



TOOL SERVICE CORPORATION

DECIMAL EQUIVALENTS

DRILL SIZE	DECIMAL INCHES	DRILL SIZE	DECIMAL INCHES	DRILL SIZE	DECIMAL INCHES	DRILL SIZE	DECIMAL INCHES	DRILL SIZE	DECIMAL INCHES	DRILL SIZE	DECIMAL INCHES
0.10mm	.0039	1.25mm	.0492	3.00mm	.1160	5.40mm	.2126	Q	.3320	9/16	.5625
0.20mm	.0079	1.30mm	.0512	3.00mm	.1181	5.40mm	.2130	8.50mm	.3346	14.50mm	.5709
0.30mm	.0118	1.35mm	.0520	3.10mm	.1200	5.50mm	.2165	8.60mm	.3386	14.75mm	.5807
0.32mm	.0126	1.35mm	.0531	3.10mm	.1220	5.50mm	.2188	R	.3390	15.00mm	.5906
0.35mm	.0135	1.40mm	.0550	3.10mm	.1250	5.60mm	.2205	8.70mm	.3425	15.00mm	.5938
0.35mm	.0138	1.40mm	.0551	3.20mm	.1260	5.60mm	.2210	11/32	.3438	15.25mm	.6004
0.38mm	.0145	1.45mm	.0571	3.30mm	.1285	5.70mm	.2244	S	.3480	15.50mm	.6102
0.38mm	.0150	1.50mm	.0591	3.30mm	.1299	5.70mm	.2280	9.00mm	.3504	15.75mm	.6201
1/64	.0156	1.50mm	.0595	3.40mm	.1339	5.80mm	.2283	9.00mm	.3543	16.00mm	.6299
0.40mm	.0157	1.55mm	.0610	3.40mm	.1360	5.90mm	.2323	T	.3580	16.25mm	.6398
0.42mm	.0160	1.60mm	.0625	3.50mm	.1378	A	.2340	9.10mm	.3583	16.50mm	.6496
0.45mm	.0165	1.60mm	.0630	3.50mm	.1405	15/64	.2344	9.20mm	.3622	16.50mm	.6562
0.45mm	.0177	1.60mm	.0635	3.60mm	.1406	B	.2362	9.30mm	.3661	16.75mm	.6693
0.48mm	.0180	1.65mm	.0650	3.60mm	.1417	C	.2380	9.40mm	.3680	17.00mm	.6719
0.50mm	.0189	1.70mm	.0669	3.70mm	.1440	D	.2402	9.50mm	.3740	17.25mm	.6791
0.50mm	.0197	1.75mm	.0670	3.70mm	.1457	E	.2420	9.60mm	.3750	17.50mm	.6875
0.55mm	.0200	1.75mm	.0689	3.80mm	.1470	1/4	.2480	9.70mm	.3770	17.50mm	.6890
0.55mm	.0210	1.80mm	.0709	3.80mm	.1495	6.30mm	.2480	9.80mm	.3858	18.00mm	.7087
0.55mm	.0217	1.85mm	.0728	3.80mm	.1496	6.30mm	.2500	9.90mm	.3888	18.00mm	.7188
0.60mm	.0225	1.85mm	.0728	3.90mm	.1520	6.40mm	.2500	10.00mm	.3906	18.50mm	.7283
0.60mm	.0236	1.90mm	.0730	3.90mm	.1535	6.50mm	.2559	10.00mm	.3937	19.00mm	.7480
0.62mm	.0244	1.90mm	.0748	3.90mm	.1540	6.50mm	.2570	X	.3970	19.00mm	.7500
0.62mm	.0244	1.95mm	.0760	4.00mm	.1562	F	.2570	10.20mm	.4016	19.50mm	.7656
0.65mm	.0250	1.95mm	.0768	4.00mm	.1570	G	.2598	10.20mm	.4062	19.50mm	.7677
0.65mm	.0256	5/64	.0781	4.00mm	.1575	6.60mm	.2598	13/32	.4130	20.00mm	.7812
0.70mm	.0260	2.00mm	.0785	4.00mm	.1590	6.70mm	.2638	10.50mm	.4134	20.00mm	.7874
