

### THREAD/SCREW - Drill & Tap Chart

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

Steven L Henderson's Cutting Edge Designs