

Standard Tap & Drill Sizes

American Std. and Unified Form Threads

Tap Drill Size is approximately 75% Thread

Thread	Drill	Thread	Drill	Thread	Drill
0-80	3/64	1/4-20	7	1-12	59/64
1-64	53	1/4-28	3	1 1/8-7	63/64
1-72	53	5/16-18	F	1 1/8-12	1-3/64
2-56	50*	5/16-24	I	1 1/4-7	1-7/64
2-64	50	3/8-16	5/16	1 1/4-12	1-11/64
3-48	47*	3/8-24	Q	1 3/8 -6	1-7/32
3-56.	45*	7/16-14	U	1 3/8-12	1-19/64
4-40	43	7/16-20	25/64*	1 1/2 -6	1-11/32
4-48	42	1/2-13	27/64	1 1/2-12	1-27/64
5-40	38*	1/2-20	29/64	1 3/4 -5	1-9/16
5-44	37	9/16-12	31/64	2" - 4 1/2	1-25/32
6-32	36	9/16-18	33/64	2 1/4-4 1/2	2-1/32
6-40	33	5/8-11	17/32	2 1/2 - 4	2-1/4
8-32	29	5/8-18	37/64	2 3/4 - 4	2-1/2
8-36	29	3/4-10	21/32	3" - 4	2-3/4
10-24	25	3/4-16	11/16	3 1/4-4	3 "
10-32	21	7/8-9	49/64	3 1/2-4	3-1/4
12-24	16*	7/8-14	13/16	3 3/4-4	3-1/2
12-28	14*	1" -8	7/8	4" - 4	3-3/4
		1" -14	15/16		

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
	#80	.0135"	.3429 mm	
	#79	.0145"	.3683 mm	
	1/64"	.015625"	.3969 mm	#0 Pilot in Soft-Wood
	#78	.016"	.4064 mm	
	#77	.018"	.4572 mm	
		.0197"	.5000 mm	
	#76	.02"	.5080 mm	
	#75	.021"	.5334 mm	
	#74	.0225"	.5715 mm	
	#73	.024"	.6096 mm	
	#72	.025"	.6350 mm	
	#71	.026"	.6604 mm	
	#70	.028"	.7112 mm	
	#69	.0292"	.7416 mm	
		.0295"	.7500 mm	M1x.25 coarse
	#68	.031"	.7874 mm	
	1/32"	.03125"	.7938 mm	#0 Pilot, Hard-Wood #1 Pilot, Hard & Soft-Wood #2 Pilot, Soft-Wood
	#67	.032"	.8128 mm	
	#66	.033"	.8382 mm	
		.0335"	.8500 mm	M1.1x.25 coarse
	#65	.035"	.8890 mm	
	#64	.036"	.9144 mm	
	#63	.037"	.9398 mm	
		.0374"	.9500 mm	M1.2x.25 coarse
	#62	.038"	.9652 mm	
	#61	.039"	.9906 mm	
		.0394"	1.0000 mm	
	#60	.04"	1.0160 mm	
	#59	.041"	1.0414 mm	
	#58	.042"	1.0668 mm	
	#57	.043"	1.0922 mm	
		.0433"	1.1000 mm	M1.4x.3 coarse
	#56	.0465"	1.1811 mm	
#0-80 UNF	3/64"	.046875"	1.1906 mm	#0-80 UNF #2 Pilot, Hard-wood #3 Pilot, Soft-Wood #4 Pilot, Soft-Wood

