

How to determine what size hole to drill for:

## Special Pitch Taps

Calculated the **Tap DIAMETER** minus **.974"** divided by the **pitch (TPI)**

**For Example: 3/8 - 32**

$$.375" - (.974" / 32) = .345"$$

**Use drill size closest to .345"**

## For METRIC Special Taps

Subtract the **PITCH** from the **TAP DIAMETER**

**For Example: 10MM x 1.5**

$$10 - 1.5 = 8.5$$

**Use drill size closest to 8.5MM**