



Recommended tap drill sizes

Nominal Tap Size	Recommended Tap Drill		% of Thread	Nominal Tap Size	Recommended Tap Drill		% of Thread
	Drill	Decimal Equivalent			Drill	Decimal Equivalent	
2 - 56	51	.0670	74	5/16" - 18	F	.2570	72
2 - 64	50	.0700	70	5/16" - 24	H	.2660	78
4 - 40	44	.0860	74	3/8" - 16	5/16"	.3125	72
4 - 48	42	.0935	61	3/8" - 24	21/64"	.3281	79
6 - 32	37	.1040	78	7/16" - 14	T	.3580	81
6 - 40	34	.1110	75	7/16" - 20	W	.3860	72
8 - 32	29	.1360	62	1/2" - 20	29/64"	.4531	65
10 - 24	27	.1440	79	9/16" - 12	19/32"	.4687	82
10 - 32	5/32"	.1562	75	9/16" - 18	1/2"	.5000	80
12 - 28	16	.1770	77	5/8" - 11	17/32"	.5312	75
1/4" - 20	9	.1960	77	5/8" - 18	9/16"	.5625	80
1/4" - 28	3	.2130	72	3/4" - 10	41/64"	.6406	80

Recommended tap drill sizes for metric taps

Metric Tap Size	Recommended Metric Drill			Closest Recommended Inch Drill		
	Drill Size	Inch Equivalent	% of Thread	Drill Size	Decimal Equivalent	% of Thread
M1.6 x 0.35	1.25	0.0492	69	—	—	—
M1.8 x 0.35	1.45	0.0571	69	—	—	—
M2 x 0.4	1.60	0.0630	69	52	.0635	66
M2.5 x 0.45	2.05	0.0807	69	46	.0810	67
M3 x 0.50	2.50	0.0984	68	40	0.0980	70
M3.5 x 0.60	2.90	0.1142	68	33	0.1130	72
M4 x 0.70	3.30	0.1299	69	30	0.1285	73
M5 x 0.80	4.20	0.1654	69	19	0.1660	68
M6 x 1.00	5.00	0.1968	70	9	0.1960	71
M8 x 1.25	6.70	0.2638	74	17/64"	0.2656	71
M10 x 1.50	8.50	0.3346	71	Q	0.3320	75
M12 x 1.75	10.20	0.4016	74	Y	0.4040	71
M14 x 2	12.00	0.4724	72	19/32"	0.4688	76
M16 x 2	14.00	0.5512	72	35/64"	0.5469	76

Recommended tap drill sizes for thread forming taps

Nominal Tap Size	Recommended Drill Size for approx 65% Thread		Nominal Tap Size	Recommended Drill Size for approx 65% Thread	
	Drill Size	Decimal Equivalent		Drill Size	Decimal Equivalent
2 - 56	5/64"	.0781	1/4" - 20	1	.2280
2 - 64	47	.0785	1/4" - 28	19/64"	.2344
4 - 40	38	.1015	5/16" - 18	L	.2900
4 - 48	2.6mm	.1024	5/16" - 24	M	.2950
6 - 32	1/8"	.1250	3/8" - 16	S	.3480
6 - 40	3.25mm	.1280	3/8" - 24	T	.3580
8 - 32	25	.1495	7/16" - 14	19/32"	.4062
10 - 24	11/64"	.1719	7/16" - 20	Z	.4130
10 - 32	16	.1770	1/2" - 13	19/32"	.4682
12 - 28	7	.2010	1/2" - 20	12.25mm	.4823

Recommended tap drill sizes for NPT taper pipe taps

Tap Size	Threads per inch	Tap Drill Size	Decimal Equivalent
1/8"	27	11/32"	.3437
1/4"	18	7/16"	.4375
3/8"	18	37/64"	.5781
1/2"	14	23/32"	.7187