

Tap Drill Sizes (cont.)

**Probable Percentage of Full Thread Produced
in Tapped Hole Using Stock Sizes of Drill**

Tap	Tap Drill	Decimal Equiv. of Tap Drill	Theoretical % of Thread	Probable Oversize (Mean)	Probable Hole Size	Percentage of Thread
1"-12	29/32	.9063	87	.0060	.9123	81
	39/64	.9219	72	.0060	.9279	67
	13/16	.9375	58	.0060	.9435	52
1"-14	39/64	.9219	84	.0060	.9279	78
	13/16	.9375	67	.0060	.9435	61
1 1/8"-7	31/32	.9688	84	.0062	.9750	81
	43/64	.9844	76	.0067	.9911	72
	1"	1.000	67	.0070	1.007	64
1 1/8"-12	13/16	1.0156	59	.0070	1.0226	55
	17/32	1.0313	87	.0071	1.0384	80
	13/16	1.0469	72	.0072	1.0541	66
1 1/8"-7	13/16	1.0938	84			
	13/16	1.1094	76			
1 1/8"-12	1 1/8	1.125	67			
	13/32	1.1563	87			
1 3/8"-6	1 1/16	1.1719	72			
	13/16	1.1875	87			
	1 1/16	1.2031	79			
1 3/8"-12	17/32	1.2188	72			
	1 1/16	1.2344	65			
	17/32	1.2813	87			
1 1/2"-6	1 1/16	1.2969	72			
	13/16	1.3125	87			
	1 1/16	1.3281	79			
1 1/2"-12	1 1/16	1.3438	72			
	1 1/16	1.3594	65			
	1 1/32	1.4063	87			
	1 1/8	1.4219	72			

No
Test Results
Available

Reaming
Recommended

American National Pipe Thread Tap Drill Sizes

Nominal Size Inches	No. of Threads per Inch	Depth of Thread Inches	Tap Drills for Pipe Threads	
			Minor Diameter Small End of Pipe	Size Drill
1/8	27	.02963	.3339	R
1/4	18	.04444	.4329	7/16
3/8	18	.04444	.5676	3/4
1/2	14	.05714	.7013	23/32
3/4	14	.05714	.9105	39/64
1	11 1/2	.06957	1.1441	1 1/32
1 1/4	11 1/2	.06957	1.4876	1 1/2
1 1/2	11 1/2	.06957	1.7265	1 9/16
2	11 1/2	.06957	2.1995	2 7/32
2 1/2	8	.10000	2.6195	2 3/8
3	8	.10000	3.2406	3 1/4
3 1/2	8	.10000	3.7375	3 3/4
4	8	.10000	4.2344	4 1/4

DECIMAL EQUIVALENTS

1 64	.015625	33 64	.515625
1 32	.03125	17 32	.53125
3 64	.046875	35 64	.546875
1 16	.0625	9 16	.5625
5 64	.078125	37 64	.578125
3 32	.09375	19 32	.59375
7 64	.109375	39 64	.609375
1 8	.125	5 8	.625
9 64	.140625	41 64	.640625
5 32	.15625	21 32	.65625
11 64	.171875	43 64	.671875
3 16	.1875	11 16	.6875
13 64	.203125	45 64	.703125
7 32	.21875	23 32	.71875
15 64	.234375	47 64	.734375
1 4	.25	3 4	.75
17 64	.265625	49 64	.765625
9 32	.28125	25 32	.78125
19 64	.296875	51 64	.796875
5 16	.3125	13 16	.8125
21 64	.328125	53 64	.828125
11 32	.34375	27 32	.84375
23 64	.359375	55 64	.859375
3 8	.375	7 8	.875
25 64	.390625	57 64	.890625
13 32	.40625	29 32	.90625
27 64	.421875	59 64	.921875
7 16	.4375	15 16	.9375
29 64	.453125	61 64	.953125
15 32	.46875	31 32	.96875
31 64	.484375	63 64	.984375
1 2	.5	1	.