

Tap Drill Chart: Inch and Metric

All 45 threads in one printable chart: numbered screws, inch UNC and UNF, and metric coarse. Each row shows the drill for aluminum, steel and stainless.

Thread	Series	Major diameter	Pitch	Aluminum, brass (75%)	Mild steel (60%)	Stainless, titanium (50%)
#0-80	UNF	0.0600 in (1.52 mm)	80 TPI (0.318 mm)	3/64 in 81%	3/64 in 81%	#55 49%
#2-56	UNC	0.0860 in (2.18 mm)	56 TPI (0.454 mm)	#50 69%	#49 56%	#49 56%
#4-40	UNC	0.1120 in (2.84 mm)	40 TPI (0.635 mm)	#43 71%	#42 57%	#41 49%
#5-40	UNC	0.1250 in (3.17 mm)	40 TPI (0.635 mm)	#38 72%	#37 65%	7/64 in 48%
#6-32	UNC	0.1380 in (3.51 mm)	32 TPI (0.794 mm)	#36 78%	#33 62%	#32 54%
#6-40	UNF	0.1380 in (3.51 mm)	40 TPI (0.635 mm)	#33 77%	#31 55%	#31 55%
#8-32	UNC	0.1640 in (4.17 mm)	32 TPI (0.794 mm)	#29 69%	#28 58%	#27 49%
#10-24	UNC	0.1900 in (4.83 mm)	24 TPI (1.058 mm)	#25 75%	#22 61%	#20 54%
#10-32	UNF	0.1900 in (4.83 mm)	32 TPI (0.794 mm)	#21 76%	#19 59%	#18 50%
#12-24	UNC	0.2160 in (5.49 mm)	24 TPI (1.058 mm)	#16 72%	#14 63%	#12 50%
1/4-20	UNC	0.2500 in (6.35 mm)	20 TPI (1.270 mm)	#7 75%	#4 63%	7/32 in 48%
5/16-18	UNC	0.3125 in (7.94 mm)	18 TPI (1.411 mm)	letter F 77%	letter H 64%	letter J 49%
3/8-16	UNC	0.3750 in (9.52 mm)	16 TPI (1.587 mm)	5/16 in 77%	letter P 64%	letter Q 53%
7/16-14	UNC	0.4375 in (11.11 mm)	14 TPI (1.814 mm)	letter U 75%	letter V 65%	25/64 in 51%
1/2-13	UNC	0.5000 in (12.70 mm)	13 TPI (1.954 mm)	27/64 in 78%	7/16 in 63%	29/64 in 47%
9/16-12	UNC	0.5625 in (14.29 mm)	12 TPI (2.117 mm)	31/64 in 72%	1/2 in 58%	1/2 in 58%
5/8-11	UNC	0.6250 in (15.88 mm)	11 TPI (2.309 mm)	17/32 in 79%	35/64 in 66%	9/16 in 53%
3/4-10	UNC	0.7500 in (19.05 mm)	10 TPI (2.540 mm)	21/32 in 72%	43/64 in 60%	11/16 in 48%
7/8-9	UNC	0.8750 in (22.22 mm)	9 TPI (2.822 mm)	49/64 in 76%	25/32 in 65%	51/64 in 54%
1/4-28	UNF	0.2500 in (6.35 mm)	28 TPI (0.907 mm)	#3 80%	#2 63%	#1 47%
5/16-24	UNF	0.3125 in (7.94 mm)	24 TPI (1.058 mm)	letter I 75%	letter K 58%	9/32 in 58%
3/8-24	UNF	0.3750 in (9.52 mm)	24 TPI (1.058 mm)	letter Q 79%	letter R 67%	letter S 50%
7/16-20	UNF	0.4375 in (11.11 mm)	20 TPI (1.270 mm)	25/64 in 72%	letter X 62%	13/32 in 48%
1/2-20	UNF	0.5000 in (12.70 mm)	20 TPI (1.270 mm)	29/64 in 72%	29/64 in 72%	15/32 in 48%
9/16-18	UNF	0.5625 in (14.29 mm)	18 TPI (1.411 mm)	33/64 in 65%	33/64 in 65%	33/64 in 65%
5/8-18	UNF	0.6250 in (15.88 mm)	18 TPI (1.411 mm)	37/64 in 65%	37/64 in 65%	37/64 in 65%

