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Tap Drill Sizes ' for Unified Inch Screw Threads

Tap Size	Tap Drill Size (inches)	Decimal Equiv. Of Tap Drill (inches)	Theoretical Thread	Percent Of Thread	Probable Mean Hole Size (inches)	Probable Hole Size (inches)	Tap Size	Tap Drill Size (inches)	Decimal Equiv. Of Tap Drill (inches)	Theoretical Thread	Percent Of Thread	Probable Mean Hole Size (inches)	Probable Hole Size (inches)
0-80	.56	.0465	.83	.0015	.0480	.74	8-32	3.40mm	.1339	.74	.0029	1.568	.67
	.364	.0409	.81	.0015	.0424	.71		.29	.1360	.69	.0029	1.389	.62
	1.20mm	.0472	.79	.0015	.0487	.69	8-36	.29	.1360	.78	.0029	1.389	.70
	1.20mm	.0482	.67	.0015	.0507	.57		3.0mm	.1378	.72	.0029	1.407	.65
1-64	.54	.0550	.89	.0015	.0565	.81	10-24	.27	.1440	.85	.0032	1.472	.79
	1.40mm	.0571	.78	.0015	.0586	.71		3.7mm	.1467	.82	.0032	1.489	.76
	.53	.0565	.67	.0015	.0589	.59		.26	.1470	.79	.0032	1.502	.74
1-72	1.5mm	.0591	.77	.0015	.0606	.68		.25	.1485	.75	.0032	1.527	.69
	.53	.0595	.75	.0015	.0610	.67		.24	.1520	.70	.0032	1.552	.64
	1.50mm	.0610	.67	.0015	.0634	.68	10-32	.22	.1563	.83	.0032	1.559	.75
2-56	.51	.0670	.82	.0017	.0687	.74		.22	.1570	.81	.0032	1.602	.73
	1.75mm	.0689	.73	.0017	.0716	.66		.21	.1590	.76	.0032	1.622	.68
	.50	.0700	.69	.0017	.0717	.62	12-24	.1164	.1719	.82	.0035	1.754	.75
2-64	1.80mm	.0700	.65	.0017	.0726	.58		.17	.1730	.79	.0035	1.785	.73
	.50	.0700	.79	.0017	.0717	.70		.16	.1770	.72	.0035	1.805	.66
	1.80mm	.0709	.74	.0017	.0726	.66	12-28	.16	.1770	.84	.0035	1.805	.77
3-48	.49	.0730	.64	.0017	.0747	.56		.15	.1800	.78	.0035	1.835	.70
	.48	.0760	.85	.0019	.0779	.78	4-60mm	.1811	.2570	.75	.0035	1.846	.67
	.484	.0781	.77	.0019	.0800	.70		.14	.1820	.73	.0035	1.855	.66
	.47	.0785	.76	.0019	.0804	.69	1/4-20	.9	.1960	.83	.0038	1.998	.77
	2.00mm	.0787	.75	.0019	.0806	.68		.8	.1990	.79	.0038	2.028	.73
	.46	.0810	.67	.0019	.0829	.60		.7	.2010	.75	.0038	2.048	.70
3-56	.45	.0825	.63	.0019	.0839	.56		13/64	.2031	.72	.0038	2.069	.66
	.46	.0810	.78	.0019	.0829	.69	1/4-28	5.40mm	.2125	.81	.0038	2.164	.72
	.45	.0820	.73	.0019	.0839	.65		.3	.2130	.80	.0038	2.168	.72
	2.10mm	.0827	.70	.0019	.0846	.62	5/16-18	F	.2570	.77	.0038	2.608	.72
4-40	.44	.0860	.60	.0019	.0880	.54		6-60mm	.2598	.73	.0038	2.636	.68
	2.20mm	.0866	.78	.0020	.0886	.72	5/16-24	H	.2660	.86	.0041	2.701	.78
	.43	.0890	.71	.0020	.0910	.65		6-80mm	.2677	.83	.0041	2.718	.75
	2.30mm	.0906	.66	.0020	.0926	.60		.1	.2720	.75	.0041	2.781	.67
4-48	2.35mm	.0925	.72	.0020	.0926	.72	3/8-16	7.80mm	.3071	.84	.0044	3.115	.78
	.42	.0935	.68	.0020	.0955	.61		7-90mm	.3110	.79	.0044	3.154	.73
	3-32	.0938	.68	.0020	.0968	.60		5/16	.3125	.77	.0044	3.169	.72
	2.40mm	.0945	.65	.0020	.0965	.57		O	.3160	.73	.0044	3.204	.68
5-40	.40	.0980	.83	.0023	.1003	.76	3/8-24	21.64	.3281	.87	.0044	3.325	.79
	.39	.0995	.79	.0023	.1018	.71		8-40mm	.3337	.82	.0044	3.351	.74
	.38	.1015	.72	.0023	.1038	.65		O	.3320	.79	.0044	3.364	.71
5-44	2.60mm	.1024	.70	.0023	.1047	.63		8-50mm	.3346	.75	.0044	3.390	.67
	.38	.1015	.79	.0023	.1038	.72	7/16-14	T	.3580	.86	.0046	3.626	.81
	2.60mm	.1024	.77	.0023	.1047	.69		23/64	.3694	.84	.0046	3.640	.79
	.37	.1040	.71	.0023	.1063	.63		8-20mm	.3622	.81	.0046	3.668	.76
6-32	.37	.1040	.84	.0023	.1063	.78		9-20mm	.3661	.77	.0046	3.717	.72
	.36	.1065	.78	.0023	.1088	.72		U	.3680	.75	.0046	3.726	.70
	7/64	.1084	.70	.0026	.1120	.64	9-40mm	3.701	.73	.0046	3.747	.68	
	.35	.1100	.69	.0026	.1120	.63	7/16-20	W	.3860	.79	.0046	3.966	.72
	.34	.1100	.67	.0026	.1136	.60		25/64	.3906	.72	.0046	3.992	.65
6-40	.34	.1110	.83	.0026	.1136	.75	1/2-13	10.50mm	.4134	.87	.0047	4.181	.82
	.33	.1130	.77	.0026	.1156	.69		27/64	.4219	.78	.0047	4.256	.73
	2.90mm	.1142	.73	.0026	.1168	.65	1/2-20	29.64	.4531	.72	.0047	4.578	.65
9/16-12	.32	.1160	.68	.0026	.1186	.60		1-1/4-7	1.3-22	1.0038	.84		
	3.154	.4844	.72	.0048	.4892	.68		1.764	1.1094	.76			

