

Micro-Mark®

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TAPS & DIES

Taps and dies are numbered according to the below listed scale, where the beginning number refers to the diameter of the rod/hole. The diameter change (up or down in size) is always in increments of 13/1000", or 0.013".

00 = .047"
0 = .060"
1 = .073"
2 = .086"
3 = .099"
4 = .112"
5 = .125"
etc.

The second number refers to the number of threads per inch. So a 2-56 die is a die with a diameter of .086", and 56 threads per inch. Taps are measured the same, but the first number refers to the diameter of the hole it threads.

Tap Drill – drills holes

Tap – threads holes

Die – threads rod

Clearance Drill – makes a clearance hole for screw to pass through

THREADING WITH TAPS

TAP SIZE	00-90	0-80	1-72	2-56	3-48	4-40	6-32	8-32
Screw Body Diameter	.047"	.060"	.073"	.086"	.099"	.112"	.138"	.164"
Clearance Drill No.	55	52	48	43	39	33	28	19
Tap Drill No.	61	55	53	50	47	43	36	29

THREADING WITH DIES

Rod Size Required	.047" ^A (3/64")	.063" ^B (1/16")	.073" ^A	.086" ^A	.094" ^C (3/32")	.114" ^D	.140" ^D	.165" ^D
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^A Available in Micro-Mark #80816 Brass Rod Assortment

^B Micro-Mark #82638 1/16" x 12" Brass Rod

^C Micro-Mark #60227 3/32" x 12" Brass Rod

^D Not available from Micro-Mark