



Tap Drill Sizes – US, Metric, Pipe

U.S. Tap Drill									
Bolt Size		Threads per Inch (TPI)	Minor (root) Dia.	Tap Drill Size (75% thread)		Clearance Hole Drill Size			
Dia.	Major Dia.			Drill Size	Decimal Equiv.	Close Fit		Free Fit	
						Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.
# 4	.1120	40	.0813	43	.0890	32	.1160	30	.1285
# 6	.1380	32	.0997	36	.1065	27	.1440	25	.1495
# 8	.1640	32	.1257	29	.1360	18	.1695	16	.1770
#10	.1900	24	.1389	25	.1495	9	.1960	7	.2010
		32	.1517	21	.1590				
# 12	.2160	24	.1649	16	.1770	2	.2210	1	.2280
1/4	.2500	20	.1887	7	.2010	F	.2570	H	.2660
		28	.2062	3	.2130				
5/16	.3125	18	.2443	F	.2570	P	.3230	Q	.3320
		24	.2614	I	.2720				
3/8	.3750	16	.2983	5/16	.3125	W	.3860	X	.3970
		24	.3239	Q	.3320				
7/16	.4375	14	.3499	U	.3680	29/64	.4531	15/32	.4687
		20	.3762	25/64	.3906				
1/2	.5000	13	.4056	27/64	.4219	33/64	.5156	17/32	.5312
		20	.4387	29/64	.4531				
9/16	.5625	12	.4603	31/64	.4844	37/64	.5781	19/32	.5938
		18	.4943	33/64	.5156				
5/8	.6250	11	.5135	17/32	.5312	41/64	.6406	21/32	.6562
		18	.5568	37/64	.5781				
3/4	.7500	10	.6273	21/32	.6562	49/64	.7656	25/32	.7812
		16	.6733	11/16	.6875				
7/8	.8750	9	.7387	49/64	.7656	57/64	.8906	29/32	.9062
		14	.7874	13/16	.8125				
1	1.000	8	.8466	7/8	.8750	1-1/64	1.0156	1-1/32	1.0313
		12	.8978	15/16	.9375				

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Metric Fine Thread	
Thread Size	Tap Drill (mm)
M4 x 0.35	3.65
M4 x 0.5	3.50
M5 x 0.5	4.50
M6 x .5	5.50
M6 x .75	5.25
M7 x .75	6.25
M8 x .5	7.00
M8 x .75	7.25
M8 x 1	7.50
M9 x 1	8.00
M10 x 0.75	9.25
M10 x 1	9.00
M10 x 1.25	8.75
M11 x 1	10.00
M12 x .75	11.25
M12 x 1	11.00
M12 x 1.5	10.50

Metric Coarse Thread	
Thread Size	Tap Drill (mm)
M4 x 0.7	3.30
M4.5 x 0.75	3.75
M5 x 0.8	4.20
M6 x 1	5.00
M7 x 1	6.00
M8 x 1.25	6.75
M9 x 1.25	7.75
M10 x 1.5	8.50
M11 x 1.5	9.50
M12 x 1.75	10.25

For Metric sizes only. Diameter of thread minus the pitch equals the tap drill size.

e.g. M6 x 1
 $6 - 1 = 5\text{mm}$

Pipe Threads				
Nominal OD	American Standard (NPT)		British Standard (BSP)	
	Threads per inch	Drill Size	Threads per inch	Drill Size
1/8	27	R	28	11/32
1/4	18	7/16	19	15/32
3/8	18	37/64	19	39/64
1/2	14	23/32	14	3/4
5/8	-	-	14	53/64
3/4	14	59/64	14	31/32

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