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
		.0492"	1.2500 mm	M1.6x.35 coarse
		.0512"	1.3000 mm	M1.7x.35 coarse
	#55	.052"	1.3208 mm	
	#54	.055"	1.3970 mm	
		.0571"	1.4500 mm	M1.8x.35 coarse
		.0591"	1.5000 mm	
#1-64 UNC #1-72 UNF	#53	.0595"	1.5113 mm	#1-64 UNC #1-72 UNF
	1/16"	.0625"	1.5875 mm	#0 Wood Shank Hole #3 Pilot, Hard-Wood #4 Pilot, Hard-wood #5 Pilot, Soft-wood #6 Pilot, Soft-wood #7 Pilot, Soft-wood
		.063"	1.6000 mm	M2x.4 coarse
	#52	.0635"	1.6129 mm	
	#51	.067"	1.7018 mm	
		.0689"	1.7500 mm	M2.2x.45 coarse
#2-64 UNF #2-56 UNC	#50	.07"	1.7780 mm	#2-64 UNF #2-56 UNC
	#49	.073"	1.8542 mm	
	#48	.076"	1.9304 mm	
	5/64"	.078125"	1.9844 mm	#1 Wood Shank Hole #5 Pilot, Hard-wood #6 Pilot, Hard-wood #8 Pilot, Soft-wood #9 Pilot, Soft-wood
#3-48 UNC	#47	.0785"	1.9939 mm	#3-48 UNC
		.0787"	2.0000 mm	
		.0807"	2.0500 mm	M2.5x.45 coarse
	#46	.081"	2.0574 mm	
#3-56 UNF	#45	.082"	2.0828 mm	#3-56 UNF
	#44	.086"	2.1844 mm	
#4-40 UNC	#43	.089"	2.2606 mm	#4-40 UNC
#4-48 UNF	#42	.0935"	2.3749 mm	#4-48 UNF
	3/32"	.09375"	2.3813 mm	#2 Wood Shank Hole #7 Pilot, Hard-wood #8 Pilot, Hard-wood #10 Pilot, Soft-wood #11 Pilot, Soft-wood
	#41	.096"	2.4384 mm	
	#40	.098"	2.4892 mm	
		.0984"	2.5000 mm	M3x.5 coarse

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
	#39	.0995"	2.5273 mm	
#5-40 UNC	#38	.1015"	2.5781 mm	#5-40 UNC
#5-44 UNF	#37	.104"	2.6416 mm	#5-44 UNF
#6-32 UNC	#36	.1065"	2.7051 mm	#6-32 UNC
	7/64"	.109375"	2.7781 mm	#3 Wood Shank Hole #4 Wood Shank Hole #9 Pilot, Hard-wood #10 Pilot, Hard-wood #12 Pilot, Soft-wood #14 Pilot, Soft-wood
	#35	.11"	2.7940 mm	
	#34	.111"	2.8194 mm	
#6-40 UNF	#33	.113"	2.8702 mm	#6-40 UNF
		.1142"	2.9000 mm	M3.5x.6 coarse
	#32	.116"	2.9464 mm	
		.1181"	3.0000 mm	
	#31	.12"	3.0480 mm	
	1/8"	.125"	3.1750 mm	#5 Wood Shank Hole #11 Pilot, Hard-wood #12 Pilot, Hard-wood
	#30	.1285"	3.2639 mm	
		.1299"	3.3000 mm	M4x.7 coarse
#8-32 UNC #8-36 UNF	#29	.136"	3.4544 mm	#8-32 UNC #8-36 UNF
		.1378"	3.5000 mm	M4x.5 Fine
	#28	.1405"	3.5687 mm	
	9/64"	.140625"	3.5719 mm	#6 Wood Shank Hole #14 Pilot, Hard-wood #16 Pilot, Soft-wood #18 Pilot, Soft-wood
		.1417"	3.6000 mm	M4x.35 Fine
	#27	.144"	3.6576 mm	
		.1457"	3.7000 mm	M4.5x.75 coarse
	#26	.147"	3.7338 mm	
#10-24 UNC	#25	.1495"	3.7973 mm	#10-24 UNC
	#24	.152"	3.8608 mm	
	#23	.154"	3.9116 mm	
	5/32"	.15625"	3.9688 mm	#7 Wood Shank Hole #16 Pilot, Hard-wood
	#22	.157"	3.9878 mm	
		.1575"	4.0000 mm	
#10-32 UNF	#21	.159"	4.0386 mm	#10-32 UNF

