



DRILL CHART WITH TAPPING AND REAMING DATA

CUSTOM MACHINERY

DRILL SIZE				DRILL RPM		REAM RPM		TAP DATA	
FRACTIONAL	NUMBER / LETTER	METRIC - MM	DECIMAL INCHES	@ 100 SFPM	@ 250 SFPM	@ 48 SFPM	@ 120 SFPM	UNIFIED NATIONAL	NPT, NPS & ACME
	80		0.014	28,294	70,735	13,581	33,953		
	79		0.015	26,343	65,857	12,645	31,611		
1/64			0.016	24,485	61,213	11,753	29,382		
	78		0.016	23,873	59,683	11,459	28,648		
	77		0.018	21,221	53,051	10,186	25,465		
		,5	0.020	19,389	48,473	9,307	23,267		
	76		0.020	19,099	47,746	9,167	22,918		
	75		0.021	18,189	45,473	8,731	21,827		
	74		0.023	16,976	42,441	8,149	20,372		
	73		0.024	15,915	39,789	7,639	19,099		
	72		0.025	15,279	38,197	7,334	18,335		
	71		0.026	14,691	36,728	7,052	17,629		
	70		0.028	13,642	34,104	6,548	16,370		
	69		0.029	13,081	32,703	6,279	15,697		
		,75	0.030	12,948	32,370	6,215	15,538		
	68		0.031	12,322	30,804	5,914	14,786		
1/32			0.031	12,243	30,607	5,876	14,691		
	67		0.032	11,937	29,841	5,730	14,324		
	66		0.033	11,575	28,937	5,556	13,890		
	65		0.035	10,913	27,284	5,238	13,096		
	64		0.036	10,610	26,526	5,093	12,732		
	63		0.037	10,324	25,809	4,955	12,388		
	62		0.038	10,052	25,130	4,825	12,062		
	61		0.039	9,794	24,485	4,701	11,753		
		1	0.039	9,695	24,237	4,653	11,634		

RCD Custom Machinery

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	60		0.040	9,549	23,873	4,584	11,459		
	59		0.041	9,316	23,291	4,472	11,180		
	58		0.042	9,095	22,736	4,365	10,913		
	57		0.043	8,883	22,208	4,264	10,660		
	56		0.047	8,214	20,536	3,943	9,857	0-80 NF	
3/64			0.047	8,144	20,361	3,909	9,773		
		1,25	0.049	7,764	19,409	3,727	9,316		
	55		0.052	7,346	18,364	3,526	8,815		
	54		0.055	6,945	17,362	3,334	8,334		
		1,5	0.059	6,463	16,158	3,102	7,756		
	53		0.060	6,420	16,049	3,081	7,704	1-64 NC	
1/16			0.063	6,112	15,279	2,934	7,334	1-72 NF	
	52		0.064	6,015	15,038	2,887	7,218		
	51		0.067	5,701	14,253	2,737	6,841		
		1,75	0.069	5,544	13,860	2,661	6,653		
	50		0.070	5,457	13,642	2,619	6,548	2-56 NC / 2-64 NF	
	49		0.073	5,232	13,081	2,512	6,279		
	48		0.076	5,026	12,565	2,412	6,031		
5/64			0.078	4,891	12,227	2,348	5,869		
	47		0.079	4,866	12,165	2,336	5,839	3-48 NC	
		2	0.079	4,853	12,134	2,330	5,824		
	46		0.081	4,716	11,789	2,264	5,659		
	45		0.082	4,658	11,645	2,236	5,590	3-56 NF	
	44		0.086	4,442	11,104	2,132	5,330		
		2,25	0.089	4,311	10,778	2,069	5,173		
	43		0.089	4,292	10,729	2,060	5,150	4-40 NC	
	42		0.094	4,085	10,213	1,961	4,902	4-48 NF	
3/32			0.094	4,072	10,180	1,955	4,887		
	41		0.096	3,979	9,947	1,910	4,775		
	40		0.098	3,898	9,744	1,871	4,677		
		2,5	0.098	3,882	9,705	1,863	4,658		
	39		0.100	3,839	9,597	1,843	4,607		
	38		0.102	3,763	9,408	1,806	4,516	5-40 NC	
	37		0.104	3,673	9,182	1,763	4,407	5-44 NF	
	36		0.107	3,587	8,966	1,722	4,304		
		2,75	0.108	3,527	8,817	1,693	4,232		

