



TAP & DRILL CHART

LIGHTWEIGHT - THIN WALL INSERTS

INCH SERIES - UNC

Internal Thread Size Class 2B	Lightweight / Thin Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Tap Drill Size	C'Sink Dia +.010/- .000
10-24	75921	76321	5/16-18	I	.32
1/4-20	75922	76322	3/8-16	Q	.38
5/16-18	75923	76323	7/16-14	X	.44
3/8-16	75924	76324	1/2-13	29/64	.51
7/16-14	75925	76325	9/16-12	33/64	.57
1/2-13	75926	76326	5/8-11	37/64	.63

INCH SERIES - UNF

Internal Thread Size Class 2B	Lightweight / Thin Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Drill Size	C'Sink Dia +.010/- .000
10-32	76121	76521	5/16-18	I	.32
1/4-28	76122	76522	3/8-16	Q	.38
5/16-24	76123	76523	7/16-14	X	.44
3/8-24	76124	76524	1/2-13	29/64	.51
7/16-20	76125		9/16-12	33/64	.57
1/2-20	76126	76526	5/8-11	37/64	.63

METRIC SERIES

Internal Thread Size Class 6H	Lightweight / Thin Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Drill Size	C'Sink Dia +.010/- .000
M5-.8	75951	76351	M8-1.25	6.9	8.25
M6-1.0	75952	76352	M10-1.25	8.8	10.25
M8-1.25	75953	76353	M12-1.25	10.8	12.25
M8-1.0	76153		M12-1.25	10.8	12.25
M10-1.5	75955	76355	M14-1.5	12.8	14.25
M10-1.25	76155		M14-1.5	12.8	14.25
M12-1.75	75956	76356	M16-1.5	14.75	16.25
M12-1.25	76156		M16-1.5	14.75	16.25

HEAVY DUTY - THICK WALL INSERTS

INCH SERIES - UNC

Internal Thread Size Class 2B	Heavy Duty / Thick Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Drill Size	C'Sink Dia +.010/- .000
8-32	75900	76300	5/16-18	I	.32
10-24	75901	76301	3/8-16	Q	.38
1/4-20	75902	76302	7/16-14	X	.44
5/16-18	75903	76303	1/2-13	29/64	.51
3/8-16	75904	76304	9/16-12	33/64	.57
7/16-14	75905	76305	5/8-11	37/64	.63
1/2-13	75906	76306	3/4-16	45/64	.76
9/16-12	75907		3/4-16	45/64	.76
5/8-11	75908		7/8-14	53/64	.88
3/4-10	75909		1 1/8-12	1 1/16	1.14
7/8-9	75910		1 1/4-12	1 3/16	1.27
1-8	75911		1 3/8-12	1 5/16	1.39
1 1/8-7	75913		1 1/2-12	1 7/16	1.52
1 1/4-7	75914		1 5/8-12	1 9/16	1.64
1 1/2-6	75916		1 7/8-12	1 13/16	1.89

INCH SERIES - UNF

Internal Thread Size Class 2B	Heavy Duty / Thick Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Drill Size	C'Sink Dia +.010/- .000
10-32	76101	76501	3/8-16	Q	.38
1/4-28	76102	76502	7/16-14	X	.44
5/16-24	76103	76503	1/2-13	29/64	.51
3/8-24	76104	76504	9/16-12	33/64	.57
7/16-20	76105		5/8-11	37/64	.63
1/2-20	76106	76506	3/4-16	45/64	.76
9/16-18	76107		3/4-16	45/64	.76
5/8-18	76108		7/8-14	53/64	.88
3/4-16	76109		1 1/8-12	1 1/16	1.14
7/8-14	76110		1 1/4-12	1 3/16	1.27
1-12	76111		1 3/8-12	1 5/16	1.39
1-14	76112		1 3/8-12	1 5/16	1.39

METRIC SERIES

Internal Thread Size Class 6H	Heavy Duty / Thick Wall				
	Carbon Steel P/N	Stainless Steel P/N	External Thread / Tap Size	Drill Size	C'Sink Dia +.010/- .000
M4-0.7	75963	76363	M8-1.25	6.90	8.25
M5-0.8	75964	76364	M10-1.25	8.80	10.25
M6-1.0	75965	76365	M12-1.25	10.80	12.25
M8-1.25	75966	76366	M14-1.5	12.80	14.25
M10-1.5	75967	76367	M16-1.5	14.75	16.25
M12-1.75	75969	76369	M18-1.5	16.75	18.25
M14-2.0	75970		M20-1.5	18.75	20.25
M14-1.5	76170		M20-1.5	18.75	20.25
M16-2.0	75971		M22-1.5	20.50	22.25
M16-1.5	76171		M22-1.5	20.50	22.25
M18-1.5	76172		M24-1.5	22.50	24.25
M20-2.5	75973		M30-2.0	28.00	30.25
M20-1.5	76173		M30-2.0	28.00	30.25
M22-1.5	76174		M32-2.0	30.00	32.25
M24-3.0	75975		M33-2.0	31.00	33.25
M24-2.0	76175		M33-2.0	31.00	33.25