

Imperial Tap Drill Chart

Machine Screw Size		Number of Threads Per Inch	Minor Dia.	Tap Drills				Clearance Hole Drills			
				Aluminum, Brass &		Stainless Steel,		All Materials			
No. or Dia.	Major Dia.			75% Thread	50% Thread	Close Fit		Free Fit			
		Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.		
0	0.06	80	0.0447	Mar-64	0.0469	55	0.052	52	0.0635	50	0.07
1	0.073	64	0.0538	53	0.0595	16-Jan	0.0625	48	0.076	46	0.081
		72	0.056	53	0.0595	52	0.0635				
2	0.086	56	0.0641	50	0.07	49	0.073	43	0.089	41	0.096
		64	0.0668	50	0.07	48	0.076				
3	0.099	48	0.0734	47	0.0785	44	0.086	37	0.104	35	0.11
		56	0.0771	45	0.082	43	0.089				
4	0.112	40	0.0813	43	0.089	41	0.096	32	0.116	30	0.1285
		48	0.0864	42	0.0935	40	0.098				
5	0.125	40	0.0943	38	0.1015	Jul-64	0.1094	30	0.1285	29	0.136
		44	0.0971	37	0.104	35	0.11				
6	0.138	32	0.0997	36	0.1065	32	0.116	27	0.144	25	0.1495
		40	0.1073	33	0.113	31	0.12				
8	0.164	32	0.1257	29	0.136	27	0.144	18	0.1695	16	0.177
		36	0.1299	29	0.136	26	0.147				
10	0.19	24	0.1389	25	0.1495	20	0.161	9	0.196	7	0.201
		32	0.1517	21	0.159	18	0.1695				
12	0.216	24	0.1649	16	0.177	12	0.189	2	0.221	1	0.228
		28	0.1722	14	0.182	10	0.1935				
		32	0.1777	13	0.185	9	0.196				
1/4	0.25	20	0.1887	7	0.201	Jul-32	0.2188	F	0.257	H	0.266
		28	0.2062	3	0.213	1	0.228				
		32	0.2117	Jul-32	0.2188	1	0.228				
5/16	0.3125	18	0.2443	F	0.257	J	0.277	P	0.323	Q	0.332
		24	0.2614	I	0.272	Sep-32	0.2812				
		32	0.2742	Sep-32	0.2812	L	0.29				
3/8	0.375	16	0.2983	16-May	0.3125	Q	0.332	W	0.386	X	0.397
		24	0.3239	Q	0.332	S	0.348				
		32	0.3367	Nov-32	0.3438	T	0.358				

7/16	0.4375	14	0.3499	U	0.368	25/64	0.3906	29/64	0.4531	15/32	0.4687
		20	0.3762	25/64	0.3906	13/32	0.4062				
		28	0.3937	Y	0.404	Z	0.413				
1/2	0.5	13	0.4056	27/64	0.4219	29/64	0.4531	33/64	0.5156	17/32	0.5312
		20	0.4387	29/64	0.4531	15/32	0.4688				
		28	0.4562	15/32	0.4688	15/32	0.4688				
9/16	0.5625	12	0.4603	31/64	0.4844	33/64	0.5156	37/64	0.5781	19/32	0.5938
		18	0.4943	33/64	0.5156	17/32	0.5312				
		24	0.5114	33/64	0.5156	17/32	0.5312				
5/8	0.625	11	0.5135	17/32	0.5312	16-Sep	0.5625	41/64	0.6406	21/32	0.6562
		18	0.5568	37/64	0.5781	19/32	0.5938				
		24	0.5739	37/64	0.5781	19/32	0.5938				
11/16	0.6875	24	0.6364	41/64	0.6406	21/32	0.6562	45/64	0.7031	23/32	0.7188
3/4	0.75	10	0.6273	21/32	0.6562	16-Nov	0.6875	49/64	0.7656	25/32	0.7812
		16	0.6733	16-Nov	0.6875	45/64	0.7031				
		20	0.6887	45/64	0.7031	23/32	0.7188				
1 3/16	0.8125	20	0.7512	49/64	0.7656	25/32	0.7812	53/64	0.8281	27/32	0.8438
7/8	0.875	9	0.7387	49/64	0.7656	51/64	0.7969	57/64	0.8906	29/32	0.9062
		14	0.7874	13/16	0.8125	53/64	0.8281				
		20	0.8137	53/64	0.8281	27/32	0.8438				
15/16	0.9375	20	0.8762	57/64	0.8906	29/32	0.9062	61/64	0.9531	31/32	0.9688
1	1	8	0.8466	8-Jul	0.875	59/64	0.9219	1/1/64	1.0156	1/1/32	1.0313
		12	0.8978	15/16	0.9375	61/64	0.9531				
		20	0.9387	61/64	0.9531	31/32	0.9688				
1 1/16	1.0625	18	0.9943	1	1	1/1/64	1.0156	1/5/64	1.0781	1/3/32	1.0938
1 1/8	1.125	7	0.9497	63/64	0.9844	1/1/32	1.0313	1/9/64	1.1406	1/5/32	1.1562
		12	1.0228	1/3/64	1.0469	1/5/64	1.0781				
		18	1.0568	1/1/16	1.0625	1/5/64	1.0781				
1 3/16	1.1875	18	1.1193	1/1/08	1.125	1/9/64	1.1406	1/13/64	1.2031	1/7/32	1.2188
1 1/4	1.25	7	1.0747	1/7/64	1.1094	1/5/32	1.1562	1/17/64	1.2656	1/9/32	1.2812
		12	1.1478	1/11/64	1.1719	1/13/64	1.2031				
		18	1.1818	1/3/16	1.1875	1/13/64	1.2031				
1 5/16	1.3125	18	1.2443	1/1/04	1.25	1/17/64	1.2656	1/21/64	1.3281	1/11/32	1.3438
1 3/8	1.375	6	1.1705	1/7/32	1.2187	1/17/64	1.2656	1/25/64	1.3906	1/13/32	1.4062
		12	1.2728	1/19/64	1.2969	1/21/64	1.3281				
		18	1.3068	1/5/16	1.3125	1/21/64	1.3281				
1 7/16	1.4375	18	1.3693	1/3/08	1.375	1/25/64	1.3906	1/29/64	1.4531	1/15/32	1.4688

1 1/2	1.5	6	1.2955	1/11/32	1.3437	1/25/64	1.3906	1-33/64	1.5156	1/17/32	1.5312
		12	1.3978	1/27/64	1.4219	1/7/16	1.4375				
		18	1.4318	1/7/16	1.4375	1/29/64	1.4531				
1 9/16	1.5625	18	1.4943	12-Jan	1.5	1-33/64	1.5156	1-37/64	1.5781	1/19/32	1.5938
1 5/8	1.625	18	1.5568	1/9/16	1.5625	1-37/64	1.5781	1-41/64	1.6406	1/21/32	1.6562
1 11/16	1.6875	18	1.6193	1/5/08	1.625	1-41/64	1.6406	1-45/64	1.7031	1/23/32	1.7188
1 3/4	1.75	5	1.5046	1/9/16	1.5625	1/5/08	1.625	1-49/64	1.7659	1/25/32	1.7812