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7/64			0.109	3,491	8,729	1,676	4,190		
	35		0.110	3,472	8,681	1,667	4,167	6-32 NC	
	34		0.111	3,441	8,603	1,652	4,129		
	33		0.113	3,380	8,451	1,623	4,056	6-40 NF	
	32		0.116	3,293	8,232	1,581	3,951		
		3	0.118	3,234	8,086	1,552	3,881		
	31		0.120	3,183	7,958	1,528	3,820		
1/8			0.125	3,056	7,639	1,467	3,667		
		3,25	0.128	2,984	7,460	1,432	3,581		
	30		0.129	2,973	7,431	1,427	3,567		
	29		0.136	2,809	7,022	1,348	3,370	8-32 NC	
		3,5	0.138	2,772	6,930	1,331	3,326	8-36 NF	
	28		0.141	2,719	6,797	1,305	3,262		
9/64			0.141	2,717	6,792	1,304	3,260		
	27		0.144	2,653	6,631	1,273	3,183		
	26		0.147	2,598	6,496	1,247	3,118		
		3,75	0.148	2,588	6,470	1,242	3,105		
	25		0.150	2,555	6,387	1,226	3,066	10-24 NC	
	24		0.152	2,513	6,282	1,206	3,016		
	23		0.154	2,480	6,201	1,191	2,976		
5/32			0.156	2,445	6,113	1,174	2,934		
	22		0.157	2,433	6,082	1,168	2,920		
		4	0.158	2,425	6,063	1,164	2,910		
	21		0.159	2,402	6,006	1,153	2,883	10-32 NF	
	20		0.161	2,372	5,931	1,139	2,847		
	19		0.166	2,301	5,753	1,104	2,761		
		4,25	0.167	2,283	5,708	1,096	2,740		
	18		0.170	2,254	5,634	1,082	2,704		
11/64			0.172	2,222	5,555	1,067	2,666		
	17		0.173	2,208	5,520	1,060	2,650		
	16		0.177	2,158	5,395	1,036	2,590	12-24 NC	
		4,5	0.177	2,156	5,389	1,035	2,587		
	15		0.180	2,122	5,305	1,019	2,546		
	14		0.182	2,099	5,247	1,007	2,518	12-28 NF	
	13		0.185	2,065	5,162	991	2,478	12-32 NEF	
		4,75	0.187	2,043	5,107	980	2,451		

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3/16			0.188	2,037	5,093	978	2,445		
	12		0.189	2,021	5,053	970	2,425		
	11		0.191	2,000	5,000	960	2,400		
	10		0.194	1,974	4,935	948	2,369		
	9		0.196	1,949	4,872	935	2,339		
		5	0.197	1,940	4,850	931	2,328		
	8		0.199	1,919	4,799	921	2,303		
	7		0.201	1,900	4,751	912	2,280	1/4-20 UNC	
13/64			0.203	1,881	4,702	903	2,257		
	6		0.204	1,872	4,681	899	2,247		
	5		0.206	1,859	4,647	892	2,230		
		5,25	0.207	1,848	4,620	887	2,218		
	4		0.209	1,828	4,569	877	2,193		
	3		0.213	1,793	4,483	861	2,152	1/4-28 UNF	
		5,5	0.217	1,764	4,411	847	2,117		
7/32			0.219	1,746	4,364	838	2,095	1/4-32 NEF	
	2		0.221	1,728	4,321	830	2,074		
		5,75	0.226	1,687	4,218	810	2,025		
	1		0.228	1,675	4,188	804	2,010		
	A		0.234	1,632	4,081	784	1,959		
15/64			0.234	1,630	4,074	782	1,955		
		6	0.236	1,617	4,043	776	1,941		
	B		0.238	1,605	4,012	770	1,926		
	C		0.242	1,578	3,946	758	1,894		
	D		0.246	1,553	3,882	745	1,863		
		6,25	0.246	1,552	3,880	745	1,863		
1/4	E		0.250	1,528	3,820	733	1,833		
		6,5	0.256	1,493	3,732	716	1,791		
	F		0.257	1,486	3,716	713	1,784	5/16-18 NC	
	G		0.261	1,463	3,659	702	1,756		
17/64			0.266	1,438	3,595	690	1,726		
		6,75	0.266	1,438	3,594	690	1,725		
	H		0.266	1,436	3,590	689	1,723		
	I		0.272	1,404	3,511	674	1,685	5/16-24 NF	
		7	0.276	1,386	3,465	665	1,663		
	J		0.277	1,379	3,447	662	1,655		