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
	#20	.161"	4.0894 mm	
		.1654"	4.2000 mm	M5x.8 coarse
	#19	.166"	4.2164 mm	
	#18	.1695"	4.3053 mm	
	11/64"	.171875"	4.3656 mm	#8 Wood Shank Hole #20 Pilot, Soft-wood
#12-24 UNC	#17	.173"	4.3942 mm	#12-24 UNC
	#16	.177"	4.4958 mm	
		.1772"	4.5000 mm	M5x.5 Fine
#12-28 UNF	#15	.18"	4.5720 mm	#12-28 UNF
	#14	.182"	4.6228 mm	
	#13	.185"	4.6990 mm	
	3/16"	.1875"	4.7625 mm	#9 Wood Shank Hole #10 Wood Shank Hole #18 Pilot, Hard-wood
	#12	.189"	4.8006 mm	
	#11	.191"	4.8514 mm	
	#10	.1935"	4.9149 mm	
	# 9	.196"	4.9784 mm	
		.1969"	5.0000 mm	M6x1 coarse
	# 8	.199"	5.0546 mm	
1/4"-20 UNC	# 7	.201"	5.1054 mm	1/4"-20 UNC
	13/64"	.203125"	5.1594 mm	#11 Wood Shank Hole #20 Pilot, Hard-wood
	# 6	.204"	5.1816 mm	
	# 5	.2055"	5.2197 mm	
		.2067"	5.2500 mm	M6x.75 Fine
	# 4	.209"	5.3086 mm	
1/4"-28 UNF	# 3	.213"	5.4102 mm	1/4"-28 UNF
		.2165"	5.5000 mm	M6x.5 Fine
	7/32"	.21875"	5.5563 mm	#12 Wood Shank Hole
	# 2	.221"	5.6134 mm	
	# 1	.228"	5.7912 mm	
	A	.234"	5.9436 mm	
	15/64"	.234375"	5.9531 mm	
		.2362"	6.0000 mm	M7x1 coarse
	B	.238"	6.0452 mm	
	C	.242"	6.1468 mm	
	D	.246"	6.2484 mm	1/16"-27 NPT
		.2461"	6.2500 mm	M7x.75 Fine
	1/4"	.25"	6.3500 mm	#14 Wood Shank Hole

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
	E	.25"	6.3500 mm	
		.2559"	6.5000 mm	
5/16"-18 UNC	F	.257"	6.5278 mm	5/16"-18 UNC
	G	.261"	6.6294 mm	
	17/64"	.265625"	6.7469 mm	#16 Wood Shank Hole
	H	.266"	6.7564 mm	
		.2677"	6.8000 mm	M8x1.25 coarse
5/16"-24 UNF	I	.272"	6.9088 mm	5/16"-24 UNF
		.2756"	7.0000 mm	M8x.5 Fine
	J	.277"	7.0358 mm	
	K	.281"	7.1374 mm	
	9/32"	.28125"	7.1438 mm	
		.2854"	7.2500 mm	M8x.75 Fine
	L	.29"	7.3660 mm	
	M	.295"	7.4930 mm	
		.2953"	7.5000 mm	M8x1 Fine
	19/64"	.296875"	7.5406 mm	#18 Wood Shank Hole
	N	.302"	7.6708 mm	
		.3071"	7.8000 mm	M9x1.25 coarse
3/8"-16 UNC	5/16"	.3125"	7.9375 mm	3/8"-16 UNC
		.315"	8.0000 mm	M9x1 Fine
	O	.316"	8.0264 mm	
	P	.323"	8.2042 mm	
	21/64"	.328125"	8.3344 mm	#20 Wood Shank Hole
3/8"-24 UNF	Q	.332"	8.4328 mm	3/8"-24 UNF
		.3346"	8.5000 mm	M10x1.5 coarse
	R	.339"	8.6106 mm	1/8"-27 NPT
	11/32"	.34375"	8.7313 mm	
		.3465"	8.8000 mm	M10x1.25 Fine
	S	.348"	8.8392 mm	
		.3543"	9.0000 mm	M10x1 Fine
	T	.358"	9.0932 mm	7/16"-14 UNC
	23/64"	.359375"	9.1281 mm	
		.3642"	9.2500 mm	M10x.75 Fine
	U	.368"	9.3472 mm	
		.374"	9.5000 mm	M11x1.5 coarse
	3/8"	.375"	9.5250 mm	
	V	.377"	9.5758 mm	
	W	.386"	9.8044 mm	
7/16"-20 UNF	25/64"	.390625"	9.9219 mm	7/16"-20 UNF

