

## American National Standard Pipe

Pipe			Tapping Drills								
Size (in)	Threads/ Inch	Nom. OD (in)	Taper NPT w/ Reamer *			Taper NPT w/o Reamer			Straight NPS		
			Drill Size	Equivalents (in) (mm)		Drill Size	Equivalents (in) (mm)		Drill Size	Equivalents (in) (mm)	
1/16	27	0.313	15/64"	0.2344	5.9531	C	0.2420	6.1468	1/4"	0.2500	6.3500
1/8	27	0.405	21/64"	0.3281	8.3344	Q	0.3320	8.4328	11/32"	0.3438	8.7313
1/4	18	0.540	27/64"	0.4219	10.7156	7/16"	0.4375	11.1125	7/16"	0.4375	11.1125
3/8	18	0.675	9/16"	0.5625	14.2875	37/64"	0.5781	14.6844	19/32"	0.5938	15.0813
1/2	14	0.840	11/16"	0.6875	17.4625	45/64"	0.7031	17.8594	23/32"	0.7188	18.2563
3/4	14	1.050	57/64"	0.8906	22.6219	29/32"	0.9063	23.0188	15/16"	0.9375	23.8125
1	11-1/2	1.315	1-1/8"	1.1250	28.5750	1-9/32"	1.2813	32.5438	1-5/32"	1.1563	29.3688
1-1/4	11-1/2	1.660	1-15/32"	1.4688	37.3063	1-31/64"	1.4844	37.7031	1-1/2"	1.5000	38.1000
1-1/2	11-1/2	1.900	1-23/32"	1.7188	43.6563	1-23/32"	1.7188	43.6563	1-3/4"	1.7500	44.4500
2	11-1/2	2.375	2-5/32"	2.1563	54.7688	2-3/16"	2.1875	55.5625	2-3/16"	2.1875	55.5625
2-1/2	8	2.875	2-25/32"	2.7813	70.6438	2-5/8"	2.6250	66.6750	2-5/8"	2.6250	66.6750
3	8	3.500	3-9/32"	3.2813	83.3438	3-1/4"	3.2500	82.5500	3-1/4"	3.2500	82.5500
3-1/2	8	4.000	3-3/4"	3.7500	95.2500	3-3/4"	3.7500	95.2500	3-3/4"	3.7500	95.2500
4	8	4.500	4-1/4"	4.2500	107.9500	4-1/4"	4.2500	107.9500	4-1/4"	4.2500	107.9500
5	8	5.563	5-1/4"	5.2500	133.3500	5-9/32"	5.2813	134.1438	5-5/16"	5.3125	134.9375
6	8	6.625	6-1/4"	6.2500	158.7500	6-11/32"	6.3438	161.1313	6-3/8"	6.3750	161.9250
8	8	8.625									
10	8	10.750									
12	8	12.750									
14 (OD)	8	14.000									
16 (OD)	8	16.000									

\* Ream the hole before tapping with a reamer having a taper of 3/4 inch per foot.

**Pipe Size** is the accepted industry designation and does not refer to either the inside or the outside diameter (ID or OD) of a pipe or a fitting.

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Pipe		Schedule 10 **		Schedule 40 **		Schedule 80 **		Schedule 160 **	
Size	Nom. OD	ID	Wall Thick.	ID	Wall Thick.	ID	Wall Thick.	ID	Wall Thick.
(in)	(in)	(in)	(in)	(in)	(in)	(in)	(in)	(in)	(in)
1/8	0.405	0.307	0.049	0.269	0.068	0.215	0.095		
1/4	0.540	0.410	0.065	0.364	0.088	0.302	0.119		
3/8	0.675	0.545	0.083	0.493	0.091	0.423	0.126		
1/2	0.840	0.674	0.083	0.622	0.109	0.546	0.147	0.466	0.187
3/4	1.050	0.884	0.109	0.824	0.113	0.742	0.154	0.614	0.218
1	1.315	1.097	0.109	1.049	0.133	0.957	0.179	0.815	0.250
1-1/4	1.660	1.442	0.109	1.380	0.140	1.278	0.191	1.160	0.250
1-1/2	1.900	1.682	0.109	1.610	0.145	1.500	0.200	1.338	0.281
2	2.375	2.157	0.109	2.067	0.154	1.939	0.218	1.689	0.343
2-1/2	2.875	2.635	0.120	2.469	0.203	2.323	0.276	2.125	0.375
3	3.500	3.260	0.120	3.068	0.216	2.900	0.300	2.626	0.437
4	4.500	4.260	0.120	4.026	0.237	3.826	0.337	3.438	0.531
5	5.563	5.295	0.134	5.047	0.258	4.813	0.375	4.313	0.625
6	6.625	6.357	0.134	6.065	0.280	5.761	0.432	5.189	0.718
8	8.625	8.329	0.148	7.981	0.322	7.625	0.500	6.813	0.906

\*\* Because of differing manufacturing methods and tolerances, pipe ID and wall thickness may vary slightly from the values given.

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