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	K		0.281	1,359	3,398	652	1,631		
9/32			0.281	1,358	3,396	652	1,630	5/16-32 NEF	
		7,25	0.285	1,338	3,346	642	1,606		
	L		0.290	1,317	3,293	632	1,581		
	M		0.295	1,295	3,237	622	1,554		
		7,5	0.295	1,293	3,234	621	1,552		
19/64			0.297	1,287	3,216	618	1,544		
	N		0.302	1,265	3,162	607	1,518		3/8-12 ACME
		7,75	0.305	1,252	3,130	601	1,502		
5/16			0.313	1,222	3,056	587	1,467	3/-16 NC	
		8	0.315	1,213	3,032	582	1,455		
	O		0.316	1,209	3,022	580	1,451		
	P		0.323	1,183	2,956	568	1,419		
		8,25	0.325	1,176	2,940	564	1,411		
21/64			0.328	1,164	2,910	559	1,397		
	Q		0.332	1,151	2,876	552	1,381	3/8-24 NF	
		8,5	0.335	1,142	2,854	548	1,370		
	R		0.339	1,127	2,817	541	1,352		1/8-27 NPT
11/32			0.344	1,111	2,778	533	1,333		
		8,75	0.345	1,109	2,772	532	1,331		
	S		0.348	1,098	2,744	527	1,317		1/8-27 NPS
		9	0.354	1,078	2,695	517	1,294		
	T		0.358	1,067	2,667	512	1,280		
23/64			0.359	1,063	2,657	510	1,275		
		9,25	0.364	1,049	2,622	503	1,259		7/16-12 ACME
	U		0.368	1,038	2,595	498	1,246	7/16-14 NC	
		9,5	0.374	1,021	2,553	490	1,226		
3/8			0.375	1,019	2,546	489	1,222		
	V		0.377	1,013	2,533	486	1,216		
		9,75	0.384	995	2,487	478	1,194		
	W		0.386	990	2,474	475	1,187		
25/64			0.391	978	2,445	469	1,173	7/16-20 NF	
		10	0.394	970	2,426	466	1,164		
	X		0.397	962	2,405	462	1,155		
	Y		0.404	945	2,364	454	1,135		
13/32			0.406	940	2,350	451	1,128		1/2-10 ACME

