

Drill and Tap Chart

Drill #	Decimal Equiv.	Percent Threads		
		90%	75%	60%
A	.2340			
15/64	.2344			
B	.2380			
C	.2420			
D	.2460			
1/4	.2500			
E	.2500			
F	.2570	5/16-18		
G	.2610			
17/64	.2652	5/16-20		
H	.2660		5/16-18	
I	.2720	5/16-24		
J	.2770		5/16-24	5/16-18
K	.2810			
9/32	.2812	5/16-32		5/16-24
L	.2900		5/16-32	
M	.2950			5/16-32
N	.3020			
5/16	.3125	3/8-16		
O	.3160			
P	.3230		3/8-16	
21/64	.3281	3/8-20		
Q	.3320	3/8-24		3/8-16
R	.3390		3/8-24	
11/32	.3438	3/8-32		
S	.3480		3/8-32	3/8-24
T	.3580			3/8-32
23/64	.3594			
U	.3680	7/16-14		
3/8	.3750			
V	.3770		7/16-14	
W	.3860			
25/64	.3906	7/16-20		7/16-14
X	.3970	7/16-24	7/16-20	
Y	.4040	7/16-28		
13/32	.4062		7/16-28	7/16-20
Z	.4130			7/16-28

Standard threads are 90%.

The drill size nearest to the calculated value is used.

Some of the threads don't have a drill size available.

To calculate the hole size for any percentage of threads:

$$\text{hole size} = \text{dia.} - \frac{1.08253 \times \text{percent of thread}}{\text{threads per inch}}$$

Drill #	Decimal Equiv.	Percent Threads		
		90%	75%	60%
27/64	.4219	1/2-13		
7/16	.4375		1/2-13	
29/64	.4531	1/2-20		1/2-13
15/32	.4688	1/2-28		1/2-20
31/64	.4844	9/16-12		1/2-28
1/2	.5000		9/16-12	
33/64	.5156	9/16-18		9/16-12
17/32	.5312	5/8-11	9/16-24	9/16-18
35/64	.5469		5/8-11	
9/16	.5625			5/8-11
37/64	.5781	5/8-18		
19/32	.5938		5/8-24	5/8-18
39/64	.6094			
5/8	.6250	11/16-16		
41/64	.6406	11/16-24	11/16-16	
21/32	.6562	3/4-10	11/16-24	
43/64	.6719	3/4-12	3/4-10	
11/16	.6875	3/4-16		3/4-10
45/64	.7031	3/4-20	3/4-16	
23/32	.7188	3/4-27		3/4-20
47/64	.7344			
3/4	.7500			
49/64	.7656	7/8-9		
25/32	.7812		7/8-9	
51/64	.7969	7/8-12		7/8-9
13/16	.8125	7/8-14		
53/64	.8281	7/8-20		7/8-14
27/32	.8438	7/8-27		7/8-20
55/64	.8594			
7/8	.8750	1-8		
57/64	.8906	15/16-20		
29/32	.9062		1-8	15/16-20
59/64	.9219	1-12		1-8
15/16	.9375	1-14	1-12	
61/64	.9531	1-18		1-12
31/32	.9688			1-18
63/64	.9844	1-1/8-7		