

**Tap drill hole size chart metric chart printable chart pdf**

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If you just want a simple tap drill chart in Metric and Imperial sizes, or a pdf you can print and post in your workshop, scroll down. But, before you do, wouldn't you like to hear about something that's much better in every way? Something that'll make it much less likely you'll break a tap? Something a little more modern than a simple chart? Let us help, and BTW, it's completely free too! What's better than a drill size chart? Make no mistake, having a good drill bit size chart (sometimes called a "drill index") is a very handy thing indeed to have around. If it has information on which twist drill size to use for tapping, so much the better. But in this age of computers and the Internet, you can recommend size from the tap manufacturer. Anytime you see just one size being recommended, you know you can do better—one size does not fit all when it comes to tapping. How can that be? Well, it's actually pretty simple. To know which drill bit size is right for your particular tapping application, you need to consider what thread percentage you need when you're doing a tap. What's Thread Percentage and Why Care? It's the ratio of the thread to the lead. Each thread moves from valley to peak. Now suppose you ran a twist drill down the hole and shaved off some of the peaks. They're pretty delicate, and will wear off quickly if they come into contact with the thread. You need at least 100% thread, that is, 100% of the lead moves 3 times the pitch of the tap. Why does this matter? Because it is the power to tap that breaks taps, for one thing. Getting 99% of the lead moved with 1/3 the force of what you need means you're dramatically lengthening the life of the tap.

Now we all know what happens when we break a tap, right? Sailors would go running out of the shop if they heard the language we use in that case. It's just not a happy thing. But is it okay to have less than 100% threads? In fact, many standards bodies insist on it. For example, American National and Unified Standard specify that the pitch diameter of a tap must be at least 95% of the thread diameter. These specifications also provide a minimum value that varies from approximately 53% to 75%, depending upon the diameter and pitch of thread. Thread Percentage and Tap Drill Charts Most tap drill charts call out only one tap drill size, and that will produce an approximate 75 percent thread. For most applications, you can get longer tool life and lower likelihood of breaking a tap off in the hole by using a lower percent of thread. Companies like G-Wizard actually recommend 60% to 70% percentage of thread for most applications because it significantly lowers the torque force required to tap without giving up much thread strength. That's why these lower percentages are a better idea for your tap's tool life!

Thread Percentage vs Strength Chart Let's take a closer look at the relationship between torque and thread strength based on thread percentage. Red marks the typical 75% percent of thread average. Tap drill charts hands us, we're subjecting our poor taps to a huge amount of additional torque for very little extra strength! Is this all you wonder the daps give up and break on us after that kind of abuse? So what's the right way to choose a thread percentage and how do we get from there to a proper drill size? General Guidelines for Choosing Thread Percentage Try this approach, which is based on material and type of work: The material matters, because we can afford higher thread engagement in softer materials and we actually need to increase thread strength. For hard or tough materials, a lower percentage can really help tap life and those materials have lots of strength even at the lower percentages. In deeper holes, we run the most risk of breaking a tap and in sheet metal we need the strongest threads because there is much thread depth for holding power. Tapping Drill Size Problem #2: Form Taps vs Cut Taps Form Taps don't make any chips. This is a huge advantage when dealing with deep holes and especially for blind holes where chips can jam up in the bottom of the hole. Form Taps make stronger threads than Cut Taps. What could be better? Better Thread Gaging. Form taps work by cold forming the metal in the hole. Since no chips are made, the likelihood of producing oversized threads is far less than for Cut Taps. Stronger Taps. It just gets better and better—form taps are stronger and less likely to break than cut taps. Longer Tap Life. Form taps, properly used, can last 3 to 20 times longer than cutting taps because they have no cutting edge to dull. Faster Tapping. You can run higher spindle speeds with form taps than cut taps. In fact, the main disadvantage of Form Taps is they can't be used on materials that are too hard. The hardness limit for Form Taps is higher than you probably think (they're good for much more than aluminum), but there is a limit nonetheless. Given all that, you're definitely going to need to figure out Form Tap Drill Sizes first! Quick Tip: If you're wondering about the different types of thread taps, click the link for our complete guide. How Do I Go From Thread Percentages to Tap Drill Size? Well, you can't use a standard drill chart, that much is clear. You could calculate the optimal size for a particular percentage of thread and then go to a standard drill chart to find the nearest size. That works, but it is a fair amount of trouble. I promised you a better way, and here it is—you can use our G-Wizard Calculator's Thread Database to tell you exactly what you need to know, and it is very fast and easy to do. Let's walk through it: Go to the Thread Database in G-Wizard by selecting the Threads tab. Choose which thread you want. G-Wizard has a bunch of them in its database. In the lower left corner is a convenient table of tap sizes with a column showing thread percentage. You can even select Form or Cut Taps to change the drill size. Here's what it looks like: Tapping Drill Chart for 1/4-20 Thread Nice, huh? It saves people a lot of time. There's a whole ton of other very handy reference time savers there too, not to mention the world's best Feeds and Speeds Calculator. I've all but quit having to dig through my Machinery's Handbook to find information—I just use G-Wizard. Here's something else you can get lifetime access to all the reference calculators and materials except the Feeds and Speeds Calculator just by signing up for a Free Trial of G-Wizard. That's right, it is completely free to access all that just by signing up for a free trial and you'll also get all the upgrades and customer service for life! Plus, buy the \$79 version and you get up to 1 HP on the Feeds and Speeds too for life. So what's the catch? Why does anyone ever pay more than \$79? Many hobbyists don't pay more than \$79. BTW, the catch is a spindle power limit. When you buy the 1 year G-Wizard for \$79, you get 1 year of unlimited spindle power for Feeds and Speeds. When that expires, you get a spindle power limit of 1 HP. That limit is based on however many years you subscribe for. You can increase it any time you like by renewing the subscription. Or, if you don't like subscriptions, you can also by the product outright. And we never charge for updates or customer service. So go ahead, give G-Wizard free trial, a try. You'll be surprised at all the time it saves you on things like Tap Drill Sizes, not to mention the longer tool life, better surface finish, and shorter cycle times you'll get from better Feeds and Speeds. Bonus: Depth Clearance When Tapping Blind Holes. Blind Holes are particularly prone to breaking taps. It's harder to clear the chips for one thing, but the other thing is machinists don't leave enough clearance at the bottom of the hole. Most don't even know how much clearance they should be leaving. But, G-Wizard will calculate the clearance for you. Just one more way it's saving you time and trouble. Hey, What About that Free Drill Bit Size Chart? Here you go, Metric and Imperial sizes are called out in the "Use" column—the chart below. It's even an NPT Tap Drill Chart:





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