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Starrett

DECIMAL EQUIVALENTS

INCH/METRIC TAP DRILL SIZES & DECIMAL EQUIVALENTS

INCH DRILL	DECIMAL EQUIVALENT	TAP #/IN	METRIC TAP	METRIC TAP DRILL SIZES	DECIMAL (mm)
10	.5030	3/4 - 10	M1.5 x 0.35	1.25	.0482
11	.5032		M1.5 x 0.35	1.45	.0571
12	.5034		M2 x 0.4	1.60	.0630
13	.5036		M2.2 x 0.45	1.75	.0689
16	.5040	3/4 - 16	M2.5 x 0.45	2.05	.0807
18	.5042		M3 x 0.5	2.50	.0884
20	.5044		M3.5 x 0.6	2.90	.1142
22	.5046		M4 x 0.7	3.30	.1299
24	.5048	7/8 - 8	M4.5 x 0.75	3.70	.1457
26	.5050		M5 x 0.8	4.20	.1604
28	.5052		M6 x 1	5.00	.1900
30	.5054		M7 x 1	6.00	.2362
32	.5056	7/8 - 14	M8 x 1.25	6.70	.2638
34	.5058		M8 x 1	7.00	.2756
36	.5060		M10 x 1.5	8.50	.3348
38	.5062		M10 x 1.25	8.70	.3426
40	.5064	1 - 8	M12 x 1.75	10.20	.4019
42	.5066		M12 x 1.25	10.80	.4252
44	.5068		M14 x 2	12.00	.4724
46	.5070		M14 x 1.5	12.50	.4921
48	.5072	1 - 12	M16 x 2	14.00	.5512
50	.5074		M16 x 1.5	14.50	.5709
52	.5076		M18 x 2.5	15.50	.6102
54	.5078		M18 x 1.5	16.50	.6486
56	.5080	1 - 14	M20 x 2.5	17.50	.6890
58	.5082		M20 x 1.5	18.50	.7283
60	.5084		M22 x 2.5	19.50	.7677
62	.5086		M22 x 1.5	20.50	.8071
1 1/16	1.0000	1 1/8 - 7	M24 x 3	21.00	.8288
1 1/8	1.0400		M24 x 2	22.00	.8661
1 1/4	1.0900		M27 x 3	24.00	.9449
1 1/2	1.1400		M27 x 2	25.00	.9843
1 3/8	1.1800	1 1/8 - 12	M30 x 3.5	26.50	1.0433
1 1/2	1.2000		M30 x 2	28.00	1.1024
1 5/8	1.2500		M33 x 3.5	29.50	1.1614
1 3/4	1.3100		M33 x 2	31.00	1.2206
1 7/8	1.3700	1 1/2 - 6	M36 x 4	32.00	1.2686
2	1.4200		M36 x 3	33.00	1.2892
2 1/4	1.4700		M39 x 4	35.00	1.3780
2 1/2	1.5200		M39 x 3	36.00	1.4173
2 3/4	1.5700	1 1/2 - 12	M42 x 4	37.00	
3	1.6200		M42 x 3	38.00	
3 1/4	1.6700		M45 x 4	39.00	
3 1/2	1.7200		M45 x 3	40.00	
3 3/4	1.7700	1 3/4 - 4	M48 x 5	41.00	
4	1.8200		M48 x 4	42.00	
4 1/4	1.8700		M51 x 5	43.00	
4 1/2	1.9200		M51 x 4	44.00	
4 3/4	1.9700	1 3/4 - 6	M54 x 5	45.00	
5	2.0200		M54 x 4	46.00	
5 1/4	2.0700		M57 x 5	47.00	
5 1/2	2.1200		M57 x 4	48.00	
5 3/4	2.1700	1 3/4 - 8	M60 x 5	49.00	
6	2.2200		M60 x 4	50.00	
6 1/4	2.2700		M63 x 5	51.00	
6 1/2	2.3200		M63 x 4	52.00	
6 3/4	2.3700	1 3/4 - 10	M66 x 5	53.00	
7	2.4200		M66 x 4	54.00	
7 1/4	2.4700		M69 x 5	55.00	
7 1/2	2.5200		M69 x 4	56.00	
7 3/4	2.5700	1 3/4 - 12	M72 x 5	57.00	
8	2.6200		M72 x 4	58.00	
8 1/4	2.6700		M75 x 5	59.00	
8 1/2	2.7200		M75 x 4	60.00	
8 3/4	2.7700	1 3/4 - 14	M78 x 5	61.00	
9	2.8200		M78 x 4	62.00	
9 1/4	2.8700		M81 x 5	63.00	
9 1/2	2.9200		M81 x 4	64.00	
9 3/4	2.9700	1 3/4 - 16	M84 x 5	65.00	
10	3.0200		M84 x 4	66.00	
10 1/4	3.0700		M87 x 5	67.00	
10 1/2	3.1200		M87 x 4	68.00	
10 3/4	3.1700	1 3/4 - 18	M90 x 5	69.00	
11	3.2200		M90 x 4	70.00	
11 1/4	3.2700		M93 x 5	71.00	
11 1/2	3.3200		M93 x 4	72.00	
11 3/4	3.3700	1 3/4 - 20	M96 x 5	73.00	
12	3.4200		M96 x 4	74.00	
12 1/4	3.4700		M99 x 5	75.00	
12 1/2	3.5200		M99 x 4	76.00	
12 3/4	3.5700	1 3/4 - 22	M102 x 5	77.00	
13	3.6200		M102 x 4	78.00	
13 1/4	3.6700		M105 x 5	79.00	
13 1/2	3.7200		M105 x 4	80.00	
13 3/4	3.7700	1 3/4 - 24	M108 x 5	81.00	
14	3.8200		M108 x 4	82.00	
14 1/4	3.8700		M111 x 5	83.00	
14 1/2	3.9200		M111 x 4	84.00	
14 3/4	3.9700	1 3/4 - 26	M114 x 5	85.00	
15	4.0200		M114 x 4	86.00	
15 1/4	4.0700		M117 x 5	87.00	
15 1/2	4.1200		M117 x 4	88.00	
15 3/4	4.1700	1 3/4 - 28	M120 x 5	89.00	
16	4.2200		M120 x 4	90.00	
16 1/4	4.2700		M123 x 5	91.00	
16 1/2	4.3200		M123 x 4	92.00	
16 3/4	4.3700	1 3/4 - 30	M126 x 5	93.00	
17	4.4200		M126 x 4	94.00	
17 1/4	4.4700		M129 x 5	95.00	
17 1/2	4.5200		M129 x 4	96.00	
17 3/4	4.5700	1 3/4 - 32	M132 x 5	97.00	
18	4.6200		M132 x 4	98.00	
18 1/4	4.6700		M135 x 5	99.00	
18 1/2	4.7200		M135 x 4	100.00	
18 3/4	4.7700	1 3/4 - 34	M138 x 5	101.00	
19	4.8200		M138 x 4	102.00	
19 1/4	4.8700		M141 x 5	103.00	
19 1/2	4.9200		M141 x 4	104.00	
