



Société d'acier et d'outillage Industriels Itée
Industrial steel & supply Co. Ltd

S.A.O.I.

DISTRIBUTEUR D'OUTILLAGES ET ACCESSOIRES

TAP DRILL SIZES

TAP SIZE	TPI	TAP DRILL	TAP SIZE	TPI	TAP DRILL	TAP SIZE	TPI	TAP DRILL	TAP SIZE	TPI	TAP DRILL			
N° 0	80	NF 3/64	N° 8	32	NC 29		7/16	14	NC	U	1"	8	NC	7/8
1	64	NC 53		36	NF 29			20	NF	25/64		12	NF	59/64
	72	NF 53	10	24	NC 25	1/2		13	NC	27/64		14	NS	15/16
2	56	NC 50		32	NF 21			20	NF	29/64	1-1/8	7	NC	63/64
	64	NF 50	12	24	NC 16		9/16	12	NC	31/64		12	NF	1-3/64
3	48	NC 47		28	NF 14			18	NF	33/64	1-1/4	7	NC	1-7/64
	56	NF 45					5/8	11	NC	17/32		12	NF	1-11/64
4	36	NS 44						18	NF	37/64	1-3/8	6	NC	1-7/32
	40	NC 43	1/4	20	NC 7		11/16	11	NS	19/32		12	NF	1-19/64
	48	NF 42		28	NF 3			16	NC	5/8	1-1/2	6	NC	1-11/32
5	40	NC 38	5/16	18	NC F	3/4		10	NC	21/32		12	NF	1-27/64
	44	NF 37		24	NF I			16	NF	11/16	1-5/8	5-1/2	NS	1-29/64
6	32	NC 36	3/8	16	NC 5/16		7/8	9	NC	49/64	1-3/4	5	NC	1-9/16
	40	NF 33		24	NF Q			14	NF	13/16	2"	4-1/2	NC	1-25/32

TAP DRILL SIZES — METRIC

SIZE OVER 1-1/8" DIAMETER
RECOMMEND REAMING

SIZE M M	PITCH M M	DRILL M M	INCH EQUIV	DRILL INCH	SIZE M M	PITCH M M	DRILL M M	INCH EQUIV	DRILL INCH	SIZE M M	PITCH M M	DRILL M M	INCH EQUIV	DRILL INCH
M1.6	0.35	1.25	.049	3/64	M8	1.25	6.75	.266	17/64	M16	2.0	14.0	.551	35/64
M2	0.4	1.6	.063	1/16		1.0	7.0	.276	J		1.5	14.5	.571	9/16
M2.5	0.45	2.05	.081	46	M10	1.5	8.5	.335	Q	M18	2.5	15.5	.610	39/64
M3	0.5	2.5	.098	40		1.25	8.75	.344	11/32		1.5	16.5	.650	41/64
M4	0.7	3.3	.130	30	M12	1.75	10.2	.402	Y	M20	2.5	17.5	.689	11/16
M5	0.8	4.2	.165	19		1.25	10.7	.421	27/64		1.5	18.5	.728	23/32
M6	1.0	5.0	.197	9	M14	2.0	12.0	.472	15/32	M24	3.0	21.0	.827	53/64
M6.3	1.0	5.3	.209	4		1.5	12.5	.492	31/64		2.0	22.0	.866	55/64
M7	1.0	6.0	.236	15/64						M39	4.0	35.0	1.378	1-3/8
											3.0	36.0	1.417	1-27/64

PIPE TAP DRILL SIZES

THE ISO PIPE STANDARD IS
THE BRITISH STANDARD

NATIONAL PIPE THREADS

BRITISH & ISO PIPE THREADS

SIZE	TPI	NPT		NPTF		NPS		SIZE	Whit form	BSPT taper		BSP parallel		ISO TAPER		ISO parallel		
		TAP DRILL	DECI-MAL	TAP DRILL	DECI-MAL	TAP DRILL	DECI-MAL			TAP DRILL	DECI-MAL	TAP DRILL	DECI-MAL	TAP DRILL	DECI-MAL	TAP DRILL	DECI-MAL	
1/16	27	D	.246	D	.246	1/4	.250	1/16	28	1/4	.250	F	.257	6.3	.248	6.5	.255	
	1/8	Q	.332	R	.339	1/32	.344	1/8	28	21/64	.328	Q	.332	8.3	.327	8.5	.335	
1/4	18	7/16	.438	7/16	.438	7/16	.438	1/4	19	7/16	.438	29/64	.453	11	.433	11.5	.453	
	3/8	18	9/16	.562	37/64	.578	37/64	.578	3/8	19	9/16	.562	37/64	.578	14.5	.571	15	.591
1/2	14	45/64	.703	45/64	.703	23/32	.719	1/2	14	23/32	.719	47/64	.734	18	.709	18.5	.728	
	3/4	14	29/32	.906	59/64	.922	59/64	.922	3/4	14	59/64	.922	61/64	.953	23.5	.925	24	.945
1"	11-1/2	1-9/64	1.141	1-5/32	1.156	1-5/32	1.156	1"	11	1-11/64	1.172	1-3/16	1.188	29.5	1.161	30.2	1.189	
	1-1/4	1-31/64	1.484	1-1/2	1.500	1-33/64	1.500	1-1/4	11	1-1/2	1.500	1-17/32	1.531	38	1.496	39	1.535	
1-1/2	11-1/2	1-47/64	1.734	1-47/64	1.734	1-3/4	1.750	1-1/2	11	1-47/64	1.734	1-49/64	1.766	44	1.732	45	1.771	
	2"	11-1/2	2-13/64	2.203	2-7/32	2.219	2-7/32	2.219	2"	11	2-3/16	2.188	2-15/64	2.234	55.5	2.185	56.5	2.224

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