

American Pipe Tap Drill Sizes (Tapered Tap)

Nominal Pipe Size OD	Threads Per Inch	Outside Diameter of Pipe	Drill to Use For Tapping	Drill Size Decimal Equivalent	Length of Useful Thread (Due to Taper)
1/8	27	0.4050	R	0.3390	0.2639
1/4	18	0.5400	7/16	0.4375	0.4018
3/8	18	0.6750	37/64	0.5781	0.4078
1/2	14	0.8400	45/64"	0.7031	0.5337
3/4	14	1.0500	59/64"	0.9219	0.5457
1	11.5	1.3150	1-5/32"	1.1563	0.6828
1-1/4	11.5	1.6600	1-1/2"	1.5000	0.7068
1-1/2	11.5	1.9000	1-47/64"	1.7344	0.7235
2	11.5	2.3750	2-7/32"	2.2188	0.7565