

Starrett®

DECIMAL EQUIVALENTS

INCH/METRIC TAP DRILL SIZES & DECIMAL EQUIVALENTS

DRILL SIZE	DECIMAL EQUIVALENT	TAP SIZE	METRIC TAP DRILL SIZES			
			METRIC TAP	TAP DRILL (mm)	DECIMAL (Inch)	
<u>39</u> $\frac{19}{32}$.5938	$\frac{3}{4}$ - 10	M1.6 x 0.35	1.25	.0492	
<u>64</u> $\frac{5}{8}$.6094		M1.8 x 0.35	1.45	.0571	
<u>41</u> $\frac{5}{8}$.6250		M2 x 0.4	1.60	.0630	
<u>64</u> $\frac{21}{32}$.6406		M2.2 x 0.45	1.75	.0689	
<u>43</u> $\frac{21}{32}$.6562		M2.5 x 0.45	2.05	.0807	
<u>64</u> $\frac{11}{16}$.6719		M3 x 0.5	2.50	.0984	
<u>45</u> $\frac{11}{16}$.6875		M3.5 x 0.6	2.90	.1142	
<u>64</u> $\frac{23}{32}$.7031		M4 x 0.7	3.30	.1299	
<u>47</u> $\frac{32}{32}$.7344		$\frac{7}{8}$ - 9	M4.5 x 0.75	3.70	.1457
<u>64</u> $\frac{3}{4}$.7500			M5 x 0.8	4.20	.1654
<u>49</u> $\frac{3}{4}$.7656	M6 x 1		5.00	.1968	
<u>64</u> $\frac{25}{32}$.7812	M7 x 1		6.00	.2362	
<u>51</u> $\frac{32}{32}$.7969	$\frac{7}{8}$ - 14		M8 x 1.25	6.70	.2638
<u>64</u> $\frac{13}{16}$.8125			M8 x 1	7.00	.2756
<u>53</u> $\frac{13}{16}$.8281			M10 x 1.5	8.50	.3346
<u>64</u> $\frac{27}{32}$.8438			M10 x 1.25	8.70	.3425
<u>55</u> $\frac{32}{32}$.8594			M12 x 1.75	10.20	.4016
<u>64</u> $\frac{7}{8}$.8750			M12 x 1.25	10.80	.4252
<u>57</u> $\frac{8}{8}$.8906		M14 x 2	12.00	.4724	
<u>64</u> $\frac{29}{32}$.9062		M14 x 1.5	12.50	.4921	
<u>59</u> $\frac{32}{32}$.9219		1 - 8	M16 x 2	14.00	.5512
<u>64</u> $\frac{15}{16}$.9375			M16 x 1.5	14.50	.5709
<u>61</u> $\frac{15}{16}$.9531	M18 x 2.5		15.50	.6102	
<u>64</u> $\frac{31}{32}$.9688	M18 x 1.5		16.50	.6496	
<u>63</u> $\frac{32}{32}$.9844	$1\frac{1}{8}$ - 7		M20 x 2.5	17.50	.6890
<u>64</u> 1	1.0000			M20 x 1.5	18.50	.7283
$\frac{13}{64}$	1.0469			M22 x 2.5	19.50	.7677
$\frac{17}{64}$	1.1094			M22 x 1.5	20.50	.8071
$1\frac{11}{64}$ $1\frac{1}{8}$	1.1250			M24 x 3	21.00	.8268
$\frac{17}{32}$	1.1719			M24 x 2	22.00	.8661
$1\frac{19}{64}$ $1\frac{1}{4}$	1.2500		M27 x 3	24.00	.9449	
$\frac{11}{32}$	1.2969		M27 x 2	25.00	.9843	
$1\frac{11}{32}$ $1\frac{3}{8}$	1.3438		$1\frac{1}{2}$ - 12	M30 x 3.5	26.50	1.0433
$1\frac{12}{32}$ $1\frac{3}{8}$	1.3750			M30 x 2	28.00	1.1024
$1\frac{13}{32}$ $1\frac{3}{8}$	1.4219	M33 x 3.5		29.50	1.1614	
$1\frac{14}{32}$ $1\frac{3}{8}$	1.5000	M33 x 2		31.00	1.2205	
$1\frac{15}{32}$ $1\frac{3}{8}$		M36 x 4		32.00	1.2598	
$1\frac{16}{32}$ $1\frac{3}{8}$		M36 x 3		33.00	1.2992	
$1\frac{17}{32}$ $1\frac{3}{8}$		M39 x 4		35.00	1.3780	
$1\frac{18}{32}$ $1\frac{3}{8}$		M39 x 3		36.00	1.4173	
$1\frac{19}{32}$ $1\frac{3}{8}$						
$1\frac{20}{32}$ $1\frac{3}{8}$						

