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## TAPPING HEADS .....

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# Tap Drill Sizes

Probable percentage of full thread produced in tapped hole using stock sizes of drill.

| TAP                                  | TAP<br>DRILL | DECIMAL<br>EQUIV. | THEO. %<br>OF THRD. | PROBABLE<br>OVERSIZE | PROBABLE<br>HOLE SIZE | % OF<br>THIRD                                   | TAP      | TAP<br>DRILL | DECIMAL<br>EQUIV. | THEO. %<br>OF THRD. | PROBABLE<br>OVERSIZE   | PROBABLE<br>HOLE SIZE | % OF<br>THIRD |      |       |       |       |        |         |         |        |         |         |  |  |
|--------------------------------------|--------------|-------------------|---------------------|----------------------|-----------------------|-------------------------------------------------|----------|--------------|-------------------|---------------------|------------------------|-----------------------|---------------|------|-------|-------|-------|--------|---------|---------|--------|---------|---------|--|--|
| 0-80                                 | 56           | .0465             | 83                  | .0015                | .0480                 | 74                                              |          | 8            | .1990             | 79                  | .0038                  | .2028                 | 73            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 3/64         | .0469             | 81                  | .0015                | .0484                 | 71                                              |          | 7            | .2010             | 75                  | .0038                  | .2048                 | 70            |      |       |       |       |        |         |         |        |         |         |  |  |
| 1-64                                 | 54           | .0550             | 89                  | .0015                | .0565                 | 81                                              |          | 13/64        | .2031             | 72                  | .0038                  | .2069                 | 66            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 53           | .0595             | 67                  | .0015                | .0610                 | 59                                              | 1/4-28   | 3            | .2130             | 80                  | .0038                  | .2168                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
| 1-72                                 | 53           | .0595             | 75                  | .0015                | .0610                 | 67                                              | 5/16-18  | F            | .2570             | 77                  | .0038                  | .2608                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 1/16         | .0625             | 58                  | .0015                | .0640                 | 50                                              |          | G            | .2610             | 71                  | .0041                  | .2651                 | 66            |      |       |       |       |        |         |         |        |         |         |  |  |
| 2-56                                 | 51           | .0670             | 82                  | .0017                | .0687                 | 74                                              | 5/16-24  | H            | .2660             | 86                  | .0041                  | .2701                 | 78            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 50           | .0700             | 69                  | .0017                | .0717                 | 62                                              |          | I            | .2720             | 75                  | .0041                  | .2761                 | 67            |      |       |       |       |        |         |         |        |         |         |  |  |
| 2-64                                 | 50           | .0700             | 79                  | .0017                | .0717                 | 70                                              | 3/8-16   | 5/16         | .3125             | 77                  | .0044                  | .3169                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 49           | .0730             | 64                  | .0017                | .0747                 | 56                                              |          | O            | .3160             | 73                  | .0044                  | .3204                 | 68            |      |       |       |       |        |         |         |        |         |         |  |  |
| 3-48                                 | 48           | .0760             | 85                  | .0019                | .0779                 | 78                                              | 3/8-24   | 21/64        | .3281             | 87                  | .0044                  | .3325                 | 79            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 5/64         | .0781             | 77                  | .0019                | .0800                 | 70                                              |          | Q            | .3320             | 79                  | .0044                  | .3364                 | 71            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 47           | .0785             | 76                  | .0019                | .0804                 | 69                                              | 7/16-14  | T            | .3580             | 86                  | .0046                  | .3626                 | 81            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 46           | .0810             | 67                  | .0019                | .0829                 | 60                                              |          | 23/64        | .3594             | 84                  | .0046                  | .3640                 | 79            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 45           | .0820             | 63                  | .0019                | .0839                 | 56                                              |          | U            | .3680             | 75                  | .0046                  | .3726                 | 70            |      |       |       |       |        |         |         |        |         |         |  |  |
