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

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

THREADING WITH DIES

<table>
<thead>
<tr>
<th>Rod Size Required</th>
<th>0.047”</th>
<th>0.063”</th>
<th>0.073”</th>
<th>0.086”</th>
<th>0.094”</th>
<th>0.114”</th>
<th>0.140”</th>
<th>0.165”</th>
</tr>
</thead>
<tbody>
<tr>
<td>(3/64”)</td>
<td>(1/16”)</td>
<td>(3/32”)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Micro-Mark #82638 1/16” x 12” Brass Rod
*Micro-Mark #60227 3/32” x 12” Brass Rod