

Tap & Clearance Drill Sizes				Tap Drill				Clearance Drill			
Screw Size	Major Diameter	Threads Per Inch	Minor Diameter	75% Thread for Aluminum, Brass, & Plastics		50% Thread for Steel, Stainless, & Iron		Close Fit		Free Fit	
				Drill Size	Dec. Eq.	Drill Size	Dec. Eq.	Drill Size	Dec. Eq.	Drill Size	Dec. Eq.
0	.0600	80	.0447	3/64	.0469	55	.0520	52	.0635	50	.0700
1	.0730	64	.0538	53	.0595	1/16	.0625	48	.0760	46	.0810
		72	.0560	53	.0595	52	.0635				
2	.0860	56	.0641	50	.0700	49	.0730	43	.0890	41	.0960
		64	.0668	50	.0700	48	.0760				
3	.0990	48	.0734	47	.0785	44	.0860	37	.1040	35	.1100
		56	.0771	45	.0820	43	.0890				
4	.1120	40	.0813	43	.0890	41	.0960	32	.1160	30	.1285
		48	.0864	42	.0935	40	.0980				
5	.125	40	.0943	38	.1015	7/64	.1094	30	.1285	29	.1360
		44	.0971	37	.1040	35	.1100				
6	.138	32	.0997	36	.1065	32	.1160	27	.1440	25	.1495
		40	.1073	33	.1130	31	.1200				
8	.1640	32	.1257	29	.1360	27	.1440	18	.1695	16	.1770
		36	.1299	29	.1360	26	.1470				
10	.1900	24	.1389	25	.1495	20	.1610	9	.1960	7	.2010
		32	.1517	21	.1590	18	.1695				
12	.2160	24	.1649	16	.1770	12	.1890	2	.2210	1	.2280
		28	.1722	14	.1820	10	.1935				
		32	.1777	13	.1850	9	.1960				
1/4	.2500	20	.1887	7	.2010	7/32	.2188	F	.2570	H	.2660
		28	.2062	3	.2130	1	.2280				
		32	.2117	7/32	.2188	1	.2280				
5/16	.3125	18	.2443	F	.2570	J	.2770	P	.3230	Q	.3320
		24	.2614	I	.2720	9/32	.2812				
		32	.2742	9/32	.2812	L	.2900				
3/8	.3750	16	.2983	5/16	.3125	Q	.3320	W	.3860	X	.3970
		24	.3239	Q	.3320	S	.3480				
		32	.3367	11/32	.3438	T	.3580				
7/16	.4375	14	.3499	U	.3680	25/64	.3906	29/64	.4531	15/32	.4687
		20	.3762	25/64	.3906	13/32	.4062				
		28	.3937	Y	.4040	Z	.4130				
1/2	.5000	13	.4056	27/64	.4219	29/64	.4531	33/64	.5156	17/32	.5312
		20	.4387	29/64	.4531	15/32	.4688				
		28	.4562	15/32	.4688	15/32	.4688				
9/16	.5625	12	.4603	31/64	.4844	33/64	.5156	37/64	.5781	19/32	.5938
		18	.4943	33/64	.5156	17/32	.5312				
		24	.5114	33/64	.5156	17/32	.5312				
5/8	.6250	11	.5135	17/32	.5312	9/16	.5625	41/64	.6406	21/32	.6562
		18	.5568	37/64	.5781	19/32	.5938				
		24	.5739	37/64	.5781	19/32	.5938				
11/16	.6875	24	.6364	41/64	.6406	21/32	.6562	45/64	.7031	23/32	.7188
3/4	.7500	10	.6273	21/32	.6562	11/16	.6875	49/64	.7656	25/32	.7812
		16	.6733	11/16	.6875	45/64	.7031				
		20	.6887	45/64	.7031	23/32	.7188				
13/16	.8125	20	.7512	49/64	.7656	25/32	.7812	53/64	.8281	27/32	.8438
7/8	.8750	9	.7387	49/64	.7656	51/64	.7969	57/64	.8906	29/32	.9062
		14	.7874	13/16	.8125	53/64	.8281				
		20	.8137	53/64	.8281	27/32	.8438				
15/16	.9375	20	.8762	57/64	.8906	29/32	.9062	61/64	.9531	31/32	.9688
1	1.000	8	.8466	7/8	.8750	59/64	.9219	1-1/64	1.0156	1-1/32	1.0313
		12	.8978	15/16	.9375	61/64	.9531				
		20	.9387	61/64	.9531	31/32	.9688				

