



# 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	0.469	54	0.650
	M1.6 x 0.35	1.25	0.492	1.45	0.671
	M1.6 x 0.35	1.45	0.671	1.65	0.650
1-64		53	0.695	51	0.670
1-72		53	0.695	51	0.670
	M2 x 0.40	1.80	0.630	1.80	0.709
2-56		50	0.700	48	0.751
2-64		50	0.700	47	0.735
	M2.2 x 0.45	1.75	0.649	2.00	0.787
	M2.5 x 0.45	2.05	0.807	2.30	0.908
3-48		47	0.785	43	0.890
3-56		46	0.810	3.30	0.900
4-40		43	0.890	39	1.015
4-48		42	0.905	2.80	1.024
	M3 x 0.50	2.50	0.954	2.84	1.094
5-40		38	1.015	33	1.130
5-44		37	1.040	2.90	1.142
	M3.5 x 0.60	2.80	1.142	3.20	1.280
6-32		36	1.065	3.8	1.250
6-40		33	1.130	3.25	1.280
	M4 x 0.70	3.30	1.299	3.70	1.478
8-32		29	1.360	29	1.495
8-36		29	1.360	24	1.520
	M4.5 x 0.75	3.75	1.478	4.10	1.614
10-24		26	1.470	11.64	1.719
10-32		21	1.580	16	1.770
	M5 x 0.80	4.20	1.654	14	1.820
12-24		18	1.770	8	1.990
12-28		18	1.800	7	2.010
	M6 x 1.00	5.00	1.969	7.02	2.188
1/4-20		7	2.010	1	2.080
1/4-28		3	2.130	15.64	2.340
	M7 x 1.00	6.00	2.362	F	2.570
5/16-18		F	2.570	L	2.900
5/16-24		L	2.720	M	2.900
	M8 x 1.25	6.70	2.638	7.40	2.913
	M8 x 1.00	7.00	2.758	16.64	2.969
3/8-16		9.75	3.125	S	3.480
3/8-24		O	3.320	T	3.680
	M10 x 1.50	8.50	3.348	9.40	3.701
	M10 x 1.25	8.70	3.425	9.40	4.040
		U	3.690	V	4.130
7/16-14		11.00	3.608	2	4.430
7/16-20		10.20	4.018	11.20	4.429
	M12 x 1.75	10.20	4.252	11.50	4.829
	M12 x 1.25	10.80	4.252	15.02	4.892
		23.64	4.219	13.25	4.820
1/2-13		20.64	4.831	13.25	5.158
1/2-20		12.00	4.724	23.64	5.312
9/16-12		23.64	4.844	13.50	5.315
9/16-18		23.64	5.158		

Tap Size & Pitch		Cutting Taps		Forming Taps	
Inch	Metric	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
5/8-11		17.00	5.312	14.75	5.807
5/8-18		20.64	5.312	15.25	6.004
	M18 x 2.50	14.00	5.512	19.02	6.508
	M18 x 1.50	14.50	5.709	15.25	6.004
	M18 x 2.50	15.50	6.102	23.64	6.094
	M18 x 1.50	16.50	6.496	17.25	6.791
3/4-10		21.00	6.562	45.64	7.251
3/4-16		17.75	6.875	23.02	7.168
	M20 x 2.50	17.50	6.890	"	"
	M20 x 1.50	18.50	7.283	"	"
	M20 x 2.50	19.50	7.677	"	"
	M22 x 1.50	20.50	8.071	"	"
7/8-9		49.64	7.658	"	"
7/8-14		19.75	8.125	"	"
	M24 x 3.00	21.00	8.268	"	"
	M24 x 2.00	22.00	8.661	"	"
1-8		7.8	8.750	"	"
1-12		6.64	9.219	"	"
	M27 x 3.00	24.00	9.449	"	"
	M27 x 2.00	25.00	9.843	"	"
1 1/8-7		6.564	9.844	"	"
1 1/8-12		1.364	1.0490	"	"
	M30 x 3.50	26.50	1.0430	"	"
	M30 x 2.00	28.50	1.1024	"	"
1 1/4-7		1.764	1.1094	"	"
1 1/4-12		1.164	1.1719	"	"
	M33 x 3.50	29.50	1.1614	"	"
	M33 x 2.00	31.50	1.2208	"	"
1 3/8-6		1.702	1.2188	"	"
1 3/8-12		1.1864	1.2969	"	"
	M36 x 4.00	32.50	1.2990	"	"
	M36 x 3.00	33.50	1.2992	"	"
1 1/2-6		1.1630	1.3408	"	"
1 1/2-12		1.2064	1.4219	"	"
	M39 x 4.00	35.50	1.3780	"	"
	M39 x 3.00	36.50	1.4173	"	"