| 3-56                                 | 46           | .0810             | 78                  | .0019                | .0829                 | 69                                              | 7/16-20  | W            | .3860             | 79                  | .0046                  | .3906                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 45           | .0820             | 73                  | .0019                | .0839                 | 65                                              |          | 25/64        | .3906             | 72                  | .0046                  | .3952                 | 65            |      |       |       |       |        |         |         |        |         |         |  |  |
| 4-40                                 | 44           | .0860             | 80                  | .0020                | .0880                 | 74                                              | 1/2-13   | 27/64        | .4219             | 78                  | .0047                  | .4266                 | 73            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 43           | .0890             | 71                  | .0020                | .0910                 | 65                                              | 1/2-20   | 29/64        | .4531             | 72                  | .0047                  | .4578                 | 65            |      |       |       |       |        |         |         |        |         |         |  |  |
| 4-48                                 | 42           | .0935             | 68                  | .0020                | .0955                 | 61                                              | 9/16-12  | 15/32        | .4688             | 87                  | .0048                  | .4736                 | 82            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 3/32         | .0938             | 68                  | .0020                | .0958                 | 60                                              |          | 31/64        | .4844             | 72                  | .0048                  | .4892                 | 68            |      |       |       |       |        |         |         |        |         |         |  |  |
| 5-40                                 | 40           | .0980             | 83                  | .0023                | .1003                 | 76                                              | 9/16-18  | 1/2          | .500              | 87                  | .0048                  | .5048                 | 80            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 39           | .0995             | 79                  | .0023                | .1018                 | 71                                              | 5/8-11   | 17/32        | .5313             | 79                  | .0049                  | .5362                 | 75            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 38           | .1015             | 72                  | .0023                | .1038                 | 65                                              | 5/8-18   | 9/16         | .5625             | 87                  | .0049                  | .5674                 | 80            |      |       |       |       |        |         |         |        |         |         |  |  |
| 5-44                                 | 38           | .1015             | 79                  | .0023                | .1038                 | 72                                              | 3/4-10   | 41/64        | .6406             | 84                  | .0050                  | .6456                 | 82            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 37           | .1040             | 71                  | .0023                | .1063                 | 63                                              |          | 21/32        | .6563             | 72                  | .0050                  | .6613                 | 68            |      |       |       |       |        |         |         |        |         |         |  |  |
| 6-32                                 | 37           | .1040             | 84                  | .0023                | .1063                 | 78                                              | 3/4-16   | 11/16        | .6875             | 77                  | .0050                  | .6925                 | 71            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 36           | .1065             | 78                  | .0023                | .1088                 | 72                                              |          | 49/64        | .7656             | 76                  | .0052                  | .7708                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 7/64         | .1094             | 70                  | .0023                | .1120                 | 64                                              | 7/8-9    | 51/64        | .7969             | 84                  | .0052                  | .8021                 | 79            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 35           | .1100             | 69                  | .0026                | .1126                 | 63                                              | 1-8      | 55/64        | .8594             | 87                  | .0059                  | .8653                 | 83            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 34           | .1110             | 67                  | .0026                | .1136                 | 60                                              |          | 7/8          | .875              | 77                  | .0059                  | .8809                 | 73            |      |       |       |       |        |         |         |        |         |         |  |  |
| 6-40                                 | 34           | .1110             | 83                  | .0026                | .1136                 | 75                                              | 1-12     | 29/32        | .9063             | 87                  | .0059                  | .9122                 | 81            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 33           | .1130             | 77                  | .0026                | .1156                 | 69                                              |          | 59/64        | .9219             | 72                  | .0060                  | .9279                 | 67            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 32           | .1160             | 68                  | .0026                | .1186                 | 60                                              | 1-14     | 59/64        | .9219             | 84                  | .0060                  | .9279                 | 78            |      |       |       |       |        |         |         |        |         |         |  |  |
