

## SCREW THREADS AND TAP DRILL SIZES

NC or A.S.M.E SPECIAL MACHINE SCREWS			
ze Tap	Thds. per Inch	Tap Drill	Body Drill
	64	53	47
2	56	50	42
3	48	47	37
4	40	43	31
5	40	38	29
6	32	36	27
8	32	29	18
0	24	25	9
2	24	16	2

NF or A.S.M.E. STANDARD MACHINE SCREWS			
Size of Tap	Thds. per Inch	Tap Drill	Body Drill
2	64	50	42
3	56	45	36
4	48	42	31
5	44	37	29
6	40	33	25
8	36	29	16
10	32	21	9
*10	30	22	9
12	28	14	2

\*A.S.M.E. only

NPT PIPE THREADS		
ze of Tap	Thds. per Inch	Tap Drill
1/8	27	R
1/4	18	7/16
3/8	18	37/64
1/2	14	23/32
3/4	14	59/64
1	11 1/2	15/32
1 1/4	11 1/2	1 1/2
1 1/2	11 1/2	1 47/64
2	11 1/2	27/32
2 1/2	8	2 1/4
3	8	3 1/4

NF OR S.A.E. STANDARD SCREWS		
Size of Tap	Thds. per Inch	Tap Drill
1/4	28	3
5/16	24	1
3/8	24	Q
7/16	20	25/64
1/2	20	29/64
9/16	18	33/64
5/8	18	37/64
*11/16	16	5/8
3/4	16	11/16
7/8	14	13/16
1	14	15/16
1 1/8	12	1 3/64

\*S.A.E. only

Tap Drills allow approx. 75% Full Thread

NPT = American National Taper Pipe Thread