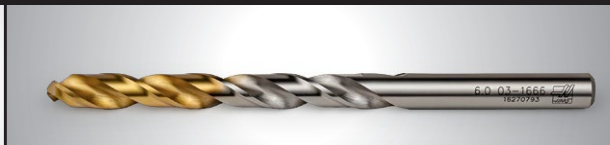
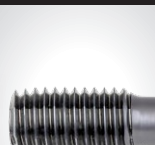


Tap Drill Sizes

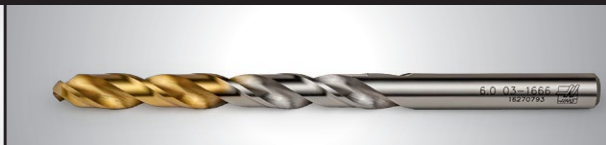
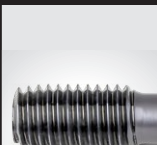
Decimal Equivalents



Haas
F1 Team

								
	DRILL SIZE			DECIMAL EQUIVALENT				
CUT TAP	METRIC	FRACTION	A-Z #	Ø INCH	Ø mm	FORM TAP*		
	1.00 mm	1/64 "		0.0156	0.397			
		1/32 "		0.0313	0.794			
				0.0394	1.000			
	1.10 mm			0.0433	1.100			
#0-80			#56	0.0465	1.181			
		3/64 "		0.0469	1.191			
M1.6 x 0.35	1.20 mm			0.0472	1.200			
	1.25 mm			0.0492	1.250			
	1.30 mm			0.0512	1.300			
			#55	0.0520	1.321			
			#54	0.0550	1.397		#0-80*	
	1.40 mm			0.0551	1.400			
M1.8 x 0.35	1.45 mm			0.0571	1.450	M1.6 x 0.35*		
	1.50 mm			0.0591	1.500			
#1-64			#53	0.0595	1.511			
#1-72								
		1/16 "		0.0625	1.588			
M2 x 0.4	1.60 mm			0.0630	1.600			
			#52	0.0635	1.613			
	1.65 mm			0.0650	1.650		M1.8 x 0.35*	
	1.70 mm			0.0669	1.700			
			#51	0.0670	1.702	#1-64*		
						#1-72*		
	M2.2 x 0.45	1.75 mm			0.0689	1.750		
#2-56			#50	0.0700	1.778			
#2-64								
	1.80 mm			0.0709	1.800	M2 x 0.4*		
			#49	0.0730	1.854			
	1.90 mm			0.0748	1.900			
			#48	0.0760	1.930			
			5/64 "	0.0781	1.984		#2-56*	
#3-48			#47	0.0785	1.994	#2-64*		
	2.00 mm			0.0787	2.000			
	M2.5 x 0.45	2.05 mm		0.0807	2.050			
			#46	0.0810	2.057			
	#3-56		#45	0.0820	2.083			
	2.10 mm			0.0827	2.100			
			#44	0.0860	2.184			
	2.20 mm			0.0866	2.200			
#4-40	2.30 mm		#43	0.0890	2.261	#3-48*		
				0.0906	2.300	#3-56*		
	#4-48		#42	0.0935	2.375	M2.5 x 0.45*		
		3/32 "		0.0938	2.381			
	2.40 mm			0.0945	2.400			
			#41	0.0960	2.438			
			#40	0.0980	2.489			
	M3 x 0.5	2.50 mm		0.0984	2.500			
			#39	0.0995	2.527			
#5-40			#38	0.1015	2.578	#4-40*		
	2.60 mm			0.1024	2.600	#4-48*		
#5-44			#37	0.1040	2.642			
	2.70 mm			0.1063	2.700			
#6-32			#36	0.1065	2.705			
		7/64 "		0.1094	2.778		M3 x 0.5*	
			#35	0.1100	2.794			
	2.80 mm			0.1102	2.800			
			#34	0.1110	2.819			
	#6-40		#33	0.1130	2.870			
	2.90 mm			0.1142	2.900	#5-40*		
						#5-44*		
			#32	0.1160	2.946			
	3.00 mm			0.1181	3.000			
			#31	0.1200	3.048			
	3.10 mm			0.1220	3.100		#6-32*	
		1/8 "		0.1250	3.175			
	3.20 mm			0.1260	3.200			
							#6-40*	
			#30	0.1285	3.264	M3.5 x 0.6*		
	M4 x 0.70	3.30 mm		0.1299	3.300			
	3.40 mm			0.1339	3.400			
#8-32			#29	0.1360	3.454			
	#8-36							
	3.50 mm			0.1378	3.500			
			#28	0.1405	3.569			
		9/64 "		0.1406	3.572			
	3.60 mm			0.1417	3.600			
			#27	0.1440	3.658			
	M4.5 x 0.75	3.70 mm		0.1457	3.700		M4 x 0.7*	
			#26	0.1470	3.734			
	#10-24			#25	0.1495		3.797	#8-32*
								M4 x 0.5*
		3.80 mm			0.1496		3.800	
			#24	0.1520	3.861			
	3.90 mm			0.1535	3.900			
			#23	0.1540	3.912			

Form Taps* require different sized Tap Drills than Cut Taps.