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USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
		.3937"	10.0000 mm	M11x1 Fine
	X	.397"	10.0838 mm	
		.4016"	10.2000 mm	M12x1.75 coarse
	Y	.404"	10.2616 mm	
	13/32"	.40625"	10.3188 mm	
	Z	.413"	10.4902 mm	
		.4134"	10.5000 mm	M12x1.5 Fine
1/2"-13 UNC	27/64"	.421875"	10.7156 mm	1/2"-13 UNC
		.4331"	11.0000 mm	M12x1 Fine
	7/16"	.4375"	11.1125 mm	3/4"-18 NPT
		.4429"	11.2500 mm	M12x.75 Fine
		.4528"	11.5000 mm	
1/2"-20 UNF	29/64"	.453125"	11.5094 mm	1/2"-20 UNF
	15/32"	.46875"	11.9063 mm	
		.4724"	12.0000 mm	M14x2 coarse
9/16"-12 UNC	31/64"	.484375"	12.3031 mm	9/16"-12 UNC
		.4921"	12.5000 mm	M14x1.5 Fine
	1/2"	.5"	12.7000 mm	
		.5039"	12.8000 mm	M14x1.25 Fine
		.5118"	13.0000 mm	M14x1 Fine
9/16"-18 UNF	33/64"	.515625"	13.0969 mm	9/16"-18 UNF
5/8"-11 UNC	17/32"	.53125"	13.4938 mm	5/8"-11 UNC
		.5315"	13.5000 mm	
	35/64"	.546875"	13.8906 mm	
		.5512"	14.0000 mm	M16x2 coarse
5/8"-18 UNF	9/16"	.5625"	14.2875 mm	5/8"-18 UNF
		.5709"	14.5000 mm	M16x1.5 Fine
	37/64"	.578125"	14.6844 mm	3/8"-18 NPT
		.5906"	15.0000 mm	M16x1 Fine
	19/32"	.59375"	15.0813 mm	
	39/64"	.609375"	15.4781 mm	
		.6102"	15.5000 mm	M18x2.5 coarse
	5/8"	.625"	15.8750 mm	
		.6299"	16.0000 mm	M18x2 Fine
3/4"-10 UNC	41/64"	.640625"	16.2719 mm	3/4"-10 UNC
		.6496"	16.5000 mm	
	21/32"	.65625"	16.6688 mm	
		.6693"	17.0000 mm	M18x1 Fine
	43/64"	.671875"	17.0656 mm	
3/4"-16 UNF	11/16"	.6875"	17.4625 mm	3/4"-16 UNF

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USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
		.689"	17.5000 mm	M20x2.5 coarse
	45/64"	.703125"	17.8594 mm	1/2"-14 NPT
		.7087"	18.0000 mm	M20x2 Fine
	23/32"	.71875"	18.2563 mm	
		.7283"	18.5000 mm	M20x1.5 Fine
	47/64"	.734375"	18.6531 mm	
		.748"	19.0000 mm	M20x1 Fine
	3/4"	.75"	19.0500 mm	
7/8"-9 UNC	49/64"	.765625"	19.4469 mm	7/8"-9 UNC
		.7677"	19.5000 mm	M22x2.5 coarse
	25/32"	.78125"	19.8438 mm	
		.7874"	20.0000 mm	M22x2 Fine
	51/64"	.796875"	20.2406 mm	
		.8071"	20.5000 mm	M22x1.5 Fine
7/8"-14 UNF	13/16"	.8125"	20.6375 mm	7/8"-14 UNF
		.8268"	21.0000 mm	M24x3 coarse M22x1 Fine
	53/64"	.828125"	21.0344 mm	
	27/32"	.84375"	21.4313 mm	
		.8465"	21.5000 mm	
	55/64"	.859375"	21.8281 mm	
		.8661"	22.0000 mm	M24x2 Fine
1"-8 UNC	7/8"	.875"	22.2250 mm	1"-8 UNC
		.8858"	22.5000 mm	M24x1.5 Fine
	57/64"	.890625"	22.6219 mm	
		.9055"	23.0000 mm	
1"-12 UNF	29/32"	.90625"	23.0188 mm	1"-12 UNF
	59/64"	.921875"	23.4156 mm	3/4"-14 NPT
		.9252"	23.5000 mm	
	15/16"	.9375"	23.8125 mm	
		.9449"	24.0000 mm	M27x3 coarse
	61/64"	.953125"	24.2094 mm	
		.9646"	24.5000 mm	M26x1.5 Fine
	31/32"	.96875"	24.6063 mm	
		.9843"	25.0000 mm	M27x2 Fine
1-1/8"-7 UNC	63/64"	.984375"	25.0031 mm	1-1/8"-7 UNC
	1"	1.000"	25.4000 mm	
		1.0039"	25.5000 mm	M27x1.5 Fine
		1.0433"	26.5000 mm	M30x3.5 coarse
		1.0433"	26.5000 mm	M28x1.5 Fine
1-1/8"-12 UNF	1-3/64"	1.046875"	26.5906 mm	1-1/8"-12 UNF

