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NPS	Threads per inch	Tap drill (approx.)
1/8	27	11/32 in
1/4	18	7/16 in
3/8	18	37/64 in
1/2	14	23/32 in
3/4	14	59/64 in
1	11.5	1-5/32 in
1-1/4	11.5	1-1/2 in
1-1/2	11.5	1-47/64 in
2	11.5	2-7/32 in