

Imperial Tap Drill Chart

Machine Screw Size			Number of Threads Per inch	Minor Dia.		Tap Drills						Clearance Hole Drills											
						Aluminum, Brass & Plastics			Stainless Steel, Steels & Iron			All Materials											
No. or Dia.	Major Dia.		in	mm	Drill Size	75% Thread		Drill Size	50% Thread		Close Fit			Free Fit									
	in	mm				in	mm		in	mm	in	mm	Drill Size	in	mm	Drill Size	in	mm					
0	0.0600	1.52	80	0.0447	1.14	3/64	0.0469	1.19	55	0.0520	1.32	52	0.0635	1.61	50	0.0700	1.78						
1	0.0730	1.85	64	0.0538	1.37	53	0.0595	1.51	1/16	0.0625	1.59	48	0.0760	1.93	46	0.0810	2.06						
			72	0.0560	1.42	53	0.0595	1.51	52	0.0635	1.61												
2	0.0860	2.18	56	0.0641	1.63	50	0.0700	1.78	49	0.0730	1.85	43	0.0890	2.26	41	0.0960	2.44						
			64	0.0668	1.70	50	0.0700	1.78	48	0.0760	1.93												
3	0.0990	2.51	48	0.0734	1.86	47	0.0785	1.99	44	0.0860	2.18	37	0.1040	2.64	35	0.1100	2.79						
			56	0.0771	1.96	45	0.0820	2.08	43	0.0890	2.26												
4	0.1120	2.84	40	0.0813	2.07	43	0.0890	2.26	41	0.0960	2.44	32	0.1160	2.95	30	0.1285	3.26						
			48	0.0864	2.19	42	0.0935	2.37	40	0.0980	2.49												
5	0.1250	3.18	40	0.0943	2.40	38	0.1015	2.58	7/64	0.1094	2.78	30	0.1285	3.26	29	0.1360	3.45						
			44	0.0971	2.47	37	0.1040	2.64	35	0.1100	2.79												
6	0.1380	3.51	32	0.0997	2.53	36	0.1065	2.71	32	0.1160	2.95	27	0.1440	3.66	25	0.1495	3.80						
			40	0.1073	2.73	33	0.1130	2.87	31	0.1200	3.05												
8	0.1640	4.17	32	0.1257	3.19	29	0.1360	3.45	27	0.1440	3.66	18	0.1695	4.31	16	0.1770	4.50						
			36	0.1299	3.30	29	0.1360	3.45	26	0.1470	3.73												
10	0.1900	4.83	24	0.1389	3.53	25	0.1495	3.80	20	0.1610	4.09	9	0.1960	4.98	7	0.2010	5.11						
			32	0.1517	3.85	21	0.1590	4.04	18	0.1695	4.31												
12	0.2160	5.49	24	0.1649	4.19	16	0.1770	4.50	12	0.1890	4.80	2	0.2210	5.61	1	0.2280	5.79						
			28	0.1722	4.37	14	0.1820	4.62	10	0.1935	4.91												
			32	0.1777	4.51	13	0.1850	4.70	9	0.1960	4.98												
1/4	0.2500	6.35	20	0.1887	4.79	7	0.2010	5.11	7/32	0.2188	5.56	F	0.2570	6.53	H	0.2660	6.76						
			28	0.2062	5.24	3	0.2130	5.41	1	0.2280	5.79												
			32	0.2117	5.38	7/32	0.2188	5.56	1	0.2280	5.79												
5/16	0.3125	7.94	18	0.2443	6.21	F	0.2570	6.53	J	0.2770	7.04	P	0.3230	8.20	Q	0.3320	8.43						
			24	0.2614	6.64	I	0.2720	6.91	9/32	0.2812	7.14												
			32	0.2742	6.96	9/32	0.2812	7.14	L	0.2900	7.37												
3/8	0.3750	9.53	16	0.2983	7.58	5/16	0.3125	7.94	Q	0.3320	8.43	W	0.3860	9.80	X	0.3970	10.08						
			24	0.3239	8.23	Q	0.3320	8.43	S	0.3480	8.84												
			32	0.3367	8.55	11/32	0.3438	8.73	T	0.3580	9.09												