| 8-32                                 | 29           | .1360             | 69                  | .0029                | .1389                 | 62                                              | 1-1/8-7  | 31/32        | .9688             | 84                  | .0062                  | .9750                 | 81            |      |       |       |       |        |         |         |        |         |         |  |  |
| 8-36                                 | 29           | .1360             | 78                  | .0029                | .1389                 | 70                                              |          | 63/64        | .9844             | 76                  | .0067                  | .9911                 | 72            |      |       |       |       |        |         |         |        |         |         |  |  |
| 10-24                                | 27           | .1140             | 85                  | .0032                | .1472                 | 79                                              |          | 1-1/64       | 1.0156            | 59                  | .0070                  | 1.0226                | 55            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 26           | .1470             | 79                  | .0032                | .1502                 | 74                                              | 1-1/8-12 | 1-1/32       | 1.0313            | 87                  | .0071                  | 1.0384                | 80            |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 25           | .1495             | 75                  | .0032                | .1527                 | 69                                              | 1-1/4-7  | 1-3/32       | 1.0938            | 84                  | REAMING<br>RECOMMENDED |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 24           | .1520             | 70                  | .0032                | .1152                 | 64                                              |          | 1-7/64       | 1.1094            | 76                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
| 10-32                                | 5/32         | .1653             | 83                  | .0032                | .1595                 | 75                                              | 1-1/4-12 | 1-11/64      | 1.1719            | 72                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 22           | .1570             | 81                  | .0032                | .1602                 | 73                                              | 1-3/8-6  | 1-13/64      | 1.2031            | 79                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 21           | .1590             | 76                  | .0032                | .1622                 | 68                                              |          | 1-7/32       | 1.2188            | 72                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
| 12-24                                | 11/64        | .1719             | 82                  | .0035                | .1754                 | 75                                              | 1-3/8-12 | 1-19/64      | 1.2969            | 72                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 17           | .1730             | 79                  | .0035                | .1765                 | 73                                              | 1-1/2-6  | 1-21/64      | 1.3281            | 79                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 16           | .1770             | 72                  | .0035                | .1805                 | 66                                              |          | 1-11/32      | 1.3438            | 72                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
| 12-28                                | 16           | .1770             | 84                  | .0035                | .1805                 | 77                                              | 1-1/2-12 | 1-27/64      | 1.4219            | 72                  |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
|                                      | 15           | .1800             | 78                  | .0035                | .1835                 | 70                                              |          |              |                   |                     |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
| 1/4-20                               | 9            | .1960             | 83                  | .0038                | .1998                 | 77                                              |          |              |                   |                     |                        |                       |               |      |       |       |       |        |         |         |        |         |         |  |  |
| SUGGESTED<br>PIPE TAP<br>DRILL SIZES |              |                   |                     |                      |                       | TAP SIZE<br>TAPER PIPE TAP<br>STRAIGHT PIPE TAP |          |              |                   |                     |                        | 1/16                  | 1/8           | 1/4  | 3/8   | 1/2   | 3/4   | 1      | 1-1/4   | 1-1/2   | 2      | 2-1/2   | 3       |  |  |
|                                      |              |                   |                     |                      |                       |                                                 |          |              |                   |                     |                        | C                     | Q             | 7/16 | 9/16  | 45/64 | 29/32 | 1-9/64 | 1-31/64 | 1-23/32 | 2-3/16 | 2-39/64 | 3-15/64 |  |  |
|                                      |              |                   |                     |                      |                       |                                                 |          |              |                   |                     |                        | 1/4                   | 11/32         | 7/16 | 37/64 | 23/32 | 59/64 | 1-5/32 | 1-1/2   | 1-3/4   | 2-7/32 | 2-21/32 |         |  |  |

\* For dryseal straight pipe threads, suggest drill size as shown, except 1/4" pipe, .444 drill size. 578

No Liability is assumed resulting from the use of the information contained herein.

