



Imperial Tap & Clearance Drill Sizes				Tap Drill				Clearance Drill			
				75% Thread for Aluminum, Brass, & Plastics		50% Thread for Steel, Stainless, & Iron		Close Fit		Standard Fit	
				Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal	Drill Size	Decimal
Screw Size	Major Diameter	Threads Per Inch	Minor Diameter								
0	0.06	80	0.0447	23437	0.0469	55	0.052	52	0.0635	50	0.07
1	0.073	64	0.0538	53	0.0595	1/16	0.0625	48	0.076	46	0.081
		72	.0560	53	.0595	52	.0635				
2	0.086	56	0.0641	50	0.07	49	0.073	43	0.089	41	0.096
		64	.0668	50	.0700	48	.0760				
3	0.099	48	0.0734	47	0.0785	44	0.086	37	0.104	35	0.11
		56	.0771	45	.0820	43	.0890				
4	0.112	40	0.0813	43	0.089	41	0.096	32	0.116	30	0.1285
		48	.0864	42	.0935	40	.0980				
5	0.125	40	0.0943	38	0.1015	23559	0.1094	30	0.1285	29	0.136
		44	.0971	37	.1040	35	.1100				
6	0.138	32	0.0997	36	0.1065	32	0.116	27	0.144	25	0.1495
		40	.1073	33	.1130	31	.1200				
8	0.164	32	0.1257	29	0.136	27	0.144	18	0.1695	16	0.177
		36	.1299	29	.1360	26	.1470				
10	0.19	24	0.1389	25	0.1495	20	0.161	9	0.196	7	0.201
		32	.1517	21	.1590	18	.1695				
12	0.216	24	0.1649	16	0.177	12	0.189	2	0.221	1	0.228
		28	.1722	14	.1820	10	.1935				
		32	.1777	13	.1850	9	.1960				
1/4	0.25	20	0.1887	7	0.201	11871	0.2188	F	0.257	H	0.266
		28	.2062	3	.2130	1	.2280				
		32	.2117	7/32	.2188	1	.2280				
5/16	0.3125	18	0.2443	F	0.257	J	0.277	P	0.323	Q	0.332
		24	.2614	I	.2720	9/32	.2812				
		32	.2742	9/32	.2812	L	.2900				
3/8	0.375	16	0.2983	43967	0.3125	Q	0.332	W	0.386	X	0.397
		24	.3239	Q	.3320	S	.3480				
		32	.3367	11/32	.3438	T	.3580				
7/16	0.4375	14	0.3499	U	0.368	25/64	0.3906	29/64	0.4531	15/32	0.4687
		20	.3762	25/64	.3906	13/32	.4062				
		28	.3937	Y	.4040	Z	.4130				
1/2	0.5	13	0.4056	27/64	0.4219	29/64	0.4531	33/64	0.5156	17/32	0.5312
		20	.4387	29/64	.4531	15/32	.4688				
		28	.4562	15/32	.4688	15/32	.4688				
9/16	0.5625	12	0.4603	31/64	0.4844	33/64	0.5156	37/64	0.5781	19/32	0.5938
		18	.4943	33/64	.5156	17/32	.5312				
		24	.5114	33/64	.5156	17/32	.5312				
5/8	0.625	11	0.5135	17/32	0.5312	44090	0.5625	41/64	0.6406	21/32	0.6562
		18	.5568	37/64	.5781	19/32	.5938				
11/16	0.6875	24	0.6364	41/64	0.6406	21/32	0.6562	45/64	0.7031	23/32	0.7188
		10	0.6273	21/32	0.6562	44151	0.6875				
3/4	0.75	16	.6733	11/16	.6875	45/64	.7031	49/64	0.7656	25/32	0.7812
		20	.6887	45/64	.7031	23/32	.7188				
		13/16	0.8125	20	0.7512	49/64	0.7656				
7/8	0.875	9	0.7387	49/64	0.7656	51/64	0.7969	57/64	0.8906	29/32	0.9062
		14	.7874	13/16	.8125	53/64	.8281				
		20	.8137	53/64	.8281	27/32	.8438				
15/16	0.9375	20	0.8762	57/64	0.8906	29/32	0.9062	61/64	0.9531	31/32	0.9688
1	1.00	8	0.8466	44020	0.875	59/64	0.9219	1-1/64	1.0156	1-1/32	1.0313
		12	.8978	15/16	.9375	61/64	.9531				
		20	.9387	61/64	.9531	31/31	.9688				