



# MORSE

## Cutting Tools

NEW BEDFORD, MASSACHUSETTS

### TAP DRILL SIZES

TAP SIZE	APPROXIMATE TAP DRILL SIZE			TAP SIZE	APPROXIMATE TAP DRILL SIZE		
	75%	70%	60%		75%	70%	60%
0-80	56	56	$\frac{3}{16}$	$\frac{3}{16}$ -20	7	6	4
1-64	54	54	53	$\frac{1}{4}$ -28	3	3	2
1-72	54	54	53	$\frac{9}{16}$ -18	F	G	H
2-56	51	51	50	$\frac{9}{16}$ -24	.272	.275	$\frac{9}{32}$
2-64	50	50	49	$\frac{3}{8}$ -16	$\frac{5}{16}$	O	P
3-48	48	47	46	$\frac{3}{8}$ -24	Q	R	$\frac{1}{16}$
3-56	47	46	45	$\frac{7}{16}$ -14	U	$\frac{3}{8}$	.382
4-40	44	44	43	$\frac{7}{16}$ -20	W	$\frac{23}{64}$	X
4-48	43	42	$\frac{3}{32}$	$\frac{1}{2}$ -13	.425	.430	$\frac{3}{16}$
5-40	39	38	37	$\frac{1}{2}$ -20	$\frac{23}{64}$	$\frac{23}{64}$	.461
5-44	38	38	37	$\frac{9}{16}$ -12	$\frac{23}{64}$	$\frac{23}{64}$	$\frac{1}{2}$
6-32	36	35	33	$\frac{9}{16}$ -18	$\frac{23}{64}$	$\frac{23}{64}$	.519
6-40	34	33	32	$\frac{5}{8}$ -11	$\frac{23}{64}$	$\frac{23}{64}$	.554
8-32	30	29	28	$\frac{5}{8}$ -18	.575	.575	$\frac{23}{64}$
8-36	29	29	28	$\frac{1}{16}$ -16	.631	.631	$\frac{43}{64}$
10-24	25	24	22	$\frac{3}{4}$ -10	$\frac{21}{32}$	$\frac{21}{32}$	$\frac{43}{64}$
10-32	21	20	19	$\frac{3}{4}$ -16	$\frac{1}{16}$	.693	$\frac{43}{64}$
12-24	17	16	14	$\frac{7}{8}$ -9	$\frac{49}{64}$	.774	.788
12-28	15	14	12	$\frac{7}{8}$ -14	.805	$\frac{13}{16}$	.819
				1-8	$\frac{7}{8}$	.886	$\frac{29}{32}$
				1-12	$\frac{29}{32}$	$\frac{59}{64}$	$\frac{19}{16}$

### PIPE TAP SIZES

NOMINAL SIZE	TAP DRILL		NOMINAL SIZE	TAP DRILL	
	TAPER NPT	STRAIGHT NPT		TAPER NPT	STRAIGHT NPT
$\frac{1}{8}$ -27	D	$\frac{1}{8}$	$\frac{3}{4}$ -14	$\frac{59}{64}$	$\frac{15}{16}$
$\frac{1}{4}$ -27	R	S	1-11-15	1- $\frac{39}{32}$	1- $\frac{31}{16}$
$\frac{1}{2}$ -18	$\frac{7}{16}$	$\frac{23}{64}$	1- $\frac{11}{16}$ -11-15	1-15	1- $\frac{23}{16}$
$\frac{3}{4}$ -18	$\frac{23}{64}$	$\frac{19}{32}$	1- $\frac{3}{8}$ -11-15	1- $\frac{43}{64}$	1- $\frac{3}{8}$
1-14	$\frac{23}{32}$	$\frac{43}{64}$	2-11-15	2- $\frac{39}{32}$	2- $\frac{39}{32}$



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# Tap Drill Sizes Morse Cutting Tools

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