19 3/4	4.9700	1 3/4 - 36	M144 x 5	105.00	
20	5.0200		M144 x 4	106.00	
20 1/4	5.0700		M147 x 5	107.00	
20 1/2	5.1200		M147 x 4	108.00	
20 3/4	5.1700	1 3/4 - 38	M150 x 5	109.00	
21	5.2200		M150 x 4	110.00	
21 1/4	5.2700		M153 x 5	111.00	
21 1/2	5.3200		M153 x 4	112.00	
21 3/4	5.3700	1 3/4 - 40	M156 x 5	113.00	
22	5.4200		M156 x 4	114.00	
22 1/4	5.4700		M159 x 5	115.00	
22 1/2	5.5200		M159 x 4	116.00	
22 3/4	5.5700	1 3/4 - 42	M162 x 5	117.00	
23	5.6200		M162 x 4	118.00	
23 1/4	5.6700		M165 x 5	119.00	
23 1/2	5.7200		M165 x 4	120.00	
23 3/4	5.7700	1 3/4 - 44	M168 x 5	121.00	
24	5.8200		M168 x 4	122.00	
24 1/4	5.8700		M171 x 5	123.00	
24 1/2	5.9200		M171 x 4	124.00	
24 3/4	5.9700	1 3/4 - 46	M174 x 5	125.00	
25	6.0200		M174 x 4	126.00	
25 1/4	6.0700		M177 x 5	127.00	
25 1/2	6.1200		M177 x 4	128.00	
25 3/4	6.1700	1 3/4 - 48	M180 x 5	129.00	
26	6.2200		M180 x 4	130.00	
26 1/4	6.2700		M183 x 5	131.00	
26 1/2	6.3200		M183 x 4	132.00	
26 3/4	6.3700	1 3/4 - 50	M186 x 5	133.00	
27	6.4200		M186 x 4	134.00	
27 1/4	6.4700		M189 x 5	135.00	
27 1/2	6.5200		M189 x 4	136.00	
27 3/4	6.5700	1 3/4 - 52	M192 x 5	137.00	
28	6.6200		M192 x 4	138.00	
28 1/4	6.6700		M195 x 5	139.00	
28 1/2	6.7200		M195 x 4	140.00	
28 3/4	6.7700	1 3/4 - 54	M198 x 5	141.00	
29	6.8200		M198 x 4	142.00	
29 1/4	6.8700		M201 x 5	143.00	
29 1/2	6.9200		M201 x 4	144.00	
29 3/4	6.9700	1 3/4 - 56	M204 x 5	145.00	
30	7.0200		M204 x 4	146.00	
30 1/4	7.0700		M207 x 5	147.00	
30 1/2	7.1200		M207 x 4	148.00	
30 3/4	7.1700	1 3/4 - 58	M210 x 5	149.00	
31	7.2200		M210 x 4	150.00	
31 1/4	7.2700		M213 x 5	151.00	
31 1/2	7.3200		M213 x 4	152.00	
31 3/4	7.3700	1 3/4 - 60	M216 x 5	153.00	
32	7.4200		M216 x 4	154.00	
32 1/4	7.4700		M219 x 5	155.00	
32 1/2	7.5200		M219 x 4	156.00	
32 3/4	7.5700	1 3/4 - 62	M222 x 5	157.00	
33	7.6200		M222 x 4	158.00	
33 1/4	7.6700		M225 x 5	159.00	
33 1/2	7.7200		M225 x 4	160.00	
33 3/4	7.7700	1 3/4 - 64	M228 x 5	161.00	
34	7.8200		M228 x 4	162.00	
34 1/4	7.8700		M231 x 5	163.00	
34 1/2	7.9200		M231 x 4	164.00	
34 3/4	7.9700	1 3/4 - 66	M234 x 5	165.00	
35	8.0200		M234 x 4	166.00	
35 1/4	8.0700		M237 x 5	167.00	
35 1/2	8.1200		M237 x 4	168.00	
35 3/4	8.1700	1 3/4 - 68	M240 x 5	169.00	
36	8.2200		M240 x 4	170.00	
36 1/4	8.2700		M243 x 5	171.00	
36 1/2	8.3200		M243 x 4	172.00	
36 3/4	8.3700	1 3/4 - 70	M246 x 5	173.00	
37	8.4200		M246 x 4	174.00	
37 1/4	8.4700		M249 x 5	175.00	
37 1/2	8.5200		M249 x 4	176.00	
37 3/4	8.5700	1 3/4 - 72	M252 x 5	177.00	
38	8.6200		M252 x 4	178.00	
38 1/4	8.6700		M255 x 5	179.00	
38 1/2	8.7200		M255 x 4	180.00	
38 3/4	8.7700	1 3/4 - 74	M258 x 5	181.00	
39	8.8200		M258 x 4	182.00	
39 1/4	8.8700		M261 x 5	183.00	
39 1/2	8.9200		M261 x 4	184.00	
39 3/4	8.9700	1 3/4 - 76	M264 x 5	185.00	
40	9.0200		M264 x 4	186.00	
40 1/4	9.0700		M267 x 5	187.00	
40 1/2	9.1200		M267 x 4	188.00	
40 3/4	9.1700	1 3/4 - 78	M270 x 5	189.00	
41	9.2200		M270 x 4	190.00	
41 1/4	9.2700		M273 x 5	191.00	
41 1/2	9.3200		M273 x 4	192.00	
41 3/4	9.3700	1 3/4 - 80	M276 x 5	193.00	
42	9.4200		M276 x 4	194.00	
42 1/4	9.4700		M279 x 5	195.00	
42 1/2	9.5200		M279 x 4	196.00	
42 3/4	9.5700	1 3/4 - 82	M282 x 5	197.00	
43	9.6200		M282 x 4	198.00	
43 1/4	9.6700		M285 x 5	199.00	
43 1/2	9.7200		M285 x 4	200.00	
43 3/4	9.7700	1 3/4 - 84	M288 x 5	201.00	
44	9.8200		M288 x 4	202.00	
44 1/4	9.8700		M291 x 5	203.00	
44 1/2	9.9200		M291 x 4	204.00	
44 3/4	9.9700	1 3/4 - 86	M294 x 5	205.00	
45	10.0200		M294 x 4	206.00	
45 1/4	10.0700		M297 x 5	207.00	
45 1/2	10.1200		M297 x 4	208.00	
45 3/4	10.1700	1 3/4 - 88	M300 x 5	209.00	
46	10.2200		M300 x 4	210.00	
46 1/4	10.2700		M303 x 5	211.00	
46 1/2	10.3200		M303 x 4	212.00	
46 3/4	10.3700	1 3/4 - 90	M306 x 5	213.00	
47	10.4200		M306 x 4	214.00	
47 1/4	10.4700		M309 x 5	215.00	
47 1/2	10.5200		M309 x		

