

CHAMPION

DECIMAL EQUIVALENTS

Size	Decimal	Size	Decimal	Size	Decimal	Size	Decimal	
0.35mm	80	0.0135	2.35mm	0.0925	5.40mm	0.2126	3/8	0.3750
		0.0138		0.0935		0.2130		0.3770
	79	0.0145	42	0.0938	5.50mm	0.2165	3	0.3780
	1/64	0.0156	3/32	0.0945	7/32	0.2188		0.3819
0.40mm		0.0157	41	0.0960	5.60mm	0.2205	2	0.3839
	78	0.0160	2.45mm	0.0965		0.2210		0.3858
0.45mm		0.0177	40	0.0980	5.70mm	0.2244	W	0.3860
	77	0.0180	2.50mm	0.0984	5.75mm	0.2264		0.3898
0.50mm		0.0197	39	0.0995		0.2280	1	0.3906
	76	0.0200	38	0.1015	5.80mm	0.2283		0.3937
	75	0.0210	2.60mm	0.1024	5.90mm	0.2323	X	0.3970
0.55mm		0.0217	37	0.1040	A	0.2340	Y	0.4040
	74	0.0225	2.70mm	0.1063		0.2344	13/32	0.4062
0.60mm		0.0236	36	0.1065	6.00mm	0.2362	Z	0.4130
	73	0.0240	2.75mm	0.1083	B	0.2380		0.4134
	72	0.0250	7/64	0.1094	6.10mm	0.2402	27/64	0.4219
0.65mm		0.0256	35	0.1100	C	0.2420		0.4331
	71	0.0260	2.80mm	0.1102	6.20mm	0.2441	7/16	0.4375
0.70mm		0.0276	34	0.1110	D	0.2460		0.4528
	70	0.0280	33	0.1130	6.25mm	0.2461	29/64	0.4531
	69	0.0292	2.90mm	0.1142	6.30mm	0.2480	15/32	0.4688
0.75mm		0.0295	32	0.1160	E	0.2500	1/4	0.4724
	68	0.0310	3.00mm	0.1181	6.40mm	0.2520	31/64	0.4844
0.80mm		0.0315	3.10mm	0.1200	6.50mm	0.2559		0.4921
	67	0.0320	3.10mm	0.1220	F	0.2570	1/2	0.5000
	66	0.0330	3.20mm	0.1250	6.60mm	0.2598		0.5118
0.85mm		0.0335	3.25mm	0.1260	G	0.2610	33/64	0.5156
	65	0.0350	3.30mm	0.1280	6.70mm	0.2638	17/32	0.5312
0.90mm		0.0354	3.40mm	0.1285		0.2656	17/64	0.5315
	64	0.0360	3.40mm	0.1299	6.75mm	0.2657	35/64	0.5469
	63	0.0370	3.50mm	0.1339	H	0.2660		0.5512
0.95mm		0.0374	29	0.1360	6.80mm	0.2677	9/16	0.5625
	62	0.0380	28	0.1378	6.90mm	0.2717		0.5709
	61	0.0390	9/64	0.1405	7.00mm	0.2720	37/64	0.5781
1.00mm		0.0394	3.60mm	0.1417	I	0.2756		0.5906
	60	0.0400	3.60mm	0.1440	J	0.2770	19/32	0.5938
	59	0.0410	3.70mm	0.1457	7.10mm	0.2795	39/64	0.6094
1.05mm		0.0413	26	0.1470	K	0.2810		0.6102
	58	0.0420	3.75mm	0.1476		0.2812	5/8	0.6250
	57	0.0430	25	0.1495	7.20mm	0.2835		0.6299
1.10mm		0.0433	3.80mm	0.1496	7.25mm	0.2854	41/64	0.6406
1.15mm		0.0453	24	0.1496	7.30mm	0.2874		0.6496
	56	0.0465	3.90mm	0.1520	L	0.2900	21/32	0.6562
	3/64	0.0469	23	0.1535	7.40mm	0.2913		0.6693
1.20mm		0.0472	5/32	0.1540	M	0.2950	43/64	0.6719
1.25mm		0.0492	22	0.1562	7.50mm	0.2953	11/16	0.6875
1.30mm		0.0512	4.00mm	0.1570		0.2969	19/64	0.6890
	55	0.0520	21	0.1575	7.60mm	0.2992	45/64	0.7031
	54	0.0531	20	0.1590	N	0.3020		0.7087
1.35mm		0.0550	4.10mm	0.1610	7.70mm	0.3031	23/32	0.7188
1.40mm		0.0551	4.20mm	0.1614	7.75mm	0.3051		0.7283
1.45mm		0.0571	19	0.1654	7.80mm	0.3071	47/64	0.7344
1.50mm		0.0591	4.25mm	0.1660	7.90mm	0.3110		0.7480
	53	0.0595	4.30mm	0.1673		0.3125	3/4	0.7500
1.55mm		0.0610	18	0.1693	8.00mm	0.3150	49/64	0.7656
	1/16	0.0625	11/64	0.1695	O	0.3160		0.7677
1.60mm		0.0630	17	0.1719	8.10mm	0.3189	25/32	0.7812
	52	0.0635	4.40mm	0.1730	8.20mm	0.3228		0.7874
1.65mm		0.0650	16	0.1732	P	0.3230	51/64	0.7969
1.70mm		0.0669	15	0.1770	8.25mm	0.3248		0.8071
	51	0.0670	4.50mm	0.1772	8.30mm	0.3268	13/16	0.8125
1.75mm		0.0689	14	0.1800		0.3281	21/64	0.8268
	50	0.0700	4.60mm	0.1811	8.40mm	0.3307	53/64	0.8281
1.80mm		0.0709	13	0.1820	Q	0.3320	27/32	0.8438
1.85mm		0.0728	3/16	0.1850	8.50mm	0.3346		0.8465
	49	0.0730	11	0.1870	R	0.3386	55/64	0.8594
1.90mm		0.0748	4.80mm	0.1875	8.60mm	0.3390		0.8661
	48	0.0760	12	0.1890	8.70mm	0.3425	7/8	0.8750
1.95mm		0.0768	4.90mm	0.1910		0.3438	22.50mm	0.8858
	5/64	0.0781	10	0.1929	8.75mm	0.3445	57/64	0.8906
	47	0.0785	9	0.1935	8.80mm	0.3465		0.9055
2.00mm		0.0787	5.00mm	0.1960	S	0.3480	29/32	0.9062
2.05mm		0.0807	8	0.1969	8.90mm	0.3504	59/64	0.9219
	46	0.0810	5.10mm	0.1990	9.00mm	0.3543		0.9252
	45	0.0820	7	0.1999	T	0.3580	15/16	0.9375
2.10mm		0.0827	13/64	0.2008	9.10mm	0.3583		0.9449
2.15mm		0.0846	6	0.2010		0.3594	61/64	0.9531
	44	0.0860	5.20mm	0.2031	9.20mm	0.3622		0.9646
2.20mm		0.0866	5	0.2040	9.25mm	0.3642	31/32	0.9688
2.25mm		0.0886	5.25mm	0.2047	9.30mm	0.3661		0.9843
	43	0.0890	5.30mm	0.2055	U	0.3680	63/64	0.9844
2.30mm		0.0906	4	0.2067	9.40mm	0.3701	1	1.0000
				0.2087	9.50mm	0.3740		
				0.2090				