Thread	Series	Major diameter	Pitch	Aluminum, brass (75%)	Mild steel (60%)	Stainless, titanium (50%)
<u>3/4-16</u>	UNF	0.7500 in (19.05 mm)	16 TPI (1.587 mm)	11/16 in 77%	45/64 in 58%	45/64 in 58%
<u>7/8-14</u>	UNF	0.8750 in (22.22 mm)	14 TPI (1.814 mm)	13/16 in 67%	13/16 in 67%	53/64 in 51%
<u>M2</u>	Metric coarse	2.000 mm (0.0787 in)	0.40 mm	1.6 mm 77%	1.7 mm 58%	1.7 mm 58%
<u>M2.5</u>	Metric coarse	2.500 mm (0.0984 in)	0.45 mm	2.05 mm 77%	2.1 mm 68%	2.2 mm 51%
<u>M3</u>	Metric coarse	3.000 mm (0.1181 in)	0.50 mm	2.5 mm 77%	2.6 mm 62%	2.7 mm 46%
<u>M3.5</u>	Metric coarse	3.500 mm (0.1378 in)	0.60 mm	2.9 mm 77%	3.0 mm 64%	3.1 mm 51%
<u>M4</u>	Metric coarse	4.000 mm (0.1575 in)	0.70 mm	3.3 mm 77%	3.4 mm 66%	3.5 mm 55%
<u>M5</u>	Metric coarse	5.000 mm (0.1969 in)	0.80 mm	4.2 mm 77%	4.4 mm 58%	4.5 mm 48%
<u>M6</u>	Metric coarse	6.000 mm (0.2362 in)	1.00 mm	5.0 mm 77%	5.2 mm 62%	5.3 mm 54%
<u>M8</u>	Metric coarse	8.000 mm (0.3150 in)	1.25 mm	6.8 mm 74%	7.0 mm 62%	7.2 mm 49%
<u>M10</u>	Metric coarse	10.000 mm (0.3937 in)	1.50 mm	8.5 mm 77%	8.8 mm 62%	9.0 mm 51%
<u>M12</u>	Metric coarse	12.000 mm (0.4724 in)	1.75 mm	10.2 mm 79%	10.6 mm 62%	10.9 mm 48%
<u>M14</u>	Metric coarse	14.000 mm (0.5512 in)	2.00 mm	12.0 mm 77%	12.4 mm 62%	12.7 mm 50%
<u>M16</u>	Metric coarse	16.000 mm (0.6299 in)	2.00 mm	14.0 mm 77%	14.4 mm 62%	14.7 mm 50%
<u>M18</u>	Metric coarse	18.000 mm (0.7087 in)	2.50 mm	15.5 mm 77%	16.1 mm 59%	16.4 mm 49%
<u>M20</u>	Metric coarse	20.000 mm (0.7874 in)	2.50 mm	17.5 mm 77%	18.1 mm 59%	18.4 mm 49%
<u>M22</u>	Metric coarse	22.000 mm (0.8661 in)	2.50 mm	19.5 mm 77%	20.1 mm 59%	20.4 mm 49%
<u>M24</u>	Metric coarse	24.000 mm (0.9449 in)	3.00 mm	21.0 mm 77%	21.7 mm 59%	22.1 mm 49%
<u>M30</u>	Metric coarse	30.000 mm (1.1811 in)	3.50 mm	26.5 mm 77%	27.3 mm 59%	27.8 mm 48%

Tap Drill Chart: Inch and Metric | tapdrillsize.com/tap-drill-chart/ | Last reviewed October 7, 2026 | Check your tap maker's chart before cutting.

Chart drills match the [American Fastener tap and drill chart](#) and the [Fabworks tap drill chart](#). Thread percentages use the formula printed in the [OSG tap drill chart, Vol 3 \(2024\)](#). Last reviewed October 7, 2026.
Method: [how the numbers are calculated](#).