

# 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
<b>UNIFIED TAPS</b>			<b>TAPER PIPE TAPS -NPT</b>			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	<b>I.S.O. METRIC FINE</b>		
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	<b>STRAIGHT PIPE TAPS -NPS</b>			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	<b>I.S.O. METRIC COARSE</b>			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