



# STANDARD TAP GUIDE

| Machine Screw Size |            | Threads Per Inch | Minor Dia. | Tap Drills                 |                |                                |                | Clearance Hole Drills |                |            |                | Tip Depth of drill at major diameter.<br>Depth from lip to tip at center. |       |
|--------------------|------------|------------------|------------|----------------------------|----------------|--------------------------------|----------------|-----------------------|----------------|------------|----------------|---|-------|
|                    |            |                  |            | Aluminum, Brass & Plastics |                | Stainless Steel, Steels & Iron |                | All Materials         |                |            |                |   |       |
| No. or Dia.        | Major Dia. |                  |            | 75% Thread                 |                | 50% Thread                     |                | Close Fit             |                | Free Fit   |                |   |       |
|                    |            |                  |            | Drill Size                 | Decimal Equiv. | Drill Size                     | Decimal Equiv. | Drill Size            | Decimal Equiv. | Drill Size | Decimal Equiv. |   |       |
| 0                  | 0.06       | 80               | 0.0447     | 3/64                       | 0.0469         | 55                             | 0.052          | 52                    | 0.0635         | 50         | 0.07           | 0.018   | 0.012 |
| 1                  | 0.073      | 64               | 0.0538     | 53                         | 0.0595         | 1/16                           | 0.0625         | 48                    | 0.076          | 46         | 0.081          | 0.022   | 0.015 |
|                    |            | 72               | 0.056      | 53                         | 0.0595         | 52                             | 0.0635         |                       |                |            |                |   |       |
| 2                  | 0.086      | 56               | 0.0641     | 50                         | 0.07           | 49                             | 0.073          | 43                    | 0.089          | 41         | 0.096          | 0.026   | 0.018 |
|                    |            | 64               | 0.0668     | 50                         | 0.07           | 48                             | 0.076          |                       |                |            |                |   |       |
| 3                  | 0.099      | 48               | 0.0734     | 47                         | 0.0785         | 44                             | 0.086          | 37                    | 0.104          | 35         | 0.11           | 0.030   | 0.021 |
|                    |            | 56               | 0.0771     | 45                         | 0.082          | 43                             | 0.089          |                       |                |            |                |   |       |
| 4                  | 0.112      | 40               | 0.0813     | 43                         | 0.089          | 41                             | 0.096          | 32                    | 0.116          | 30         | 0.1285         | 0.034   | 0.023 |
|                    |            | 48               | 0.0864     | 42                         | 0.0935         | 40                             | 0.098          |                       |                |            |                |   |       |
| 5                  | 0.125      | 40               | 0.0943     | 38                         | 0.1015         | 7/64                           | 0.1094         | 30                    | 0.1285         | 29         | 0.136          | 0.038   | 0.026 |
|                    |            | 44               | 0.0971     | 37                         | 0.104          | 35                             | 0.11           |                       |                |            |                |   |       |
| 6                  | 0.138      | 32               | 0.0997     | 36                         | 0.1065         | 32                             | 0.116          | 27                    | 0.144          | 25         | 0.1495         | 0.041   | 0.029 |
|                    |            | 40               | 0.1073     | 33                         | 0.113          | 31                             | 0.12           |                       |                |            |                |   |       |
| 8                  | 0.164      | 32               | 0.1257     | 29                         | 0.136          | 27                             | 0.144          | 18                    | 0.1695         | 16         | 0.177          | 0.049   | 0.034 |
|                    |            | 36               | 0.1299     | 29                         | 0.136          | 26                             | 0.147          |                       |                |            |                |   |       |
| 10                 | 0.19       | 24               | 0.1389     | 25                         | 0.1495         | 20                             | 0.161          | 9                     | 0.196          | 7          | 0.201          | 0.057   | 0.039 |
|                    |            | 32               | 0.1517     | 21                         | 0.159          | 18                             | 0.1695         |                       |                |            |                |   |       |
| 12                 | 0.216      | 24               | 0.1649     | 16                         | 0.177          | 12                             | 0.189          | 2                     | 0.221          | 1          | 0.228          | 0.065   | 0.045 |