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	Z		0.413	925	2,312	444	1,110		
		10,5	0.413	924	2,310	444	1,109		
27/64			0.422	905	2,263	435	1,086	1/2-13 NC	
		11	0.433	882	2,205	423	1,058		
7/16			0.438	873	2,183	419	1,048		1/4-18 NPT
		11,5	0.453	844	2,109	405	1,012		
29/64			0.453	843	2,108	405	1,012	1/2-20 NF	1/4-18 NPS
15/32			0.469	815	2,037	391	978		
		12	0.472	809	2,021	388	970		
31/64			0.484	789	1,971	379	946	9/16-12 NC	
		12,5	0.492	776	1,941	373	931		
1/2			0.500	764	1,910	367	917		
		13	0.512	746	1,866	358	896	5/8-8 ACME	5/8-8 ACME
33/64			0.516	741	1,852	356	889	9/16-18 NF	
17/32			0.531	719	1,798	345	863	5/8-11 NC	
		13,5	0.532	719	1,797	345	862		
35/64			0.547	698	1,746	335	838		
		14	0.551	693	1,732	333	832		
9/16			0.563	679	1,698	326	815		
		14,5	0.571	669	1,673	321	803		
37/64			0.578	661	1,652	317	793	5/8-18 NF	3/8-18 NPT
		15	0.591	647	1,617	310	776		
19/32			0.594	643	1,608	309	772		3/8-18 NPS
39/64			0.609	627	1,567	301	752		3/4-6 ACME
		15,5	0.610	626	1,565	300	751		
5/8			0.625	611	1,528	293	733		
		16	0.630	606	1,516	291	728		
41/64			0.641	596	1,491	286	716		
		16,5	0.650	588	1,470	282	706		
21/32			0.656	582	1,455	279	699	3/4-10 NC	
		17	0.669	571	1,427	274	685		
43/64			0.672	568	1,421	273	682		
11/16			0.688	556	1,389	267	667	3/4-16 NF	
		17,5	0.689	554	1,386	266	665		
45/64			0.703	543	1,358	261	652		
		18	0.709	539	1,347	259	647		

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23/32			0.719	531	1,328	255	638		1/2-14 NPT
		18,5	0.728	524	1,311	252	629		7/8-6 ACME
47/64			0.734	520	1,300	250	624		1/2-14 NPS
		19	0.748	511	1,277	245	613		
3/4			0.750	509	1,273	244	611		
49/64			0.766	499	1,247	239	599	7/8-9 NC	
		19,5	0.768	498	1,244	239	597		
25/32			0.781	489	1,222	235	587		
		20	0.787	485	1,213	233	582		
51/64			0.797	479	1,198	230	575		
		20,5	0.807	473	1,183	227	568		
13/16			0.813	470	1,175	226	564	7/8-14 NF	
		21	0.827	462	1,155	222	554		1"-5 ACME
53/64			0.828	461	1,153	221	554		
27/32			0.844	453	1,132	217	543		
		21,5	0.847	451	1,128	217	541		
55/64			0.859	444	1,111	213	533		
		22	0.866	441	1,103	212	529		
7/8			0.875	437	1,091	210	524	1"-8 NC	
		22,5	0.886	431	1,078	207	517		
57/64			0.891	429	1,072	206	515		
		23	0.906	422	1,055	202	506		
29/32			0.906	422	1,054	202	506		
59/64			0.922	414	1,036	199	497	1"-12 NF	3/4-14 NPT
		23,5	0.925	413	1,032	198	495		
15/16			0.938	407	1,019	196	489	1"-14 NS	3/4-14 NPS
		24	0.945	404	1,011	194	485		2 1/8"-5 ACME
61/64			0.953	401	1,002	192	481		
		24,5	0.965	396	990	190	475		
31/32			0.969	394	986	189	473		
		25	0.984	388	970	186	466		
63/64			0.984	388	970	186	466	1 1/8-7 NC	
1			1.000	382	955	183	458		
1-3/64"			1.046	365	913	175	438	1 1/8-12 NF	
1 5/64"			1.078	354	886	170	425		2 1/4-5 ACME
1-7/64"			1.109	344	861	165	413	1 1/4-7 NC	

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1 5/32"			1.156	330	826	159	397		1"-11.5 NPT
1-11/64"			1.172	326	815	156	391	1 1/4-12 NF	
1 3/16"			1.188	322	804	154	386		1"-11.5 NPS
1 7/32"			1.219	313	783	150	376	1 3/8-6 NC	
1 9/32"			1.281	298	745	143	358		2 1/2-4 ACME
1 19/64"			1.297	295	736	141	353	1 3/8-12 NF	
1 11/32"			1.343	284	711	137	341	1 1/2-6 NC	
1 27/64"			1.422	269	672	129	322	1 1/2-12 NF	