

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".

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|------------|
| 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" (3/64") | .063" ^A (1/16") | .073" | .086" | .094" ^B (3/32") | .114" | .140" | .165" |
|-------------------|------------------|-------------------------------|-------|-------|-------------------------------|-------|-------|-------|

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

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