DRILL SIZE	DECIMAL	MM.	DRILL SIZE	DECIMAL	MM.	DRILL SIZE	DECIMAL	MM.	DRILL SIZE	DECIMAL	MM.
80	.0135	.343	43	.0890	2.261	8	.1990	5.055	25/64	.3906	9.922
79	.0145	.368	42	.0935	2.375	7	.2010	5.105	X	.3970	10.084
1/64	.0156	.397	3/32	.0938	2.380	13/64	.2031	5.159	Y	.4040	10.262
78	.0160	.406	41	.0960	2.438	6	.2040	5.182	13/32	.4062	10.319
77	.0180	.457	40	.0980	2.489	5	.2055	5.220	Z	.4130	10.490
76	.0200	.508	39	.0995	2.527	4	.2090	5.309	27/64	.4219	10.716
75	.0210	.533	38	.1015	2.578	3	.2130	5.410	7/16	.4375	11.113
74	.0225	.572	37	.1040	2.642	7/32	.2188	5.556	29/64	.4531	11.509
73	.0240	.610	36	.1065	2.705	2	.2210	5.613	15/32	.4688	11.906
72	.0250	.635	7/64	.1094	2.778	1	.2280	5.791	31/64	.4844	12.303
71	.0260	.660	35	.1100	2.794	A	.2340	5.944	1/2	.5000	12.700
70	.0280	.711	34	.1110	2.819	15/64	.2344	5.953	33/64	.5156	13.097
69	.0292	.742	33	.1130	2.870	B	.2380	6.045	17/32	.5313	13.494
68	.0310	.787	32	.1160	2.946	C	.2420	6.147	35/64	.5469	13.890
1/32	.0313	.794	31	.1200	3.048	D	.2460	6.248	9/16	.5625	14.287
67	.0320	.813	1/8	.1250	3.175	1/4 E	.2500	6.350	37/64	.5781	14.684
66	.0330	.838	30	.1285	3.264	F	.2570	6.528	19/32	.5938	15.081
65	.0350	.889	29	.1360	3.454	G	.2610	6.629	39/64	.6094	15.478
64	.0360	.914	28	.1405	3.569	17/64	.2656	6.747	5/8	.6250	15.875
63	.0370	.940	9/64	.1406	3.572	H	.2660	6.756	41/64	.6406	16.272
62	.0380	.965	27	.1440	3.658	I	.2720	6.909	21/32	.6562	16.669
61	.0390	.991	26	.1470	3.734	J	.2770	7.036	43/64	.6719	17.065
60	.0400	1.016	25	.1495	3.797	K	.2810	7.137	11/16	.6875	17.462
59	.0410	1.041	24	.1520	3.861	9/32	.2812	7.144	45/64	.7031	17.859
58	.0420	1.067	23	.1540	3.912	L	.2900	7.366	23/32	.7188	18.256
57	.0430	1.092	5/32	.1562	3.969	M	.2950	7.493	47/64	.7344	18.653
56	.0465	1.181	22	.1570	3.988	19/64	.2969	7.541	3/4	.7500	19.050
3/64	.0469	1.191	21	.1590	4.039	N	.3020	7.671	49/64	.7656	19.447
55	.0520	1.321	20	.1610	4.089	5/16	.3125	7.937	25/32	.7812	19.844
54	.0550	1.397	19	.1660	4.216	O	.3160	8.026	51/64	.7969	20.240
53	.0595	1.511	18	.1695	4.305	P	.3230	8.204	13/16	.8125	20.637
1/16	.0625	1.587	11/64	.1719	4.366	21/64	.3281	8.334	53/64	.8281	21.034
52	.0635	1.613	17	.1730	4.394	Q	.3320	8.433	27/32	.8438	21.431
51	.0670	1.702	16	.1770	4.496	R	.3390	8.611	55/64	.8594	21.828
50	.0700	1.778	15	.1800	4.572	11/32	.3438	8.731	7/8	.8750	22.225
49	.0730	1.854	14	.1820	4.623	S	.3480	8.839	57/64	.8906	22.622
48	.0760	1.930	13	.1850	4.699	T	.3580	9.093	29/32	.9062	23.019
5/64	.0781	1.984	3/16	.1875	4.762	23/64	.3594	9.128	59/64	.9219	23.415
47	.0785	1.994	12	.1890	4.801	U	.3680	9.347	15/16	.9375	23.812
46	.0810	2.057	11	.1910	4.851	3/8	.3750	9.525	61/64	.9531	24.209
45	.0820	2.083	10	.1935	4.915	V	.3770	9.576	31/32	.9688	24.606
44	.0860	2.184	9	.1960	4.978	W	.3860	9.804	63/64	.9844	25.003
									1	1.000	25.400