|                    |            | 28               | 0.1722     | 14                         | 0.182          | 10                             | 0.1935         |                       |                |            |                |   |       |
|                    |            | 32               | 0.1777     | 13                         | 0.185          | 9                              | 0.196          |                       |                |            |                |   |       |
| 1/4                | 0.25       | 20               | 0.1887     | 7                          | 0.201          | 7/32                           | 0.2188         | F                     | 0.257          | H          | 0.266          | 0.075   | 0.052 |
|                    |            | 28               | 0.2062     | 3                          | 0.213          | 1                              | 0.228          |                       |                |            |                |   |       |
|                    |            | 32               | 0.2117     | 7/32                       | 0.2188         | 1                              | 0.228          |                       |                |            |                |   |       |
| 5/16               | 0.3125     | 18               | 0.2443     | F                          | 0.257          | J                              | 0.277          | P                     | 0.323          | Q          | 0.332          | 0.094   | 0.065 |
|                    |            | 24               | 0.2614     | I                          | 0.272          | 9/32                           | 0.2812         |                       |                |            |                |   |       |
|                    |            | 32               | 0.2742     | 9/32                       | 0.2812         | L                              | 0.29           |                       |                |            |                |   |       |
| 3/8                | 0.375      | 16               | 0.2983     | 5/16                       | 0.3125         | Q                              | 0.332          | W                     | 0.386          | X          | 0.397          | 0.113   | 0.078 |
|                    |            | 24               | 0.3239     | Q                          | 0.332          | S                              | 0.348          |                       |                |            |                |   |       |
|                    |            | 32               | 0.3367     | 11/32                      | 0.3438         | T                              | 0.358          |                       |                |            |                |   |       |
| 7/16               | 0.4375     | 14               | 0.3499     | U                          | 0.368          | 25/64                          | 0.3906         | 29/64                 | 0.4531         | 15/32      | 0.4687         | 0.131   | 0.091 |
|                    |            | 20               | 0.3762     | 25/64                      | 0.3906         | 13/32                          | 0.4062         |                       |                |            |                |   |       |
|                    |            | 28               | 0.3937     | Y                          | 0.404          | Z                              | 0.413          |                       |                |            |                |   |       |
| 1/2                | 0.5        | 13               | 0.4056     | 27/64                      | 0.4219         | 29/64                          | 0.4531         | 33/64                 | 0.5156         | 17/32      | 0.5312         | 0.150   | 0.104 |
|                    |            | 20               | 0.4387     | 29/64                      | 0.4531         | 15/32                          | 0.4688         |                       |                |            |                |   |       |
|                    |            | 28               | 0.4562     | 15/32                      | 0.4688         | 15/32                          | 0.4688         |                       |                |            |                |   |       |
| 9/16               | 0.5625     | 12               | 0.4603     | 31/64                      | 0.4844         | 33/64                          | 0.5156         | 37/64                 | 0.5781         | 19/32      | 0.5938         | 0.169   | 0.116 |
|                    |            | 18               | 0.4943     | 33/64                      | 0.5156         | 17/32                          | 0.5312         |                       |                |            |                |   |       |
|                    |            | 24               | 0.5114     | 33/64                      | 0.5156         | 17/32                          | 0.5312         |                       |                |            |                |   |       |
| 5/8                | 0.625      | 11               | 0.5135     | 17/32                      | 0.5312         | 9/16                           | 0.5625         | 41/64                 | 0.6406         | 21/32      | 0.6562         | 0.188   | 0.129 |
|                    |            | 18               | 0.5568     | 37/64                      | 0.5781         | 19/32                          | 0.5938         |                       |                |            |                |   |       |
|                    |            | 24               | 0.5739     | 37/64                      | 0.5781         | 19/32                          | 0.5938         |                       |                |            |                |   |       |
| 11/16              | 0.6875     | 24               | 0.6364     | 41/64                      | 0.6406         | 21/32                          | 0.6562         | 45/64                 | 0.7031         | 23/32      | 0.6562         | 0.207   | 0.142 |