

Did You Know?

| 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 - 2.50 | 53/64 | 21.00 | 24 - 2.50 | 27/32 | 21.50 |

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