Tap drill chart

The standard drill for each thread, the one most printed charts give. 47 inch and metric threads.

Numbered screws

Thread	Drill	Size	Thread
#0-80	3/64	0.0469 in | 1.19 mm	81%
#2-56	#50	0.0700 in | 1.78 mm	69%
#4-40	#43	0.0890 in | 2.26 mm	71%
#5-40	#38	0.1015 in | 2.58 mm	72%
#6-32	#36	0.1065 in | 2.71 mm	78%
#6-40	#33	0.1130 in | 2.87 mm	77%
#8-32	#29	0.1360 in | 3.45 mm	69%
#10-24	#25	0.1495 in | 3.80 mm	75%
#10-32	#21	0.1590 in | 4.04 mm	76%
#12-24	#16	0.1770 in | 4.50 mm	72%

Inch coarse (UNC)

Thread	Drill	Size	Thread
1/4-20	#7	0.2010 in | 5.11 mm	75%
5/16-18	F	0.2570 in | 6.53 mm	77%
3/8-16	5/16	0.3125 in | 7.94 mm	77%
7/16-14	U	0.3680 in | 9.35 mm	75%
1/2-13	27/64	0.4219 in | 10.72 mm	78%
9/16-12	31/64	0.4844 in | 12.30 mm	72%
5/8-11	17/32	0.5313 in | 13.49 mm	79%
3/4-10	21/32	0.6563 in | 16.67 mm	72%
7/8-9	49/64	0.7656 in | 19.45 mm	76%

Letter drills

A	0.2340 in | 5.94 mm	B	0.2380 in | 6.05 mm
C	0.2420 in | 6.15 mm	D	0.2460 in | 6.25 mm
E	0.2500 in | 6.35 mm	F	0.2570 in | 6.53 mm
G	0.2610 in | 6.63 mm	H	0.2660 in | 6.76 mm
I	0.2720 in | 6.91 mm	J	0.2770 in | 7.04 mm
K	0.2810 in | 7.14 mm	L	0.2900 in | 7.37 mm
M	0.2950 in | 7.49 mm	N	0.3020 in | 7.67 mm
O	0.3160 in | 8.03 mm	P	0.3230 in | 8.20 mm
Q	0.3320 in | 8.43 mm	R	0.3390 in | 8.61 mm
S	0.3480 in | 8.84 mm	T	0.3580 in | 9.09 mm
U	0.3680 in | 9.35 mm	V	0.3770 in | 9.58 mm
W	0.3860 in | 9.80 mm	X	0.3970 in | 10.08 mm
Y	0.4040 in | 10.26 mm	Z	0.4130 in | 10.49 mm

Inch fine (UNF, UNEF)

Thread	Drill	Size	Thread
1/4-28	#3	0.2130 in | 5.41 mm	80%
5/16-24	I	0.2720 in | 6.91 mm	75%
3/8-24	Q	0.3320 in | 8.43 mm	79%
7/16-20	25/64	0.3906 in | 9.92 mm	72%
1/2-20	29/64	0.4531 in | 11.51 mm	72%
9/16-18	33/64	0.5156 in | 13.10 mm	65%*
5/8-18	37/64	0.5781 in | 14.68 mm	65%*
3/4-16	11/16	0.6875 in | 17.46 mm	77%
7/8-14	13/16	0.8125 in | 20.64 mm	67%
1/2-28	15/32	0.4688 in | 11.91 mm	67%
5/8-24	37/64	0.5781 in | 14.68 mm	87%*

Metric coarse

Thread	Drill	Size	Thread
M2	1.6 mm	0.0630 in	77%
M2.5	2.05 mm	0.0807 in	77%
M3	2.5 mm	0.0984 in	77%
M3.5	2.9 mm	0.1142 in	77%
M4	3.3 mm	0.1299 in	77%
M5	4.2 mm	0.1654 in	77%
M6	5.0 mm	0.1969 in	77%
M8	6.8 mm	0.2677 in	74%
M10	8.5 mm	0.3346 in	77%
M12	10.2 mm	0.4016 in	79%
M14	12.0 mm	0.4724 in	77%
M16	14.0 mm	0.5512 in	77%
M18	15.5 mm	0.6102 in	77%
M20	17.5 mm	0.6890 in	77%
M22	19.5 mm	0.7677 in	77%
M24	21.0 mm	0.8268 in	77%
M30	26.5 mm	1.0433 in	77%

tapdrillsize.com drills for steel and stainless, and a page for every thread

Thread % = (major diameter - drill) / (1.299 x pitch). Check your tap maker's chart before cutting.

* Hole outside the class 2B limits. For class 2B use 9/16-18: 12.9 mm, 5/8-18: 14.5 mm, 5/8-24: 14.8 mm.

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