Reaming Recommended

AARYLAND METRICS
HREAD DATA CHARTS
 1. American Standard Unified Thread Series
 2. Metric Standard Thread Series
 3. Unified Thread Series - Parallel (BSPP/BSPT) - 28
 4. Unified Thread Series - Parallel (BSPP/BSPT) - 19
 5. Unified Thread Series - Parallel (BSPP/BSPT) - 14
 6. Unified Thread Series - Parallel (BSPP/BSPT) - 11
 7. Unified Thread Series - Parallel (BSPP/BSPT) - 8
 8. Unified Thread Series - Parallel (BSPP/BSPT) - 6
 9. Unified Thread Series - Parallel (BSPP/BSPT) - 4
 10. Unified Thread Series - Parallel (BSPP/BSPT) - 2

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“G” Thread BSPP per ISO 228-1 JIS B 0202	Dash Size	Port O-Ring (See Pg. N6)
1/8-28	2	P8
1/4-19	4	P11
3/8-19	6	P14
1/2-14	8	P18
3/4-14	12	P24
1-11	16	P29

Table H2 – JIS B2351 Port Threads and O-Rings as

Catalogue
VER-BOLT
 VER-BOLT is a leading manufacturer of high-strength bolts and nuts. Our products are used in a wide range of applications, from construction to industrial machinery. We offer a comprehensive range of products, including bolts, nuts, washers, and lock washers. Our products are made from high-quality materials and are available in a variety of sizes and grades. We are committed to providing our customers with the highest quality products and excellent customer service.

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1/8-28	2	P8
1/4-19	4	P11
3/8-19	6	P14
1/2-14	8	P18
3/4-14	12	P24
1-11	16	P29

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