

Fraction, Metric, Number & Letter Sizes

TAPPING DRILL SIZES

PIPE SIZES

JTS Machinery & Supply Co.
Your First Source for All Your
Tooling & Metalworking Needs

TAPER (NPT)	
Tap Size	Drill Size*
1/16-27	D
1/8-27	R
1/4-18	7/16
3/8-18	37/64
1/2-14	45/64
3/4-14	59/64
1-11-1/2	1-5/32
1-1/4-11-1/2	1-1/2
1-1/2-11-1/2	1-47/64
2-11-1/2	2-7/32
2-1/2-8	2-5/8
3-8	3-1/4
3-1/2-8	3-3/4
4-8	4-1/4
* For tapping without reaming	
STRAIGHT (NPS)	
Tap Size	Drill Size
1/16-27	1/4
1/8-27	11/32
1/4-18	7/16
3/8-18	37/64
1/2-14	23/32
3/4-14	59/64
1-11-1/2	1-5/32
1-1/4-11-1/2	1-1/2
1-1/2-11-1/2	1-3/4
2-11-1/2	2-7/32
2-1/2-8	2-21/32
3-8	3-9/32
3-1/2-8	3-25/32
4-8	4-9/32

Tel: 440-951-2138 ☐ Toll Free: 800-321-3566 ☐ Fax: 440-951-6873 ☐ Toll Free Fax: 888-587-0022 ☐ www.itsmachine.com