# Thread Forming Tap Drill Sizes

| TAP SIZE | T.P.I<br>NC<br>NF | 75% THREAD NEAREST    |               |                   | 65% THREAD NEAREST    |               |                   | 55% THREAD NEAREST    |               |                   |
|----------|-------------------|-----------------------|---------------|-------------------|-----------------------|---------------|-------------------|-----------------------|---------------|-------------------|
|          |                   | THEO.<br>HOLE<br>SIZE | DRILL<br>SIZE | DECIMAL<br>EQUIV. | THEO.<br>HOLE<br>SIZE | DRILL<br>SIZE | DECIMAL<br>EQUIV. | THEO.<br>HOLE<br>SIZE | DRILL<br>SIZE | DECIMAL<br>EQUIV. |
| 0        | 80                | .0536                 | 1.35mm        | .0531             | .0545                 | 54            | .0550             | .0553                 | 54            | .0500             |
| 1        | 64                | .0650                 | 1.65mm        | .0650             | .0661                 | 1.65mm        | .0650             | .0672                 | 51            | .0670             |
|          | 72                | .0659                 | 1.65mm        | .0650             | .0669                 | 1.7mm         | .0669             | .0678                 | 51            | .0670             |
| 2        | 56                | .0769                 | 1.95mm        | .0768             | .0781                 | 5/64          | .0781             | .0793                 | 2mm           | .0787             |
|          | 64                | .0780                 | 5/64          | .0781             | .0791                 | 2mm           | .0787             | .0802                 | 2.05mm        | .0807             |
| 3        | 48                | .0884                 | 2.25mm        | .0886             | .0898                 | 43            | .0890             | .0912                 | 2.3mm         | .0906             |
|          | 56                | .0899                 | 43            | .0890             | .0911                 | 2.3mm         | .0906             | .0923                 | 2.35mm        | .0925             |
| 4        | 40                | .0992                 | 39            | .0995             | .1009                 | 39            | .0995             | .1026                 | 2.6mm         | .1024             |
|          | 48                | .1014                 | 38            | .1015             | .1028                 | 2.6mm         | .1024             | .1042                 | 28            | .1045             |
| 5        | 40                | .1122                 | 34            | .1100             | .1139                 | 33            | .1130             | .1156                 | 32            | .1160             |
|          | 44                | .1134                 | 33            | .1130             | .1150                 | 2.9mm         | .1142             | .1165                 | 32            | .1160             |
| 6        | 32                | .1221                 | 3.10mm        | .1220             | .1242                 | 1/8           | .1250             | .1263                 | 3.2mm         | .1260             |
|          | 40                | .1252                 | 1/8           | .1250             | .1269                 | 3.2mm         | .1260             | .1288                 | 30            | .1285             |
| 8        | 32                | .1481                 | 3.75mm        | .1476             | .1502                 | 3.8mm         | .1496             | .1523                 | 24            | .1520             |
|          | 36                | .1498                 | 25            | .1495             | .1517                 | 24            | .1520             | .1536                 | 3.9mm         | .1535             |
| 10       | 24                | .1687                 | 4.3mm         | .1693             | .1716                 | 11/64         | .1719             | .1744                 | 17            | .1730             |
|          | 32                | .1741                 | 4.4mm         | .1732             | .1762                 | 16            | .1770             | .1783                 | 15            | .1800             |
| 12       | 24                | .1947                 | 10            | .1935             | .1976                 | 5mm           | .1968             | .2004                 | 5.1mm         | .2008             |
|          | 28                | .1978                 | 5mm           | .1968             | .2002                 | 8             | .1990             | .2026                 | 13/64         | .2031             |
| 1/4      | 20                | .2245                 | 5.7mm         | .2244             | .2279                 | 1             | .2280             | .2313                 | 5.9mm         | .2323             |
|          | 28                | .2318                 | 5.8mm         | .2323             | .2342                 | A             | .2340             | .2366                 | 6mm           | .2362             |
| 5/16     | 18                | .2842                 | 7.2mm         | .2835             | .2879                 | 7.3mm         | .2874             | .2917                 | 7.4mm         | .2913             |
