

/CNC TAP CHART

METRIC			
THREAD SIZE	TAP DRILL HOLE SIZE FOR SOFT METALS* AND PLASTICS (MM)	TAP DRILL HOLE SIZE FOR HARD METALS** (MM)	MAX TAP DEPTH (MM)
M1x0.25	0.75	0.85	9.53
M1.2x0.25	0.95	1.00	9.53
M1.4x0.3	1.10	1.20	5.16
M1.5x0.35	1.15	1.25	5.16
M1.6x0.35	1.25	1.35	7.94
M1.8x0.35	1.45	1.55	9.53
M2x0.45	1.55	1.70	11.11
M2x0.4	1.60	1.75	11.11
M2.2x0.45	1.75	1.90	11.11
M2.5x0.45	2.05	2.20	12.70
M3x0.6	2.40	2.60	15.88
M3x0.5	2.50	2.70	15.88
M3.5x0.6	2.90	3.10	17.46
M4x0.75	3.25	3.50	19.05
M4x0.7	3.30	3.50	19.05
M4.5x0.75	3.70	4.00	22.23
M5x1.0	4.00	4.40	22.23
M5x0.9	4.10	4.40	22.23
M5x0.8	4.20	4.50	22.23
M5.5x0.9	4.60	4.90	22.23
M6x1.0	5.00	5.40	25.40
M6x0.75	5.25	5.50	25.40
M7x1.0	6.00	6.40	28.58
M7x0.75	6.20	6.50	28.58
M8x1.25	6.80	7.20	28.58
M8x1.0	7.00	7.40	28.58
M9x1.25	7.80	8.20	31.75
M9x1.0	8.00	8.40	31.75
M10x1.5	8.50	9.00	31.75
M10x1.25	8.80	9.20	31.75
M10x1.0	9.00	9.40	31.75
M11x1.5	9.50	10.00	42.07
M12x1.75	10.30	10.90	42.07
M12x1.5	10.50	11.00	42.07
M12x1.25	10.80	11.20	42.07
M14x2.0	12.10	12.70	42.07
M14x1.5	12.50	13.00	42.07
M14x1.25	12.80	13.20	42.07
M15x1.5	13.50	14.00	42.07
M16x2.0	14.00	14.75	46.04
M16x1.5	14.50	15.00	46.04
M17x1.5	15.50	16.00	46.04
M18x2.5	15.50	16.50	46.04
M18x2.0	16.00	16.75	46.04
M18x1.5	16.50	17.00	46.04

METRIC (CONT'D)			
THREAD SIZE	TAP DRILL HOLE SIZE FOR SOFT METALS* AND PLASTICS (MM)	TAP DRILL HOLE SIZE FOR HARD METALS** (MM)	MAX TAP DEPTH (MM)
M19x2.5	16.50	17.50	46.04
M20x2.5	17.50	18.50	50.80
M20x2.0	18.00	18.50	50.80
M20x1.5	18.50	19.00	50.80
M20x1	19.00	19.00	50.80
M22 x 1	21.00	21.00	55.00
M22 x 1.5	20.50	20.50	55.00
M22 x 2	20.00	20.00	55.00
M22 x 2.5	19.50	19.50	55.00
M24 x 1.5	22.50	22.50	60.00
M24 x 2	22.00	22.00	60.00
M24 x 3	21.00	21.00	60.00

* Soft metals include Aluminum 6061, Aluminum 7075 and Brass

** Hard metals include Steel 1018 and all Stainless steels

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IMPERIAL			
THREAD SIZE	TAP DRILL HOLE SIZE FOR SOFT METALS* AND PLASTICS (MM)	TAP DRILL HOLE SIZE FOR HARD METALS** (MM)	MAX TAP DEPTH (MM)
0-80	1.19	1.32	7.94
1-64	1.51	1.59	9.53
1-72	1.51	1.61	9.53
2-56	1.78	1.85	11.11
2-64	1.78	1.93	11.11
3-48	1.99	2.18	12.70
3-56	2.08	2.26	12.70
4-40	2.26	2.44	14.29
4-48	2.37	2.49	14.29
5-40	2.58	2.78	15.88
5-44	2.64	2.79	15.88
6-32	2.71	2.95	17.46
6-40	2.87	3.05	17.46
8-32	3.45	3.66	19.05
8-36	3.45	3.73	19.05
10-24	3.80	4.09	22.23
10-32	4.04	4.31	22.23
12-24	4.50	4.80	23.81
12-28	4.62	4.91	23.81
12-32	4.70	4.98	23.81
1/4-20	5.11	5.56	25.40
1/4-28	5.41	5.79	25.40
1/4-32	5.56	5.79	25.40
5/16-18	6.53	7.04	28.58
5/16-24	6.91	7.14	28.58
5/16-32	7.14	7.37	28.58
3/8-16	7.94	8.43	31.75
3/8-24	8.43	8.84	31.75
3/8-32	8.73	9.09	31.75
7/16-14	9.35	9.92	36.51
7/16-20	9.92	10.32	36.51
7/16-28	10.26	10.49	36.51
1/2-13	10.72	11.51	42.07
1/2-20	11.51	11.91	42.07
1/2-28	11.91	11.91	42.07
9/16-12	12.30	13.10	42.07
9/16-18	13.10	13.49	42.07
9/16-24	13.10	13.49	42.07
5/8-11	13.49	14.29	46.04
5/8-18	14.68	15.08	46.04
5/8-24	14.68	15.08	46.04
11/16-24	16.27	16.67	46.04
3/4-10	16.67	17.46	50.80
3/4-16	17.46	17.86	50.80
3/4-20	17.86	18.26	50.80

IMPERIAL (CONT'D)			
THREAD SIZE	TAP DRILL HOLE SIZE FOR SOFT METALS* AND PLASTICS (MM)	TAP DRILL HOLE SIZE FOR HARD METALS** (MM)	MAX TAP DEPTH (MM)
13/16-20	19.45	19.84	50.80
7/8-9	19.45	20.24	56.36
7/8-14	20.64	21.03	56.36
7/8-20	21.03	21.43	56.36
15/16-20	22.62	23.02	56.36
1"-8	22.23	23.42	63.50
1"-12	23.41	24.21	63.50
1"-20	24.21	24.61	63.50

* Soft metals include Aluminum 6061, Aluminum 7075 and Brass

** Hard metals include Steel 1018 and all Stainless steels

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NPT		
THREAD SIZE	TAP DRILL HOLE SIZE (MM)	MAX TAP DEPTH (MM)
1/16" NPT	6.15	17.46
1/8" NPT	8.43	19.05
1/4" NPT	11.11	26.99
3/8" NPT	14.29	26.99
1/2" NPT	17.86	34.93
3/4" NPT	23.02	34.93
1" NPT	28.97	44.45

NPS		
THREAD SIZE	TAP DRILL HOLE SIZE (MM)	MAX TAP DEPTH (MM)
1/8" NPS	9.09	19.05
1/4" NPS	11.91	26.99
3/8" NPS	15.08	26.99
1/2" NPS	19.00	34.93
3/4" NPS	24.21	34.93
1" NPS	30.56	44.45
1/8" NPS	9.09	19.05