0.70mm	.0276	2.05mm	.0787	4.10mm	.1610	17/64	.2656	10.50mm	.4219	20.00mm	.7969
0.75mm	.0280	2.05mm	.0807	4.10mm	.1614	H	.2660	10.80mm	.4252	20.50mm	.8071
0.75mm	.0292	2.10mm	.0810	4.20mm	.1654	6.80mm	.2677	11.00mm	.4331	21.00mm	.8125
0.75mm	.0295	2.10mm	.0820	4.20mm	.1654	6.90mm	.2717	11.00mm	.4375	21.00mm	.8268
1/32	.0310	2.15mm	.0827	4.30mm	.1660	6.90mm	.2717	11.20mm	.4409	21.00mm	.8281
0.80mm	.0312	2.15mm	.0846	4.30mm	.1693	I	.2720	11.50mm	.4528	21.50mm	.8438
0.80mm	.0315	2.20mm	.0860	4.30mm	.1695	7.00mm	.2756	11.50mm	.4531	21.50mm	.8465
0.80mm	.0320	2.20mm	.0866	4.40mm	.1719	J	.2770	11.80mm	.4646	22.00mm	.8661
0.85mm	.0330	2.25mm	.0886	4.40mm	.1732	7.10mm	.2795	11.80mm	.4688	22.00mm	.8694
0.85mm	.0335	2.30mm	.0890	4.50mm	.1770	K	.2810	12.00mm	.4724	22.50mm	.8858
0.90mm	.0350	2.30mm	.0906	4.50mm	.1772	9/32	.2812	12.00mm	.4724	22.50mm	.8896
0.90mm	.0354	2.35mm	.0925	4.50mm	.1800	7.20mm	.2835	12.20mm	.4803	23.00mm	.9055
0.90mm	.0360	2.35mm	.0925	4.60mm	.1811	7.30mm	.2874	12.20mm	.4844	23.00mm	.9062
0.95mm	.0370	2.40mm	.0938	4.60mm	.1820	L	.2900	12.50mm	.4921	23.50mm	.9219
0.95mm	.0374	3/32	.0945	4.70mm	.1850	7.40mm	.2913	12.50mm	.4921	23.50mm	.9252
0.95mm	.0380	2.40mm	.0960	4.70mm	.1875	M	.2950	13.00mm	.5039	24.00mm	.9375
1.00mm	.0390	2.45mm	.0965	4.80mm	.1890	7.50mm	.2953	13.00mm	.5039	24.00mm	.9449
1.00mm	.0394	2.45mm	.0984	4.80mm	.1910	19/64	.2969	13.20mm	.5197	24.50mm	.9646
1.00mm	.0400	2.50mm	.0984	4.90mm	.1929	7.60mm	.2992	13.20mm	.5212	24.50mm	.9688
1.05mm	.0410	2.50mm	.0995	4.90mm	.1935	N	.3020	13.50mm	.5315	25.00mm	.9843
1.05mm	.0413	2.60mm	.1015	5.00mm	.1960	7.70mm	.3031	13.50mm	.5315	25.00mm	.9844
1.05mm	.0420	2.60mm	.1024	5.00mm	.1969	7.80mm	.3071	14.00mm	.5512	1"	1.0000
1.05mm	.0430	2.60mm	.1040	5.00mm	.1990	7.90mm	.3110	14.25mm	.5610		
1.10mm	.0433	2.70mm	.1063	5.10mm	.2008	5/16	.3125				
1.15mm	.0453	2.70mm	.1065	5.10mm	.2010	O	.3160				
1.15mm	.0465	7/64	.1094	5.20mm	.2031	8.10mm	.3189				
3/64	.0469	2.80mm	.1100	5.20mm	.2040	8.20mm	.3228				
1.20mm	.0472	2.80mm	.1102	5.30mm	.2055	P	.3230				
		2.90mm	.1130	5.30mm	.2087	8.30mm	.3268				
			.1142	5.30mm	.2090	21/64	.3281				
				4	.2090	8.40mm	.3307				