|          | 24                | .2912                 | 7.4mm         | .2913             | .2941                 | M             | .2950             | .2969                 | 19/64         | .2969             |
| 3/8      | 16                | .3431                 | 8.7mm         | .3425             | .3474                 | S             | .3480             | .3516                 | 8.9mm         | .3504             |
|          | 24                | .3537                 | 9mm           | .3543             | .3566                 | 9mm           | .3543             | .3594                 | 23/64         | .3594             |
| 7/16     | 14                | .4011                 | X             | .3970             | .4059                 | Y             | .4040             | .4108                 | 13/32         | .4062             |
|          | 20                | .4120                 | Z             | .4130             | .4154                 | 10.5mm        | .4134             | .4188                 | —             | —                 |
| 1/2      | 13                | .4608                 | —             | —                 | .4660                 | —             | —                 | .4712                 | 15/32         | .4688             |
|          | 20                | .4745                 | 12mm          | .4724             | .4779                 | —             | —                 | .4813                 | —             | —                 |
| 9/16     | 12                | .5200                 | 33/64         | .5156             | .5257                 | —             | —                 | .5313                 | 17/32         | .5312             |
|          | 18                | .5342                 | 13.5mm        | .5315             | .5379                 | —             | —                 | .5417                 | —             | —                 |
| 5/8      | 11                | .5786                 | 37/64         | .5781             | .5848                 | —             | —                 | .5910                 | 15mm          | .5906             |
|          | 18                | .5967                 | 19/32         | .5938             | .6004                 | —             | —                 | .6042                 | —             | —                 |
| 3/4      | 10                | .6990                 | —             | —                 | .7058                 | 45/64         | .7031             | .7126                 | —             | —                 |
|          | 16                | .7181                 | 23/32         | .7188             | .7224                 | —             | —                 | .7266                 | —             | —                 |

## Tap Drill Sizes– Metric

| NOMINAL SIZE | PITCH | TAP DRILL SIZE | DEC. EQUIV. | THEO. % OF THIRD | PROB. OVER. INCHES | PROB. HOLE SIZE | PROB. % OF THIRD | NOMINAL SIZE | PITCH | TAP DRILL SIZE | DECIMAL EQUIV. | THEO. % OF THIRD | PROB. OVER. INCHES  | PROB. HOLE SIZE | PROB. % OF THIRD |
|--------------|-------|----------------|-------------|------------------|--------------------|-----------------|------------------|--------------|-------|----------------|----------------|------------------|---------------------|-----------------|------------------|
| MM           | MM    | MM             |             |                  |                    | MM              |                  | MM           | MM    | MM             |                |                  |                     | MM              |                  |
| 1.6          | .035  | 1.20mm         | .0472       | 88               | .0014              | .0486           | 80               | 7            | 1     | "A"            | .2340          | 81               | .0038               | .2378           | 74               |
|              |       | 1.25mm         | .0492       | 77               | .0014              | .0506           | 69               |              |       | 6mm            | .2362          | 77               | .0038               | .2400           | 70               |
| 2            | 0.4   | 1/16           | .0625       | 79               | .0015              | .0640           | 72               | 8            | 1.25  | "B"            | .2380          | 74               | .0038               | .2418           | 66               |
|              |       | 1.60mm         | .0630       | 77               | .0017              | .0647           | 69               |              |       | 6.7mm          | .2638          | 80               | .0041               | .2679           | 74               |
|              |       | #52            | .0635       | 74               | .0017              | .0652           | 66               |              |       | 17/64          | .2656          | 77               | .0041               | .2697           | 71               |
| 2.5          | 0.45  | 2.05mm         | .0807       | 77               | .0019              | .0826           | 69               | 10           | 1.5   | "H"            | .2660          | 77               | .0041               | .2701           | 70               |
