14-20 NS	.8779	22.3mm	none	24mm-2.00mm
.2010	No. 7	13/64	1/4-20 NC	.9219	59/64"	59/64	1-12 NF
.2010	No. 7	none	14-24 NS	.9375	15/16"	15/16	1-14 NS
.2047	5.2mm	none	6mm-1.00mm	.9844	63/64"	63/64	1-1/8-7 NC
.2090	No. 4	none	1/4-24 NS	1.0469	1-3/64"	1-3/64	1-1/8-12 NF
.2130	No. 3	7/32	1/4-28 NF	1.1094	1-7/64"	1-7/64	1-1/4-7 NC
.2188	7/32"	7/32	1/4-32 NEF	1.1719	1-11/64"	1-11/64	1-1/4-12 NF
.2280	No. 1	none	1/4-40 NS	1.2188	1-7/32"	1-7/32	1-3/8-6 NC
.2401	6.1mm	15/64	7mm-1.00mm	1.2969	1-19/64"	1-19/64	1-3/8-12 NF
.2570	Ltr. F	17/64	5/16-18 NC	1.3438	1-11/32"	1-11/32	1-1/2-6 NC
.2716	6.9mm	17/64	8mm-1.25mm	1.4219	1-27/64"	1-27/64	1-1/2-12 NF
.2720	Ltr. I	none	5/16-24 NF	NATIONAL PIPE TAPERED TAPS			
.2795	7.1mm	none	8mm-1.00mm	.3390"	Ltr. R	none	1/8-27 NPT
.2812	9/32"	9/32	5/16-32 NEF	.4375	7/16"	7/16"	1/4-18 NPT
.3110	7.9mm	none	9mm-1.25mm	.5781	37/64"	37/64	3/8-18 NPT
.3125	5/16"	5/16	3/8-16 NC	.7031	45/64"	45/64	1/2-14 NPT
.3189	8.1mm	none	9mm-1.00mm	.9219	59/64"	59/64	3/4-14 NPT
.3268	8.3mm	none	9mm-0.75mm	1.1562	1-5/32"	1-5/32	1-11-1/2 NPT
.3320	Ltr. Q	21/64	3/8-24 NF	1.5000	1-1/2"	1-1/2	1 1/4-11 1/2 NPT
.3425	8.7mm	none	10mm-1.50mm	1.7344	1-47/64"	1-47/64	1 1/2-11 1/2 NPT
.3503	8.9mm	11/32	10mm-1.25mm	2.2188	2-7/32"	2-7/32	2-11 1/2 NPT

*Spark Plug Taps