METRIC - BLACK • FRACTIONAL - RED • WIRE GAUGE - GREEN • LETTER SIZE - BLUE

TAP/DRILL RECOMMENDATIONS

Inch Tap Size & Pitch	Metric Tap Size & Pitch	Drill Size	Inch Tap Size & Pitch	Metric Tap Size & Pitch	Drill Size
0-80	M1.6 x 0.35	3/64		M12 x 1.75	10.20
	M1.8 x 0.35	1.25		M12 x 1.25	10.80
		1.45	1/2-13		27/64
1-64		53	1/2-20		29/64
1-72		53		M14 x 2.00	12.00
	M2 x 0.40	1.60	9/16-12		31/64
2-56		50	9/16-18		33/64
2-64		50	5/8-11		17/32
	M2.2 x 0.45	1.75	5/8-18		37/64
	M2.5 x 0.45	2.05		M16 x 2.00	14.00
3-48		47		M16 x 1.50	14.50
3-56		46		M18 x 2.50	15.50
4-40		43		M18 x 1.50	16.50
4-48		42	3/4-10		21/32
	M3 x 0.50	2.50	3/4-16		11/16
5-40		38		M20 x 2.50	17.50
5-44		37		M20 x 1.50	18.50
	M3.5 x 0.60	2.90		M22 x 2.50	19.50
6-32		36		M22 x 1.50	20.50
6-40		33	7/8-9		49/64
	M4 x 0.70	3.30	7/8-14		13/16
8-32		29		M24 x 3.00	21.00
8-36		29		M24 x 2.00	22.00
	M4.5 x 0.75	3.70	1-8		7/8
10-24		26	1-12		59/64
10-32		21		M27 x 3.00	24.00
	M5 x 0.80	4.20		M27 x 2.00	25.00
12-24		16	1-1/8-7		63/64
12-28		15	1-1/8-12		1-3/64
	M6 x 1.00	5.00		M30 x 3.50	26.50
1/4-20		7		M30 x 2.00	28.00
1/4-28		3	1-1/4-7		1-7/64
	M7 x 1.00	6.00	1-1/4-12		1-11/64
5/16-18		F		M33 x 3.50	29.50
5/16-24		I		M33 x 2.00	31.00
	M8 x 1.25	6.70	1-3/8-6		1-7/32
	M8 x 1.00	7.00	1-3/8-12		1-19/64
3/8-16		5/16		M36 x 4.00	32.00
3/8-24		Q		M36 x 3.00	33.00
	M10 x 1.50	8.50	1-1/2-6		1-11/32
	M10 x 1.25	8.70	1-1/2-12		1-27/64
7/16-14		U		M39 x 4.00	35.00
7/16-20		25/64		M39 x 3.00	36.00

PIPE TAP/DRILL RECOMMENDATIONS

Nominal Pipe Tap	NPT Size	NPS*	
		NPSM	NPSC
1/16-27	C	-	1/4
1/8-27	Q	T	Q
1/4-18	7/16	15/32	7/16
3/8-18	9/16	39/64	37/64
1/2-14	45/64	47/64	45/64
3/4-14	29/32	61/64	59/64
1-11-1/2	1-9/64	1-13/64	1-5/32
1-1/4-11-1/2	1-31/64	1-35/64	1-1/2
1-1/2-11-1/2	1-23/32	1-25/32	1-47/64
2-11-1/2	2-3/16	2-1/4	2-13/64

* Note: NPS taps are used to produce NPSM (Mechanical) and NPSC (Coupling) threads which require different tap drill sizes.