|              |       | #46            | .0810       | 76               | .0019              | .0829           | 67               |              |       | 6.8mm          | .2677          | 74               | .0041               | .2718           | 68               |
|              |       | #45            | .0820       | 71               | .0019              | .0839           | 63               |              |       | 8.4mm          | .3307          | 82               | .0044               | .3351           | 76               |
| 3            | 0.5   | #40            | .0980       | 79               | .0023              | .1003           | 70               | 12           | 1.75  | "Q"            | .3320          | 80               | .0044               | .3364           | 75               |
|              |       | 2.5mm          | .0984       | 77               | .0023              | .1007           | 68               |              |       | 8.5mm          | .3346          | 77               | .0044               | .3390           | 71               |
|              |       | #39            | .0995       | 73               | .0023              | .1018           | 64               |              |       | 10.25mm        | .2035          | 77               | .0047               | .4082           | 72               |
| 3.5          | 0.6   | #33            | .1130       | 81               | .0026              | .1156           | 72               | 14           | 2     | "Y"            | .4040          | 76               | .0047               | .4087           | 71               |
|              |       | 2.9mm          | .1142       | 77               | .0026              | .1168           | 68               |              |       | 13/32          | .4062          | 74               | .0047               | .4109           | 69               |
|              |       | #32            | .1160       | 71               | .0026              | .1186           | 63               |              |       | 15/32          | .4688          | 81               | .0048               | .4736           | 76               |
| 4            | 0.7   | 3.2mm          | .1280       | 82               | .0029              | .1309           | 74               | 16           | 2     | 12mm           | .4724          | 77               | .0048               | .4772           | 72               |
|              |       | #30            | .1285       | 81               | .0029              | .1314           | 73               |              |       | 35/64          | .5469          | 81               | .0049               | .5518           | 76               |
|              |       | 3.3mm          | .1299       | 77               | .0029              | .1328           | 69               |              |       | 14mm           | .5512          | 77               | .0049               | .5561           | 72               |
| 4.5          | 0.75  | 3.7mm          | .1457       | 82               | .0032              | .1489           | 74               | 20           | 2.5   | 11/16          | .6875          | 78               | .0050               | .6925           | 74               |
|              |       | #26            | .1470       | 79               | .0032              | .1502           | 70               |              |       | 17.5mm         | .6890          | 77               | .0052               | .6942           | 73               |
|              |       | #25            | .1495       | 72               | .0032              | .1527           | 64               |              |       | 13/16          | .8125          | 86               | .0052               | .8177           | 82               |
| 5            | .08   | 4.2mm          | .1654       | 77               | .0032              | .1686           | 69               | 24           | 3     | 21mm           | .8268          | 77               | .0059               | .8327           | 73               |
|              |       | #19            | .1660       | 75               | .0032              | .1692           | 68               |              |       | 53/64          | .8281          | 76               | .0059               | .8340           | 72               |
| 6            | 1     | #10            | .1935       | 84               | .0038              | .1973           | 76               | 30           | 3.5   | 1-1/32         | 1.0312         | 83               | .0071               | 1.0383          | 80               |
|              |       | #9             | .1960       | 79               | .0038              | .1998           | 71               |              |       | 26.5mm         | 1.0433         | 77               | .0071               | 1.0504          | 73               |
|              |       | 5mm            | .1968       | 77               | .0038              | .2006           | 70               |              |       | 1-3/64         | 1.0469         | 75               | .0072               | 1.0541          | 70               |