METRIC - RED

FRACTIONAL - GREEN

WIRE GAGE - PURPLE

LETTER SIZE - BLUE

STANDARD & ROLLFORM TAP & DRILL

TAP SIZE	DRILL SIZE	ROLL FORM	TAP SIZE	DRILL SIZE	ROLL FORM	TAP SIZE	DRILL SIZE	ROLL FORM
0 - 80	3/64	54	M5 x .8	4.2mm	14	5/8 - 18	37/64	19/32 / 15.25mm
M1.6 x .35	1.25mm	1.45mm	12 - 24	16	8 / 5mm	M16 - 2	35/64 / 14mm	19/32
1 - 64	53	51 / 1.65mm	12 - 28	15	7	M16 x 1.5	14.5mm	15.25mm
1 - 72	53	51 / 1.7mm	M6 x 1	10 / 5mm	7/32 / 5.5mm	M18 x 2.5	15.5mm	39/64
M2 x .4	1.6mm	1.80mm	1/4 - 20	7	1	M18 x 1.5	16.5mm	17.25mm
2 - 56	51	5/64	1/4 - 28	3	A / 15/64	3/4 - 10	21/32	45/64
2 - 64	50	47 / 2mm	M7 x 1	6mm	F	3/4 - 16	11/16	23/32
M2.5 x .45	2.05mm	2.30mm	5/16 - 18	F	L / 7.3mm	M20 X 2.5	11/16 / 17.5mm	
3 - 48	47 / 5/64	43	5/16 - 24	I	M	M20 x 1.5	18.5mm	18.75mm
3 - 56	46	2.3mm	M8 x 1.25	6.75mm	7.4mm	7/8 - 9	49/64	.8230
4 - 40	43	38	M8 x 1.0	7mm	19/64	7/8 - 14	13/16	27/32
4 - 48	42	2.6mm	3/8 - 16	5/16	S	M24 X 3	53/64 / 21mm	
M3 x .5	40 / 2.5mm	7/64	3/8 - 24	Q	T	1 - 8	7/8	15/16
5 - 40	38	33	M10 X 1.5	8.5mm	U / 9.3mm	1 - 12	59/64	.9630
5 - 44	37	2.9mm	M10 x 1.25	8.7mm	9.4mm	1 - 14	15/16	
M3.5 x .6	33 / 2.9mm	30 / 3.20mm	7/16 - 14	U	Y / 13/32	1-1/8 - 7	63/64	
6 - 32	36	1/8	7/16 - 20	25/64	Z / 10.5mm	1/18 - 12	1-3/64	
6 - 40	33	3.25mm	M12 X 1.75	13/32 / 10.20mm	11.2mm	M30 X 3.5	1-3/64 / 26.5mm	
M4 x .7	3.30mm	3.7mm	1/2 - 13	27/64	15/32	1-1/4 - 7	1-7/64	
8 - 32	29	25	1/2 - 20	29/64	12.25mm	1-1/4 - 12	1-11/64	
8 - 36	29	24	M14 X 2	15/32 / 12mm	33/64	1-3/8 - 6	1-7/32	
M4.5 x .75	3.75mm	4.10mm	M14 x 1.5	12.5mm	13mm	1-3/8 - 12	1-19/64	
10 - 24	26	11/64	9/16 - 12	31/64	17/32	M36 X 4	1-1/4 / 32mm	
10 - 32	21	16	9/16 - 18	33/64	13.5mm	1-1/2 - 6	1-11/32	
			5/8 - 11	17/32	14.75mm	1-1/2 - 12	1-27/64	

PIPE TAPS-NPT, NPTF, NPSM, NPSC, NPSF

Nominal Pipe	NPT & NPTF w/o Reamer	NPTF w/Reamer	NPSM	NPSC	NPSF
1/16 - 27	C (.242)	A (.234)	-	.250	D (.246)
1/8 - 27	Q (.332)	21/64	T (.358)	Q (.332)	R (.339)
1/4 - 18	7/16	27/64	15/32	7/16	7/16
3/8 - 18	9/16	9/16	-	37/64	37/64
1/2 - 14	45/64	11/16	19.0mm	45/64	45/64
3/4 - 14	29/32	57/64	61/64	59/64	59/64
1 - 11-1/2	1-9/64	1-1/8	1-13/64	1-5/32	1-5/32
1-1/4 - 11-1/2	1-31/64	1-15/32	1-35/64	1-1/2	-
1-1/2 - 11-1/2	1-23/32	1-45/64	1-25/32	1-47/64	-
2 - 11-1/2	2-3/16	2-11/64	2-1/4	2-13/64	-

HELICOIL TAP & DRILL

TAP SIZE	DRILL SIZE	TAP SIZE	DRILL SIZE
2 - 56	3/32	1/4 - 20	7/64
3 - 48	33	1/4 - 28	G
4 - 40	31	5/16 - 18	Q
4 - 48	30	5/16 - 24	21/64
5 - 40	30	3/8 - 16	X
6 - 32	25	3/8 - 24	25/64
6 - 40	26	7/16 - 14	29/64
8 - 32	17	7/16 - 20	29/64
10 - 24	13/64	1/2 - 13	33/64
10 - 32	7	1/2 - 20	33/64
12 - 24	2		

NOTE: Drill size recommendations are for approximately 70-75% thread height. Because drills make a hole slightly larger than their nominal size, the size obtained will depend on drill manufacturer, style, machine, drilling conditions, fixturing and coating chosen.



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