FRACTIONAL SIZES

WIRE GAUGE SIZES

LETTER SIZES

Metric Tap & Clearance Drill Sizes		Tap Drill				Clearance Drill			
		75% Thread for Aluminum, Brass, & Plastics		50% Thread for Steel, Stainless, & Iron		Close Fit		Standard Fit	
Screw Size (mm)	Thread Pitch (mm)	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American Drill
M1.5	0.35	1.15	56	1.25	55	1.60	1/16	1.65	52
M1.6	0.35	1.25	55	1.35	54	1.70	51	1.75	50
M 1.8	0.35	1.45	53	1.55	1/16	1.90	49	2.00	5/64
M 2	0.45	1.55	1/16	1.70	51	2.10	45	2.20	44
	0.40	1.60	52	1.75	50				
M 2.2	0.45	1.75	50	1.90	48	2.30	3/32	2.40	41
M 2.5	0.45	2.05	46	2.20	44	2.65	37	2.75	7/64
M 3	0.60	2.40	41	2.60	37	3.15	1/8	3.30	30
	0.50	2.50	39	2.70	36				
M 3.5	0.60	2.90	32	3.10	31	3.70	27	3.85	24
M 4	0.75	3.25	30	3.50	28	4.20	19	4.40	17
	0.70	3.30	30	3.50	28				
M 4.5	0.75	3.75	25	4.00	22	4.75	13	5.00	9
M 5	1.00	4.00	21	4.40	11/64	5.25	5	5.50	7/32
	0.90	4.10	20	4.40	17				
	0.80	4.20	19	4.50	16				
M 5.5	0.90	4.60	14	4.90	10	5.80	1	6.10	B
M 6	1.00	5.00	8	5.40	4	6.30	E	6.60	G
	0.75	5.25	4	5.50	7/32				
M 7	1.00	6.00	B	6.40	E	7.40	L	7.70	N
	0.75	6.25	D	6.50	F				
M 8	1.25	6.80	H	7.20	J	8.40	Q	8.80	S
	1.00	7.00	J	7.40	L				
M 9	1.25	7.80	N	8.20	P	9.50	3/8	9.90	25/64
	1.00	8.00	O	8.40	21/64				
M 10	1.50	8.50	R	9.00	T	10.50	Z	11.00	7/16
	1.25	8.80	11/32	9.20	23/64				
	1.00	9.00	T	9.40	U				
M 11	1.50	9.50	3/8	10.00	X	11.60	29/64	12.10	15/32
M 12	1.75	10.30	13/32	10.90	27/64	12.60	1/2	13.20	33/64
	1.50	10.50	Z	11.00	7/16				
	1.25	10.80	27/64	11.20	7/16				
M 14	2.00	12.10	15/32	12.70	1/2	14.75	37/64	15.50	39/64
	1.50	12.50	1/2	13.00	33/64				
	1.25	12.80	1/2	13.20	33/64				
M 15	1.50	13.50	17/32	14.00	35/64	15.75	5/8	16.50	21/32
M 16	2.00	14.00	35/64	14.75	37/64	16.75	21/32	17.50	11/16
	1.50	14.50	37/64	15.00	19/32				
M 17	1.50	15.50	39/64	16.00	5/8	18.00	45/64	18.50	47/64
M 18	2.50	15.50	39/64	16.50	41/64	19.00	3/4	20.00	25/32
	2.00	16.00	5/8	16.75	21/32				
	1.50	16.50	21/32	17.00	43/64				
M 19	2.50	16.50	21/32	17.50	11/16	20.00	25/32	21.00	53/64
M 20	2.50	17.50	11/16	18.50	23/32	21.00	53/64	22.00	55/64
	2.00	18.00	45/64	18.50	47/64				
	1.50	18.50	47/64	19.00	3/4				