7/16	0.4375	11.11	14	0.3499	8.89	U	0.3680	9.35	25/64	0.3906	9.92	29/64	0.4531	11.51	15/32	0.4687	11.90
			20	0.3762	9.56	25/64	0.3906	9.92	13/32	0.4062	10.32						
			28	0.3937	10.00	Y	0.4040	10.26	Z	0.4130	10.49						
1/2	0.5000	12.70	13	0.4056	10.30	27/64	0.4219	10.72	29/64	0.4531	11.51	33/64	0.5156	13.10	17/32	0.5312	13.49
			20	0.4387	11.14	29/64	0.4531	11.51	15/32	0.4688	11.91						
			28	0.4562	11.59	15/32	0.4688	11.91	15/32	0.4688	11.91						
9/16	0.5625	14.29	12	0.4603	11.69	31/64	0.4844	12.30	33/64	0.5156	13.10	37/64	0.5781	14.68	19/32	0.5938	15.08
			18	0.4943	12.56	33/64	0.5156	13.10	17/32	0.5312	13.49						
			24	0.5114	12.99	33/64	0.5156	13.10	17/32	0.5312	13.49						
5/8	0.6250	15.88	11	0.5135	13.04	17/32	0.5312	13.49	9/16	0.5625	14.29	41/64	0.6406	16.27	21/32	0.6562	16.67
			18	0.5568	14.14	37/64	0.5781	14.68	19/32	0.5938	15.08						
			24	0.5739	14.58	37/64	0.5781	14.68	19/32	0.5938	15.08						
11/16	0.6875	17.46	24	0.6364	16.16	41/64	0.6406	16.27	21/32	0.6562	16.67	45/64	0.7031	17.86	23/32	0.7188	18.26
3/4	0.7500	19.05	10	0.6273	15.93	21/32	0.6562	16.67	11/16	0.6875	17.46	49/64	0.7656	19.45	25/32	0.7812	19.84
			16	0.6733	17.10	11/16	0.6875	17.46	45/64	0.7031	17.86						
			20	0.6887	17.49	45/64	0.7031	17.86	23/32	0.7188	18.26						
1-3/16	0.8125	20.64	20	0.7512	19.08	49/64	0.7656	19.45	25/32	0.7812	19.84	53/64	0.8281	21.03	27/32	0.8438	21.43
7/8	0.8750	22.23	9	0.7387	18.76	49/64	0.7656	19.45	51/64	0.7969	20.24	57/64	0.8906	22.62	29/32	0.9062	23.02
			14	0.7874	20.00	13/16	0.8125	20.64	53/64	0.8281	21.03						
			20	0.8137	20.67	53/64	0.8281	21.03	27/32	0.8438	21.43						
15/16	0.9375	23.81	20	0.8762	22.26	57/64	0.8906	22.62	29/32	0.9062	23.02	61/64	0.9531	24.21	31/32	0.9688	24.61
1	1.0000	25.40	8	0.8466	21.50	7/8	0.8750	22.23	59/64	0.9219	23.42	1-1/64	1.0156	25.80	1-1/32	1.0313	26.20
			12	0.8978	22.80	15/16	0.9375	23.81	61/64	0.9531	24.21						
			20	0.9387	23.84	61/64	0.9531	24.21	31/32	0.9688	24.61						
1-1/16	1.0625	26.99	18	0.9943	25.26	1.000	1.0000	25.40	1-1/64	1.0156	25.80	1-5/64	1.0781	27.38	1-3/32	1.0938	27.78
1-1/8	1.1250	28.58	7	0.9497	24.12	63/64	0.9844	25.00	1-1/32	1.0313	26.20	1-9/64	1.1406	28.97	1-5/32	1.1562	29.37
			12	1.0228	25.98	1-3/64	1.0469	26.59	1-5/64	1.0781	27.38						
			18	1.0568	26.84	1-1/16	1.0625	26.99	1-5/64	1.0781	27.38						
1-3/16	1.1875	30.16	18	1.1193	28.43	1-1/8	1.1250	28.58	1-9/64	1.1406	28.97	1-13/64	1.2031	30.56	1-7/32	1.2188	30.96
1-1/4	1.2500	31.75	7	1.0747	27.30	1-7/64	1.1094	28.18	1-5/32	1.1562	29.37	1-17/64	1.2656	32.15	1-9/32	1.2812	32.54
			12	1.1478	29.15	1-11/64	1.1719	29.77	1-13/64	1.2031	30.56						
			18	1.1818	30.02	1-3/16	1.1875	30.16	1-13/64	1.2031	30.56						
1-5/16	1.3125	33.34	18	1.2443	31.61	1-1/4	1.2500	31.75	1-17/64	1.2656	32.15	1-21/64	1.3281	33.73	1-11/32	1.3438	34.13
1-3/8	1.3750	34.93	6	1.1705	29.73	1-7/32	1.2187	30.95	1-17/64	1.2656	32.15	1-25/64	1.3906	35.32	1-13/32	1.4062	35.72
			12	1.2728	32.33	1-19/64	1.2969	32.94	1-21/64	1.3281	33.73						
			18	1.3068	33.19	1-5/16	1.3125	33.34	1-21/64	1.3281	33.73						
1-7/16	1.4375	36.51	18	1.3693	34.78	1-3/8	1.3750	34.93	1-25/64	1.3906	35.32	1-29/64	1.4531	36.91	1-15/32	1.4688	37.31

1-1/2	1.5000	38.10	6	1.2955	32.91	1-11/32	1.3437	34.13	1-25/64	1.3906	35.32	1-33/64	1.5156	38.50	1-17/32	1.5312	38.89
			12	1.3978	35.50	1-27/64	1.4219	36.12	1-7/16	1.4375	36.51						
			18	1.4318	36.37	1-7/16	1.4375	36.51	1-29/64	1.4531	36.91						
1-9/16	1.5625	39.69	18	1.4943	37.96	1-12	1.5000	38.10	1-33/64	1.5156	38.50	1-37/64	1.5781	40.08	1-19/32	1.5938	40.48
1-5/8	1.6250	41.28	18	1.5568	39.54	1-9/16	1.5625	39.69	1-37/64	1.5781	40.08	1-41/64	1.6406	41.67	1-21/32	1.6562	42.07
1-11/16	1.6875	42.86	18	1.6193	41.13	1-5/8	1.6250	41.28	1-41/64	1.6406	41.67	1-45/64	1.7031	43.26	1-23/32	1.7188	43.66
1-3/4	1.7500	44.45	5	1.5046	38.22	1-9/16	1.5625	39.69	1-5/8	1.6250	41.28	1-49/64	1.7659	44.85	1-25/32	1.7812	45.24