|              |       | #8             | .1990       | 73               | .0038              | .2028           | 65               |              |       | 1-17/64        | 1.2656         | 74               | REAMING RECOMMENDED |                 |                  |

No Liability is assumed resulting from the use of the information contained herein.

# DECIMAL EQUIVALENTS

| SIZES | DECIMAL INCHES | SIZES  | DECIMAL INCHES | SIZES  | DECIMAL INCHES | SIZES  | DECIMAL INCHES | SIZES  | DECIMAL INCHES | SIZES  | DECIMAL INCHES |
|-------|----------------|--------|----------------|--------|----------------|--------|----------------|--------|----------------|--------|----------------|
| 97    | .0059          | 57     | .0430          | 2.9mm  | .1142          | 5.3mm  | .2087          | 8.3mm  | .3268          | 41/64  | .6406          |
| 96    | .0063          | 1.1mm  | .0433          | 32     | .1160          | 4      | .2090          | 21/64  | .3281          | 16.5mm | .6496          |
| 95    | .0067          | 1.15mm | .0453          | 3mm    | .1181          | 5.4mm  | .2126          | 8.4mm  | .3307          | 21/32  | .6562          |
| 94    | .0071          | 56     | .0465          | 31     | .1200          | 3      | .2130          | 0      | .3320          | 17mm   | .6693          |
| 93    | .0075          | 3/64   | .0469          | 3.1mm  | .1220          | 5.5mm  | .2165          | 8.5mm  | .3346          | 43/64  | .6719          |
| 92    | .0079          | 1.2mm  | .0472          | 1/8    | .1250          | 7/32   | .2188          | 8.6mm  | .3386          | 11/16  | .6875          |
| .2mm  | .0079          | 1.25mm | .0492          | 3.2mm  | .1260          | 5.6mm  | .2205          | R      | .3390          | 17.5mm | .6890          |
| 91    | .0083          | 1.3mm  | .0512          | 3.25mm | .1280          | 2      | .2210          | 8.7mm  | .3425          | 45/64  | .7031          |
| 90    | .0087          | 55     | .0520          | 30     | .1285          | 5.7mm  | .2244          | 11/32  | .3438          | 18mm   | .7087          |
| .22mm | .0087          | 1.35mm | .0531          | 3.3mm  | .1299          | 5.75mm | .2264          | 8.75mm | .3445          | 23/32  | .7188          |
| 89    | .0091          | 54     | .0550          | 3.4mm  | .1339          | 1      | .2280          | 8.8mm  | .3465          | 18.5mm | .7283          |
| 88    | .0095          | 1.4mm  | .0551          | 29     | .1360          | 5.8mm  | .2283          | S      | .3480          | 47/64  | .7344          |
| .25mm | .0098          | 1.45mm | .0571          | 3.5mm  | .1378          | 5.9mm  | .2323          | 8.9mm  | .3504          | 19mm   | .7480          |
| 87    | .0100          | 1.5mm  | .0591          | 28     | .1405          | A      | .2340          | 9mm    | .3543          | 3/4    | .7500          |
| 86    | .0105          | 53     | .0595          | 9/64   | .1406          | 15/64  | .2344          | T      | .3580          | 49/64  | .7656          |
| 85    | .0110          | 1.55mm | .0610          | 3.6mm  | .1417          | 6mm    | .2362          | 9.1mm  | .3583          | 19.5mm | .7677          |
| .28mm | .0110          | 1/16   | .0625          | 27     | .1440          | B      | .2380          | 23/64  | .3594          | 25/32  | .7812          |
| 84    | .0115          | 1.6mm  | .0630          | 3.7mm  | .1457          | 6.1mm  | .2402          | 9.2mm  | .3622          | 20mm   | .7874          |
| .3mm  | .0118          | 52     | .0635          | 26     | .1470          | C      | .2420          | 9.25mm | .3642          | 51/64  | .7969          |
| 83    | .0120          | 1.65mm | .0650          | 3.75mm | .1476          | 6.2mm  | .2441          | 9.3mm  | .3661          | 20.5mm | .8071          |
| 82    | .0125          | 1.7mm  | .0669          | 25     | .1495          | D      | .2460          | U      | .3680          | 13/16  | .8125          |
| .32mm | .0126          | 51     | .0670          | 3.8mm  | .1496          | 6.25mm | .2461          | 9.4mm  | .3701          | 21mm   | .8268          |
| 81    | .0130          | 1.75mm | .0689          | 24     | .1520          | 6.3mm  | .2480          | 9.5mm  | .3740          | 53/64  | .8281          |
| 80    | .0135          | 50     | .0700          | 3.9mm  | .1535          | E      | .2500          | 3/8    | .3750          | 27/32  | .8438          |
| .35mm | .0138          | 1.8mm  | .0709          | 23     | .1540          | 1/4    | .2500          | V      | .3770          | 21.5mm | .8465          |
| 79    | .0145          | 1.85mm | .0728          | 5/32   | .1562          | 6.4mm  | .2520          | 9.6mm  | .3780          | 55/64  | .8594          |
| 1/64  | .0156          | 49     | .0730          | 22     | .1570          | 6.5mm  | .2559          | 9.7mm  | .3819          | 22mm   | .8661          |
| .4mm  | .0157          | 1.9mm  | .0748          | 4mm    | .1575          | F      | .2570          | 9.75mm | .3839          | 7/8    | .8750          |
| 78    | .0160          | 48     | .0760          | 21     | .1590          | 6.6mm  | .2598          | 9.8mm  | .3858          | 22.5mm | .8858          |
| .45mm | .0177          | 1.95mm | .0768          | 20     | .1610          | G      | .2610          | W      | .3860          | 57/64  | .8906          |