PIPE THREAD SIZES (NPS)			
THREAD	DRILL	THREAD	DRILL
$\frac{1}{8}$ - 27	$\frac{11}{32}$	$1\frac{1}{2}$ - $11\frac{1}{2}$	$\frac{13}{4}$
$\frac{1}{4}$ - 18	$\frac{7}{16}$	2 - $11\frac{1}{2}$	$\frac{27}{32}$
$\frac{3}{8}$ - 18	$\frac{37}{64}$	$2\frac{1}{2}$ - 8	$2\frac{21}{32}$
$\frac{1}{2}$ - 14	$\frac{23}{32}$	3 - 8	$\frac{31}{4}$
$\frac{3}{4}$ - 14	$\frac{59}{64}$	$3\frac{1}{2}$ - 8	$\frac{33}{4}$
1 - $11\frac{1}{2}$	$\frac{15}{32}$	4 - 8	$4\frac{1}{4}$
$1\frac{1}{4}$ - $11\frac{1}{2}$	$\frac{11}{2}$		

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DRILL SIZE	DECIMAL EQUIV.	TAP SIZE	DRILL SIZE	DECIMAL EQUIV.	TAP SIZE	DRILL SIZE	DECIMAL EQUIV.	TAP SIZE
	80 .0135		37 .1040	5 - 44		D	.2460	
	79 .0145		36 .1065	6 - 32	$\frac{1}{4}$ E	.2500		
$\frac{1}{64}$.0156		35 .1100		F	.2570		5/16 - 18
	78 .0160		34 .1110		G	.2610		
	77 .0180		33 .1130	6 - 40	$\frac{17}{64}$ H	.2656		
	76 .0200		32 .1160		I	.2660		5/16 - 24
	75 .0210		31 .1200		J	.2720		
	74 .0225		$\frac{1}{8}$ 30 .1250		K	.2770		
	73 .0240		29 .1285		9 32 L	.2810		
	72 .0250		28 .1360	8 - 32, 36	M	.2812		
	71 .0260		28 .1405		19 64 N	.2900		
	70 .0280		27 .1406		5 16 O	.2950		
	69 .0292		26 .1440		21 64 P	.2969		
$\frac{1}{32}$	68 .0310		26 .1470		11 32 Q	.3020		
	.0312		25 .1495	10 - 24	3 16 R	.3125		3/8 - 16
	67 .0320		24 .1520		64 S	.3160		
	66 .0330		23 .1540		11 32 T	.3230		
	65 .0350		22 .1562	10 - 32	23 64 U	.3281		
	64 .0360		22 .1570		3 8 V	.3320		3/8 - 24
	63 .0370		21 .1590		11 32 W	.3390		
	62 .0380		20 .1610		23 64 X	.3438		
	61 .0390		19 .1660		3 8 Y	.3480		
	60 .0400		18 .1695		27 64 Z	.3580		
	59 .0410		17 .1719		7 16 U	.3594		7/16 - 14
	58 .0420		17 .1730		3 8 V	.3680		
	57 .0430		16 .1770	12 - 24	25 64 W	.3750		
$\frac{3}{64}$	56 .0465	0 - 80	15 .1800		13 32 X	.3770		
	.0469		14 .1820	12 - 28	27 64 Y	.3860		7/16 - 20
	55 .0520		13 .1850		3 16 Z	.3906		
	54 .0550	1 - 64, 72	12 .1890		27 64 Z	.3970		
$\frac{1}{16}$	53 .0595		11 .1910		7 16 U	.4040		
	.0625		10 .1935		27 64 V	.4062		
	52 .0635		9 .1960		7 16 U	.4130		1/2 - 13
	51 .0670		8 .1990		29 64 V	.4219		
	50 .0700	2 - 56, 64	7 .2010		7 16 U	.4375		
	49 .0730		6 .2031	1/4 - 20	15 32 W	.4531		1/2 - 20
	48 .0760		5 .2040		31 64 X	.4688		
$\frac{5}{64}$.0781		4 .2055		1 16 Y	.4844		9/16 - 12
	47 .0785	3 - 48	4 .2090		33 64 Z	.5000		
	46 .0810		3 .2130	1/4 - 28	17 32 X	.5156		9/16 - 18
	45 .0820	3 - 56	2 .2188		32 64 Y	.5312		
	44 .0860	4 - 40	2 .2210		17 32 Z	.5469		5/8 - 11
	43 .0890	4 - 48	1 .2280		35 64 X	.5699		
	42 .0935		A .2340		9 16 Y	.5625		
$\frac{3}{32}$.0938		B .2380		37 64 Z	.5781		5/8 - 18
	41 .0960		C .2420					
	40 .0980							
	39 .0995	5 - 40						
	38 .1015							

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