

N.C. OR U.S.S. STD. SCREW THRDS	
TAP	DRILL SIZE
1/4 - 20	7
5/16 - 18	F
3/8 - 16	5/16
7/16 - 14	U
1/2 - 13	27/64
9/16 - 12	31/64
5/8 - 11	17/32
3/4 - 10	21/32
7/8 - 9	49/64
1 - 8	7/8
1 1/8 - 7	63/64

MACHINE SCREWS	
TAP	DRILL SIZE
2 - 56	50
3 - 48	47
4 - 32	45
4 - 36	44
4 - 40	43
6 - 32	36
8 - 32	29
10 - 24	25
10 - 32	21
12 - 24	16
14 - 20	10

N.P.T. PIPE THREADS		
TAP	DRILL SIZE	
1/8 - 27	Q	.332
1/4 - 18	7/16	T
3/8 - 18	9/16	A
1/2 - 14	45/64	P
3/4 - 14	29/32	E
1 - 1 1/2	1-9/64	R
1 1/4 - 1 1/2	1-31/64	3/4"
1 1/2 - 1 1/2	1-23/32	P
2 - 1 1/2	2-3/16	E
2 1/2 - 8	2-39/64	R
3 - 8	3-1/4	FT.

N.F. OR S.A.E. STD. SCREW THRDS	
TAP	DRILL SIZE
1/4 - 28	3
5/16 - 24	I
3/8 - 24	Q
7/16 - 20	25/64
1/2 - 20	29/64
9/16 - 18	33/64
5/8 - 18	37/64
3/4 - 16	11/16
7/8 - 14	13/16
1 - 14	15/16
1 1/8 - 12	1 3/64

1/64	.0156	9/64	.1406	17/64	.2656	25/64	.3906	33/64	.5156	41/64	.6406	49/64	.7656	57/64	.8906
1/32	.0312	5/32	.1562	9/32	.2812	13/32	.4062	17/32	.5312	21/32	.6562	25/32	.7812	29/32	.9062
3/64	.0469	11/64	.1719	19/64	.2969	27/64	.4219	35/64	.5469	43/64	.6719	51/64	.7969	59/64	.9219
1/16	.0625	3/16	.1875	5/16	.3125	7/16	.4375	9/16	.5625	11/16	.6875	13/16	.8125	15/16	.9375
5/64	.0781	13/64	.2031	21/64	.3281	29/64	.4531	37/64	.5781	45/64	.7031	53/64	.8281	61/64	.9531
3/32	.0937	7/32	.2187	11/32	.3437	15/32	.4687	19/32	.5937	23/32	.7187	27/32	.8437	31/32	.9687
7/64	.1094	15/64	.2344	23/64	.3594	31/64	.4844	39/64	.6094	47/64	.7344	55/64	.8594	63/64	.9844
1/8	.1250	1/4	.2500	3/8	.3750	1/2	.5000	5/8	.6250	3/4	.7500	7/8	.8750		1.000