

STANDARD TAPS AND DIES (In Inches)

Thread Size	Coarse			Fine		
	Drill Size	Threads Per Inch	Decimal Size	Drill Size	Threads Per Inch	Decimal Size
4"	3	4	3.75			
3 ³ / ₄ "	3	4	3.5			
3 ¹ / ₂ "	3	4	3.25			
3 ¹ / ₄ "	3	4	3.0			
3"	2	4	2.75			
2 ³ / ₄ "	2	4	2.5			
2 ¹ / ₂ "	2	4	2.25			
2 ¹ / ₄ "	2	4.5	2.0313			
2"	1	4.5	1.7813			
1 ³ / ₄ "	1	2	1.5469			
1 ¹ / ₂ "	1	6	1.3281	1 ²⁷ / ₆₄ "	12	1.4219
1 ³ / ₈ "	1	6	1.2188	1 ¹⁹ / ₆₄ "	12	1.2969
1 ¹ / ₄ "	1	7	1.1094	1 ¹¹ / ₆₄ "	12	1.1719
1 ¹ / ₈ "	⁶³ / ₆₄ "	7	.9844	1 ³ / ₆₄ "	12	1.0469
1"	⁷ / ₈ "	8	.8750	¹⁵ / ₁₆ "	14	.9375
⁷ / ₈ "	⁴⁹ / ₆₄ "	9	.7656	¹³ / ₁₆ "	14	.8125
³ / ₄ "	²¹ / ₃₂ "	10	.6563	¹¹ / ₁₆ "	16	.6875
⁵ / ₈ "	¹⁷ / ₃₂ "	11	.5313	³⁷ / ₆₄ "	18	.5781
⁹ / ₁₆ "	³¹ / ₆₄ "	12	.4844	³³ / ₆₄ "	18	.5156
¹ / ₂ "	²⁷ / ₆₄ "	13	.4219	²⁹ / ₆₄ "	20	.4531
⁷ / ₁₆ "	U	14	.368	²⁵ / ₆₄ "	20	.3906
³ / ₈ "	⁵ / ₁₆ "	16	.3125	Q	24	.332
⁵ / ₁₆ "	F	18	.2570	I	24	.272
¹ / ₄ "	#7	20	.201	#3	28	.213
#12	#16	24	.177	#14	28	.182
#10	#25	24	.1495	#21	32	.159
³ / ₁₆ "	#26	24	.147	#22	32	.157
#8	#29	32	.136	#29	36	.136
#6	#36	32	.1065	#33	40	.113
#5	#38	40	.1015	#37	44	.104
¹ / ₈ "	³ / ₃₂ "	32	.0938	#38	40	.1015
#4	#43	40	.089	#42	48	.0935
#3	#47	48	.0785	#45	56	.082
#2	#50	56	.07	#50	64	.07
#1	#53	64	.0595	#53	72	.0595
#0	-	-	-	³ / ₆₄ "	80	.0469

(mm) Thread Pitch	TAPS AND DIES – METRIC CONVERSIONS			
	Fine Thread Size		Tap Drill Size	
	Inches	mm	Inches	mm
4.5	1.6535	42	1.4567	37.0
4.0	1.5748	40	1.4173	36.0
4.0	1.5354	39	1.3779	35.0
4.0	1.4961	38	1.3386	34.0
4.0	1.4173	36	1.2598	32.0
3.5	1.3386	34	1.2008	30.5
3.5	1.2992	33	1.1614	29.5
3.5	1.2598	32	1.1220	28.5
3.5	1.1811	30	1.0433	26.5
3.0	1.1024	28	.9842	25.0
3.0	1.0630	27	.9449	24.0
3.0	1.0236	26	.9055	23.0
3.0	.9449	24	.8268	21.0
2.5	.8771	22	.7677	19.5
2.5	.7974	20	.6890	17.5
2.5	.7087	18	.6102	15.5
2.0	.6299	16	.5118	14.0
2.0	.5512	14	.4724	12.0
1.75	.4624	12	.4134	10.5
1.50	.4624	12	.4134	10.5
1.50	.3937	11	.3780	9.6
1.50	.3937	10	.3386	8.6
1.25	.3543	9	.3071	7.8
1.25	.3150	8	.2677	6.8
1.0	.2856	7	.2362	6.0
1.0	.2362	6	.1968	5.0
.90	.2165	5.5	.1811	4.6
.80	.1968	5	.1653	4.2
.75	.1772	4.5	.1476	3.75
.70	.1575	4	.1299	3.3
.75	.1575	4	.1279	3.25
.60	.1378	3.5	.1142	2.9
.60	.1181	3	.0945	2.4
.50	.1181	3	.0984	2.5
.45	.1124	2.6	.0827	2.1
.45	.0984	2.5	.0787	2.0
.40	.0895	2.3	.0748	1.9
.40	.0787	2	.0630	1.6
.45	.0787	2	.0590	1.5
.35	.0590	1.5	.0433	1.1