



# 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	$\frac{3}{16}$	$\frac{1}{8}$ -20	7	6	4
1-64	54	54	53	$\frac{1}{8}$ -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	$\frac{23}{64}$	$\frac{23}{64}$	$\frac{1}{8}$
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	$\frac{1}{2}$ -16	.631	.631	$\frac{41}{64}$
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 NPS		TAPER NPT	STRAIGHT NPS
$\frac{1}{8}$ -27	D	$\frac{1}{8}$	$\frac{3}{4}$ -14	$\frac{59}{64}$	$\frac{15}{16}$
$\frac{1}{8}$ -27	R	S	1-11-15	1- $\frac{3}{32}$	1- $\frac{3}{16}$
$\frac{1}{4}$ -18	$\frac{7}{16}$	$\frac{23}{64}$	1- $\frac{1}{4}$ -11-15	1-10	1- $\frac{23}{64}$
$\frac{3}{8}$ -18	$\frac{23}{64}$	$\frac{19}{32}$	1- $\frac{3}{8}$ -11-15	1- $\frac{43}{64}$	1- $\frac{3}{8}$
$\frac{1}{2}$ -14	$\frac{23}{32}$	$\frac{43}{64}$	2-11-15	2- $\frac{3}{32}$	2- $\frac{3}{16}$



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**R Bogdan**



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## **Table of Contents Tap Drill Sizes Morse Cutting Tools**

1. Understanding the eBook Tap Drill Sizes Morse Cutting Tools
  - The Rise of Digital Reading Tap Drill Sizes Morse Cutting Tools
  - Advantages of eBooks Over Traditional Books
2. Identifying Tap Drill Sizes Morse Cutting Tools
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Tap Drill Sizes Morse Cutting Tools
  - User-Friendly Interface
4. Exploring eBook Recommendations from Tap Drill Sizes Morse Cutting Tools
  - Personalized Recommendations
  - Tap Drill Sizes Morse Cutting Tools User Reviews and Ratings
  - Tap Drill Sizes Morse Cutting Tools and Bestseller Lists

5. Accessing Tap Drill Sizes Morse Cutting Tools Free and Paid eBooks
  - Tap Drill Sizes Morse Cutting Tools Public Domain eBooks
  - Tap Drill Sizes Morse Cutting Tools eBook Subscription Services
  - Tap Drill Sizes Morse Cutting Tools Budget-Friendly Options
6. Navigating Tap Drill Sizes Morse Cutting Tools eBook Formats
  - ePub, PDF, MOBI, and More
  - Tap Drill Sizes Morse Cutting Tools Compatibility with Devices
  - Tap Drill Sizes Morse Cutting Tools Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Tap Drill Sizes Morse Cutting Tools
  - Highlighting and Note-Taking Tap Drill Sizes Morse Cutting Tools
  - Interactive Elements Tap Drill Sizes Morse Cutting Tools
8. Staying Engaged with Tap Drill Sizes Morse Cutting Tools
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Tap Drill Sizes Morse Cutting Tools
9. Balancing eBooks and Physical Books Tap Drill Sizes Morse Cutting Tools
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Tap Drill Sizes Morse Cutting Tools
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Tap Drill Sizes Morse Cutting Tools
  - Setting Reading Goals Tap Drill Sizes Morse Cutting Tools
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Tap Drill Sizes Morse Cutting Tools
  - Fact-Checking eBook Content of Tap Drill Sizes Morse Cutting Tools
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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