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
	1-1/16"	1.0625"	26.9875 mm	
		1.1024"	28.0000 mm	M30x2 Fine
1 1/4"-7 UNC	1-7/64"	1.109375"	28.1781 mm	1 1/4"-7 UNC
		1.122"	28.5000 mm	M30x1.5 Fine
	1-1/8"	1.125"	28.5750 mm	
	1-5/32"	1.15625"	29.3688 mm	1"-11½ NPT
		1.1614"	29.5000 mm	M33x3.5 coarse
1 1/4"-12 UNF	1-11/64"	1.171875"	29.7656 mm	1 1/4"-12 UNF
	1-3/16"	1.1875"	30.1625 mm	
		1.2205"	31.0000 mm	M33x2 Fine
		1.2598"	32.0000 mm	M36x4 coarse
		1.2992"	33.0000 mm	M36x3 Fine
1 1/2"-6 UNC	1-11/32"	1.34375"	34.1313 mm	1 1/2"-6 UNC
	1-3/8"	1.375"	34.9250 mm	
		1.378"	35.0000 mm	M39x4 coarse
		1.4173"	36.0000 mm	M39x3 Fine
1 1/2"-12 UNF	1-27/64"	1.421875"	36.1156 mm	1 1/2"-12 UNF
	1-7/16"	1.4375"	36.5125 mm	
	1-1/2"	1.5"	38.1000 mm	1 1/4"-11½ NPT
1 3/4"-5 UNC	1-35/64"	1.546875"	39.2906 mm	1 3/4"-5 UNC
	1-9/16"	1.5625"	39.6875 mm	
	1-5/8"	1.625"	41.2750 mm	
1¾"-12 UNF	1-43/64"	1.671875"	42.4656 mm	1¾"-12 UNF
	1-47/64"	1.734375"	44.0531 mm	1½"-11½ NPT
	1-3/4"	1.75"	44.4500 mm	
2"-4½ UNC	1-25/32"	1.78125"	45.2438 mm	2"-4½ UNC
	1-13/16"	1.8125"	46.0375 mm	
	1-7/8"	1.875"	47.6250 mm	
2"-12 UNF	1-59/64"	1.921875"	48.8156 mm	2"-12 UNF
	1-15/16"	1.9375"	49.2125 mm	
2 1/4 - 4 1/2 UNC	2-1/32"	2.03125"		2 1/4 - 4 1/2 UNC
	2-7/32"	2.21875"	56.3563 mm	2"-11½ NPT
2 1/2 - 4 1/2 UNC	2-1/4"	2.25"		2 1/2 - 4 1/2 UNC
2 3/4 - 4 UNC	2-1/2"	2.50"		2 3/4 - 4 UNC
	2-5/8"	2.625"	66.675 mm	2½-8 NPT
3" - 4 UNC	2-3/4"	2.75"		3" - 4 UNC
3 1/4 - 4 UNC	3"	3.000"		3 1/4 - 4 UNC
3 1/2 - 4 UNC	3-1/4"	3.25"	82.55 mm	3 1/2-4 UNC 3"-8 NPT
3 3/4" - 4 UNC	3-1/2"	3.50"		3 3/4" - 4 UNC
4" - 4 UNC	3-3/4"	3.75"	88.90 mm	4" - 4 UNC

DECIMAL INCH / METRIC EQUIVALENTS (PLUS TAP / DRILL / PILOT RECOMMENDATIONS)

USS & SAE TAP SIZES	DRILL	INCH EQ.	METRIC EQ.	ALL TAP, DRILL & PILOT SIZES
				3/2"-8 NPT
	4-1/4"	4.25"	107.95 mm	4"-8 NPT

Source: http://www.fairburyfastener.com/tap_drill_decimal_inch.htm