PIPE TAPS: NPT, NPTF, NPSM, NPSC, NPSF

Nominal Pipe Tap Size	NPT & NPTF					NPSF
	Metric Equivalent	80% Thread	NPSM	NPSC	290	
1/16-27	C (1.412)	A (1.234)	—	—	290	C (1.248)
1/8-27	C (1.332)	2.164	T (1.368)	C (1.302)	—	H (1.308)
1/4-18	7.18	2.784	5.332	5.78	—	2.784
3/8-18	9.78	9.78	6.00*	3.784	—	3.784
1/2-14	45.64	13.18	15.0 mm	15.0 mm	—	15.0 mm
3/4-14	29.62	2.764	6.164	5.64	—	5.64
1-11 1/2	1.644	1.18	1.1364	1.530	—	1.530
1 1/4-11 1/2	1.3164	1.592	1.3564	1.52	—	—
1 1/2-11 1/2	1.2932	1.4564	1.2932	1.4764	—	—
2-11 1/2	2.376	2.164	2.14	2.1364	—	—

■ METRIC    
 ■ FRACTIONAL    
 ■ WIRE GAGE    
 ■ LETTER SIZE

# Machine Tapping Guide

**Canada. Patent Office**



## Machine Tapping Guide:

Screwcutting Marcus Bowman,2015-08-31 Screwcutting is a guide to the theory and practice of threads and thread making whether that is threading a hole using hand tools or cutting a thread using a lathe The book covers details of the major threadforms such as metric Whitworth and Unified threads as well as the British Association BA and Model Engineering ME and MME series the smaller metric and Unified threads pipe threads and specialist threads such as ACME trapezoidal and RMS microscope threads Techniques for making threads manually as well as screwcutting in the lathe are also covered As well as covering the basics of screwcutting this book examines higher level and advanced techniques using case studies to demonstrate what can be achieved fine accurate and well finished work Illustrated throughout Machine tools Charles James Appleby,1897 Specifications and Drawings of Patents Issued from the United States Patent Office United States. Patent Office,1911 **American Machinist** ,1900 *India Rubber World* ,1905 Official Gazette of the United States Patent Office United States. Patent Office,1900 Western Machinery and Steel World ... ,1928 **The Tool Engineer** ,1942 **Machine and Tool Blue Book** ,1956 *Machinery* Fred Herbert Colvin,Lester Gray French,1906 **Iron Age** ,1898 **Automotive Industries** ,1921 **Official Gazette of the United States Patent Office** USA Patent Office,1899 *Machinery* Lester Gray French,1907 **The Canadian Patent Office Record and Register of Copyrights and Trade Marks** ,1902 American Machinist & Automated Manufacturing ,1924 **Modern Machine Shop** ,1952 Michigan Manufacturer & Financial Record ,1925 *Machinery Market* ,1929 **Scientific Canadian Mechanics' Magazine and Patent Office Record** Canada. Patent Office,1889

## Decoding **Machine Tapping Guide**: Revealing the Captivating Potential of Verbal Expression

In a time characterized by interconnectedness and an insatiable thirst for knowledge, the captivating potential of verbal expression has emerged as a formidable force. Its capability to evoke sentiments, stimulate introspection, and incite profound transformations is genuinely awe-inspiring. Within the pages of "**Machine Tapping Guide**," a mesmerizing literary creation penned with a celebrated wordsmith, readers set about an enlightening odyssey, unraveling the intricate significance of language and its enduring affect our lives. In this appraisal, we shall explore the book's central themes, evaluate its distinctive writing style, and gauge its pervasive influence on the hearts and minds of its readership.

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