RIGHT TRIANGLES			OBLIQUE TRIANGLES		
TO FIND SIDES	FORMULAS		TO FIND	KNOWN	SOLUTION
a	$\sqrt{b^2 + c^2}$		C	A-B	$180^\circ - (A + B)$
a	$c \times \text{Cosec. } C$	$\frac{c}{\sin C}$	b	a-B-A	$\frac{a \times \sin. B}{\sin. A}$
a	$c \times \text{Secant } B$	$\frac{c}{\cosine B}$	c	a-A-C	$\frac{a \times \sin. C}{\sin. A}$
a	$b \times \text{Cosec. } B'$	$\frac{b}{\sin B}$	Tan. A	a-C-b	$\frac{a \times \sin. C}{b - (a \times \cos. C)}$
a	$b \times \text{Secant } C$	$\frac{b}{\cosine C}$	B	A-C	$180^\circ - (A + C)$
b	$\sqrt{a^2 - c^2}$		Sin. B	b-A-a	$\frac{b \times \sin. A}{a}$
b	$a \times \sin B$	$\frac{a}{\text{Cosecant } B}$	A	B-C	$180^\circ - (B + C)$
b	$a \times \cos. C$	$\frac{a}{\text{Secant } C}$	Cos. A	a-b-c	$\frac{b^2 + c^2 - a^2}{2bc}$
b	$c \times \tan. B$	$\frac{c}{\text{Cotangent } B}$	Sin. C	c-A-a	$\frac{c \times \sin. A}{a}$
b	$c \times \cot. C$	$\frac{c}{\text{Tangent } C}$	Cot. B	a-C-b	$\frac{a \times \csc C}{b} - \cot. C$
c	$\sqrt{a^2 - b^2}$		c	b-C-B	$b \times \sin. C \times \csc B$
c	$a \times \cos. B$	$\frac{a}{\text{Secant } B}$			
c	$a \times \sin C$	$\frac{a}{\text{Cosecant } C}$			
c	$b \times \cot. B$	$\frac{b}{\text{Tangent } B}$			
c	$b \times \tan C$	$\frac{b}{\text{Cotangent } C}$			

