

Tap and Clearance Drill Sizes

| Screw | O.D. | Tap | | Close Fit | | Free Fit | |
|-------------|---------|------------|---------|------------|---------|-----------|---------|
| Size/Thread | Decimal | Size * | Decimal | Size | Decimal | Size | Decimal |
| 000-120 | 0.0340" | 71 | 0.0260" | 65 | 0.0350" | 62 | 0.0380" |
| 00-90 | 0.0440 | 65 | 0.0350 | 3/64" | 0.0469 | 55 | 0.0520 |
| 0-80 | 0.0600 | 3/64" (56) | 0.0469 | 52 | 0.0635 | 50 | 0.0700 |
| 1-72 | 0.0730 | 53 | 0.0595 | 48 | 0.0760 | 46 | 0.0810 |
| 2-56 | 0.0860 | 50 | 0.0700 | 43 | 0.0890 | 41 | 0.0960 |
| 3-48 | 0.099 | 47 | 0.0790 | 37 | 0.1040 | 36 | 0.1065 |
| 4-40 | 0.1120 | 43 | 0.0890 | 32 | 0.1160 | 30 | 0.1285 |
| 5-40 | 0.125 | 38 | 0.102 | 29 | 0.1360 | 28 (9/64) | 0.1405 |
| 6-32 | 0.1380 | 36 | 0.1065 | 27 | 0.1440 | 25 | 0.1495 |
| 8-32 | 0.1640 | 29 | 0.1360 | 18 (11/64) | 0.1695 | 16 | 0.1770 |
| 10-24 | 0.190 | 25 | 0.150 | 9 | 0.196 | 7 (13/64) | 0.2010 |
| 10-32 | 0.1900 | 21 | 0.1590 | 9 | 0.1960 | 7 (13/64) | 0.2010 |
| 1/4-20 | 0.2500 | 7 | 0.2010 | F | 0.2570 | H (17/64) | 0.2660 |
| 1/4-28 | 0.2500 | 3 | 0.2130 | F | 0.2570 | H (17/64) | 0.2660 |
| 5/16-18 | 0.3125 | F | 0.2570 | P | 0.3230 | Q | 0.3320 |
| 3/8-16 | 0.3750 | 5/16" | 0.3125 | W | 0.3860 | X | 0.3970 |
| 1/2-13 | 0.5000 | 27/64" | 0.4219 | 33/64" | 0.5156 | 17/32" | 0.5312 |

* For copper, aluminum, cast iron, bakelite, or very thin materials, use one drill size larger.