							
	DRILL SIZE			DECIMAL EQUIVALENT			
CUT TAP	METRIC	FRACTION	A-Z #	Ø INCH	Ø mm	FORM TAP*	
	4.00 mm	5/32 "		0.1563	3.969		
			#22	0.1570	3.988		
				0.1575	4.000		
#10-32			#21	0.1590	4.039		
			#20	0.1610	4.089		
	4.10 mm			0.1614	4.100		
M5 x 0.80	4.20 mm			0.1654	4.200		
			#19	0.1660	4.216		
	4.30 mm			0.1693	4.300		
		11/64 "	#18	0.1695	4.305	#10-24*	
				#17	0.1730		4.394
			4.40 mm		0.1732		4.400
#12-24			#16	0.1770	4.496	#10-32*	
	4.50 mm			0.1772	4.500		
			#15	0.1800	4.572		
	4.60 mm			0.1811	4.600	M5 x 0.8°	
#12-28			#14	0.1820	4.623		
			#13	0.1850	4.699		
	4.70 mm			0.1850	4.700	M5 x 0.5°	
#12-32		3/16 "		0.1875	4.763		
	4.80 mm			0.1890	4.800		
			#12	0.1890	4.801		
			#11	0.1910	4.851		
				0.1929	4.900		
				0.1935	4.915		
			#10	0.1935	4.915	#12-24*	
			#9	0.1960	4.978		
M6 x 1.00	5.00 mm			0.1969	5.000		
	5.10 mm		#8	0.1990	5.055		
				0.2008	5.100		
				0.2010	5.105		
1/4-20			#7	0.2010	5.105	#12-28*	
		13/64 "		0.2031	5.159		
				#6	0.2040		5.182
				0.2047	5.200		
	5.20 mm		#5	0.2055	5.220		
				0.2087	5.300		
	5.30 mm		#4	0.2090	5.309		
	5.40 mm			0.2126	5.400		
			#3	0.2130	5.410		
	1/4-28	5.50 mm			0.2165		5.500
1/4-32		7/32 "		0.2188	5.556	M6 x 1°	
	5.60 mm			0.2205	5.600		
			#2	0.2210	5.613		
	5.70 mm			0.2244	5.700	M6 x .75°	
			#1	0.2280	5.791		
		5.80 mm			0.2283		5.800
	5.90 mm			0.2323	5.900	1/4-20*	
			A	0.2340	5.944		
				0.2344	5.953		
			15/64 "		0.2362	6.000	
M7 x 1.00	6.00 mm			0.2362	6.000		
			B	0.2380	6.045		
	6.10 mm			0.2402	6.100		
	6.20 mm			0.2420	6.147		
				0.2441	6.200		
	1/16-27 NPT	6.30 mm		D	0.2460		6.248
1/16-27 NPS		1/4 "	E	0.2480	6.300		
	6.40 mm			0.2520	6.400		
	6.50 mm			0.2559	6.500		
5/16-18			F	0.2570	6.528		
	6.60 mm			0.2598	6.600		
				G	0.2610		6.629
M8 x 1.25	6.70 mm			0.2638	6.700		
		17/64 "		0.2656	6.747		
			H	0.2660	6.756		
6.80 mm					0.2677	6.800	
5/16-24	6.90 mm			0.2717	6.900		
			I	0.2720	6.909		
	M8 x 1.00	7.00 mm			0.2756		7.000
			J	0.2770	7.036		
	7.10 mm			0.2795	7.100		
			K	0.2810	7.137		
5/16-32		9/32 "		0.2813	7.144		
	7.20 mm			0.2835	7.200		
	7.30 mm			0.2874	7.300		
			L	0.2900	7.366	5/16-18*	
	7.40 mm			0.2913	7.400		
			M	0.2950	7.493		
	7.50 mm			0.2953	7.500	M8 x 1.25°	
		19/64 "		0.2969	7.541		
	7.60 mm			0.2992	7.600		
			N	0.3020	7.671	M8 x 1°	
	7.70 mm			0.3031	7.700		
	7.80 mm			0.3071	7.800		
3/8-16	7.90 mm			0.3110	7.900		
		5/16 "		0.3125	7.938		