

Inch Tap and Clearance Drill Sizes

INCH					Tap Drill				Clearance Drill			
					75% Thread for Aluminium, Brass and Plastics		50% Thread for Steel, Stainless and iron		Close Fit		Free Fit	
Screw Size	Major Diameter	Thread Form	Threads per inch	Minor Diameter	Drill Size	Dec. Eq.	Drill Size	Dec. Eq.	Drill Size	Dec. Eq.	Drill Size	Dec. Eq.
0	.0600	UNF	80	.0447	3/64	.0469	55	.0520	52	.0635	50	.0700
1	.0730	UNC	64	.0538	53	.0595	1/16	.0652	48	.0760	46	.0810
		UNF	72	.0560	53	.0595	52	.0635				
2	.0860	UNC	56	.0641	50	.0700	49	.0730	43	.0890	41	.0960
		UNF	64	.0668	50	.0700	48	.0760				
3	.0990	UNC	48	.0734	47	.0785	44	.0860	37	.1040	35	.1100
		UNF	56	.0771	45	.0820	43	.0890				
4	.1120	UNC	40	.0813	43	.0890	41	.0960	32	.1160	30	.1285
		UNF	80	.0864	42	.0935	40	.0980				
5	.1250	UNC	40	.0943	38	.1015	7/64	.1094	30	.1285	29	.1360
		UNF	44	.0971	37	.1040	35	.1100				
6	.1380	UNC	32	.0997	36	.1065	32	.1160	27	.1440	25	.1495
		UNF	40	.1073	33	.1130	31	.1200				
8	.1640	UNC	32	.1257	29	.1360	27	.1440	18	.1695	16	.1770
		UNF	60	.1299	29	.1360	26	.1470				
10	.1900	UNC	24	.1389	25	.1495	20	.1610	9	.1960	7	.2010
		UNF	32	.1517	21	.1590	18	.1695				
12	.2160	UNC	24	.1649	16	.1770	12	.1890	2	.2210	1	.2280
		UNF	28	.1722	14	.1820	10	.1935				
		UNEF	32	.1777	13	.1850	9	.1960				
1/4	.2500	UNC	20	.1887	7	.2010	7/32	.2188	F	.2570	H	.2660
		UNF	28	.2062	3	.2130	1	.2280				
		UNEF	32	.2117	7/32	.2188	1	.2280				
5/16	.3125	UNC	18	.2443	F	.2570	J	.2770	P	.3230	Q	.3320
		UNF	24	.2614	I	.2720	9/32	.2812				
		UNEF	32	.2742	9/32	.2812	L	.2900				
3/8	.3750	UNC	16	.2983	5/16	.3125	Q	.3320	W	.3860	X	.3970
		UNF	24	.3239	Q	.3320	S	.3480				
		UNEF	32	.3367	11/13	.3438	T	.3580				
7/16	.4375	UNC	14	.3499	U	.3680	25/64	.3906	29/64	.4531	15/32	.4687
		UNF	20	.3762	25/64	.3906	13/32	.4062				
		UNEF	28	.3937	Y	.4040	Z	.4130				
1/2	.5000	UNC	13	.4056	27/64	.4219	29/64	.4531	33/64	.5156	17/32	.5312
		UNF	20	.4387	29/64	.4531	15/32	.4688				
		UNEF	28	.4562	15/32	.4688	15/32	.4688				
9/16	.5625	UNC	12	.4603	31/64	.4844	33/64	.5156	37/64	.5781	19/32	.5938
		UNF	18	.4943	33/64	.5156	17/32	.5312				
		UNEF	24	.5114	33/64	.5156	17/32	.5312				
5/8	.6250	UNC	11	.5135	17/32	.5312	9/16	.5625	41/64	.6406	21/32	.6562
		UNF	18	.5568	37/64	.5781	19/32	.5938				
		UNEF	24	.5739	37/64	.5781	19/32	.5938				
11/16	.6875	UNEF	24	.6364	41/64	.6406	21/32	.6562	45/64	.7031	23/32	.6562
3/4	.7500	UNC	10	.6273	21/32	.6562	11/16	.6875	49/64	.7656	25/32	.7812
		UNF	16	.6733	11/16	.6875	45/64	.7031				
		UNEF	20	.6887	45/64	.7031	23/32	.7188				
13/16	.8125	UNEF	20	.7512	49/64	.7656	25/32	.7812	53/64	.8281	27/32	.8438
7/8	.8750	UNC	9	.7387	49/64	.7656	51/64	.7969	57/64	.8906	29/32	.9062
		UNF	14	.7874	13/16	.8125	53/64	.8281				
		UNEF	20	.8137	53/64	.8281	27/32	.8438				
15/16	.9375	UNEF	20	.8762	57/64	.8906	29/32	.9062	61/64	.9531	31/32	.9688
1	1.000	UNC	8	.8466	7/8	.8750	59/64	.9219	1-1/64	1.0156	1-1/32	1.0313
		UNF	12	.8978	15/16	.9375	61/64	.9531				
		UNS	14	.9134	61/64	.9531	15/16	.9375				
		UNEF	20	.9387	61/64	.9531	31/32	.9688				