| 77    | .0180          | 5/64   | .0781          | 4.1mm  | .1614          | 6.7mm  | .2638          | 9.9mm  | .3898          | 23mm   | .9055          |
| .5mm  | .0197          | 47     | .0785          | 4.2mm  | .1654          | 17/64  | .2656          | 25/64  | .3906          | 29/32  | .9062          |
| 76    | .0200          | 2mm    | .0787          | 19     | .1660          | 6.75mm | .2657          | 10mm   | .3937          | 59/64  | .9219          |
| 75    | .0210          | 2.05mm | .0807          | 4.25mm | .1673          | H      | .2660          | X      | .3970          | 23.5mm | .9252          |
| .55mm | .0217          | 46     | .0810          | 4.3mm  | .1693          | 6.8mm  | .2677          | Y      | .4040          | 15/16  | .9375          |
| 74    | .0225          | 45     | .0820          | 18     | .1695          | 6.9mm  | .2717          | 13/32  | .4062          | 24mm   | .9449          |
| .6mm  | .0236          | 2.1mm  | .0827          | 11/64  | .1719          | I      | .2720          | Z      | .4130          | 61/64  | .9531          |
| 73    | .0240          | 2.15mm | .0846          | 17     | .1730          | 7mm    | .2756          | 10.5mm | .4134          | 24.5mm | .9646          |
| 72    | .0250          | 44     | .0860          | 4.4mm  | .1732          | J      | .2770          | 27/64  | .4219          | 31/32  | .9688          |
| .65mm | .0256          | 2.2mm  | .0866          | 16     | .1770          | 7.1mm  | .2795          | 11mm   | .4331          | 25mm   | .9843          |
| 71    | .0260          | 2.25mm | .0886          | 4.5mm  | .1772          | K      | .2810          | 7/16   | .4375          | 63/64  | .9844          |
| .7mm  | .0276          | 43     | .0890          | 15     | .1800          | 9/32   | .2812          | 11.5mm | .4528          | 1      | 1.0000         |
| 70    | .0280          | 2.3mm  | .0906          | 4.6mm  | .1811          | 7.2mm  | .2835          | 29/64  | .4531          |        |                |
| 69    | .0292          | 2.35mm | .0925          | 14     | .1820          | 7.25mm | .2854          | 15/32  | .4688          |        |                |
| .75mm | .0295          | 42     | .0935          | 13     | .1850          | 7.3mm  | .2874          | 12mm   | .4724          |        |                |
| 68    | .0310          | 3/32   | .0938          | 4.7mm  | .1850          | L      | .2900          | 31/64  | .4844          |        |                |
| 1/32  | .0312          | 2.4mm  | .0945          | 4.75mm | .1870          | 7.4mm  | .2913          | 12.5mm | .4921          |        |                |
| .8mm  | .0315          | 41     | .0960          | 3/16   | .1875          | M      | .2950          | 1/2    | .5000          |        |                |
| 67    | .0320          | 2.45mm | .0965          | 4.8mm  | .1890          | 7.5mm  | .2953          | 13mm   | .5118          |        |                |
| 66    | .0330          | 40     | .0980          | 12     | .1890          | 19/64  | .2969          | 33/64  | .5156          |        |                |
| .85mm | .0335          | 2.5mm  | .0984          | 11     | .1910          | 7.6mm  | .2992          | 17/32  | .5312          |        |                |
| 65    | .0350          | 39     | .0995          | 4.9mm  | .1929          | N      | .3020          | 13.5mm | .5315          |        |                |
| .9mm  | .0354          | 38     | .1015          | 10     | .1935          | 7.7mm  | .3031          | 35/64  | .5469          |        |                |
| 64    | .0360          | 2.6mm  | .1024          | 9      | .1960          | 7.75mm | .3051          | 14mm   | .5512          |        |                |
| 63    | .0370          | 37     | .1040          | 5mm    | .1969          | 7.8mm  | .3071          | 9/16   | .5625          |        |                |
| .95mm | .0374          | 2.7mm  | .1063          | 8      | .1990          | 7.9mm  | .3110          | 14.5mm | .5709          |        |                |
| 62    | .0380          | 36     | .1065          | 5.     | .2008          | 5/16   | .3125          | 37/64  | .5781          |        |                |
| 61    | .0390          | 2.75mm | .1083          | 7      | .2010          | 8mm    | .3150          | 15mm   | .5906          |        |                |
| .00mm | .0394          | 7/64   | .1094          | 13/64  | .2031          | O      | .3160          | 19/32  | .5938          |        |                |
| 60    | .0400          | 35     | .1100          | 6      | .2040          | 8.1mm  | .3189          | 39/64  | .6094          |        |                |
| 59    | .0410          | 2.8mm  | .1102          | 5.2mm  | .2047          | 8.2mm  | .3228          | 15.5mm | .6102          |        |                |
| 1.05m | .0413          | 34     | .1110          | 5      | .2055          | P      | .3230          | 5/8    | .6250          |        |                |
| 58    | .0420          | 33     | .1130          | 5.25mm | .2067          | 8.25mm | .3248          | 16mm   | .6299          |        |                |

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## Notes