Feeds and Speeds for High Speed Steel Drills, Reamers and Taps										
MATERIAL	BRINELL	DRILLS			REAMERS		TAPS —S.F.M.			
		S.F.M.	POINT	FEED+	S.F.M.	FEED	THREADS PER INCH			
							3-7½	8-15	16-24	25-UP
Aluminum	99-101	200-250	118°	M	150-160	M	50	100	150	200
Aluminum Bronze	170-187	60	118°	M	40-45	M	12	25	45	60
Bakelite	—	80	60°-90°	M	50-60	M	50	100	150	200
Brass	192-202	200-250	118°	H	150-160	H	50	100	150	200
Bronze, common	166-183	200-250	118°	H	150-160	H	40	80	100	150
Bronze, phosphor, 1/2 hard	187-202	175-180	118°	M	130-140	M	25	40	50	80
Bronze, phosphor, soft	149-163	200-250	118°	H	150-160	H	40	80	100	150
Cast iron, soft	126	140-150	90°	H	100-110	H	30	60	90	140
Cast iron, medium soft	196	80-110	118°	M	50-65	M	25	40	50	80
Cast iron, hard	293-302	45-50	118°	L	67-75	L	10	20	30	40
Cast iron, chilled*	402	15	150°	L	8-10	L	5	5	10	10
Cast steel	286-302	40-50	118°	L	70-75	L	20	30	40	50
Celluloid	—	100	90°	M	75-80	M	50	100	150	200
Copper	80-85	70	100°	L	45-55	L	40	80	100	150
Drop forgings (steel)	170-196	60	118°	M	40-45	M	12	25	45	60
Duralumin	90-104	200	118°	M	150-160	M	50	100	150	200
Everdur	179-207	60	118°	L	40-45	L	20	30	40	50
Machinery steel	170-196	110	118°	H	67-75	H	35	50	60	85
Magnet steel, soft	241-302	35-40	118°	M	20-25	M	20	40	50	75
Magnet steel, hard*	321-512	15	150°	L	10	L	5	10	15	25
Manganese steel, 7-13%*	187-217	15	150°	L	10	L	15	20	25	30
Manganese copper, 30% Mn.*	134	15	150°	L	10-12	L	—	—	—	—
Malleable iron	112-126	85-90	118°	H	—	H	20	30	40	50
Mild steel, 20-30C	170-202	110-120	118°	H	75-85	H	40	55	70	90
Molybdenum steel	196-235	5	125°	M	35-45	M	20	30	35	45
Monel metal	149-170	50	188°	M	35-38	M	8	10	15	20
Nickel, pure*	187-202	75	118°	L	40	L	25	40	50	80
Nickel steel, 31/2%	196-241	60	118°	L	40-45	L	8	10	15	20
Rubber, hard	—	100	60°-90°	L	70-80	L	50	100	150	200
Screw stock, C.R.	170-196	110	118°	H	75	H	20	30	40	50
Spring steel	402	20	150°	L	12-15	L	10	10	15	15
Stainless steel	146-149	50	118°	M	30	M	8	10	15	20
Stainless steel, C.R.*	460-477	20	118°	L	15	L	8	10	15	20
Steel, 40 to .50C	170-196	80	118°	M	8-10	M	20	30	40	50
Tool, S.A.E., and Forging steel	149	75	118°	H	35-40	H	25	35	45	55
Tool, S.A.E., and Forging steel	241	50	125°	M	12	M	15	15	25	25
Tool, S.A.E., and Forging steel*	402	15	150°	L	10	L	8	10	15	20
Zinc alloy	112-126	200-250	118°	M	150-175	M	50	100	150	200

* Use specially constructed heavy duty drills.

Carbon steel tools should be run at speeds of 40% to 50% of those recommended for High Speed.

Spiral Point Taps may be run at speeds 15% to 20% faster than regular Taps.

— See chart below for recommended feed rates.

Drill Feed Per Revolution (In Inches)					Reamer Feeds	
FEED REFERENCE SYMBOL (See chart above for recommended feed)	DIAMETER OF DRILL — INCHES				OVER 1" DIAMETER	ALL DIAMETERS
	UNDER 1/8"	1/8" TO 1/4"	1/4" TO 1/2"	1/2" TO 1"		
L — Light	.001	.002	.003	.005	.006	Use a feed equal to two or three times that recommended for Drills.
M — Medium	.0015	.003	.006	.010	.012	
H — Heavy	.0025	.005	.010	.020	.025	

Drill Feed Per Revolution (in Inches)						Reamer Feeds					
FEED REFERENCE SYMBOL. (See chart above for recommended feed)	DIAMETER OF DRILL — INCHES					ALL DIAMETERS					
	UNDER 1/8"	1/8" TO 1/4"	1/4" TO 1/2"	1/2" TO 1"	OVER 1" DIAMETER						
L — Light	.001	.002	.003	.005	.006	Use a feed equal to two or three times that recommended for Drills.					
M — Medium	.0015	.003	.006	.010	.012						
H — Heavy	.0025	.005	.010	.020	.025						

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