

THREAD SIZE	TAP DRILL SIZE	CLEARANCE DRILL SIZE
# 0-80	# 56 (.046)	1/16 (.062)
# 1-64	# 53 (.059)	# 49 (.073)
# 1-72	# 53 (.059)	# 49 (.073)
# 2-56	# 50 (.070)	# 43 (.089)
# 2-64	# 50 (.070)	# 43 (.089)
# 3-48	# 47 (.078)	# 39 (.099)
# 3-56	# 46 (.081)	#39 (.099)
# 4-40	# 43 (.089)	1/8 (.125)
# 4-48	# 42 (.093)	1/8 (.125)
# 5-40	# 39 (.099)	# 30 (.128)
# 6-32	# 36 (.106)	# 27 (.144)
# 6-40	# 33 (.113)	# 27 (.144)
# 8-32	# 29 (.136)	# 17 (.173)
# 10-24	# 25 (.149)	# 7 (.201)
# 10-32	# 21 (.159)	# 7 (.201)
¼-20	# 7 (.201)	“G” (.261)
¼-28	# 3 (.213)	“G” (.261)
5/16-18	“F” (.257)	“P” (.323)
5/16-24	“I” (.272)	“P” (.323)
3/8-16	5/16 (.312)	“V” (.377)
3/8-24	“Q” (.332)	“V” (.377)
7/16-14	“U” (.368)	29/64 (.453)
7/16-20	“W” (.386)	29/64 (.453)
½-13	27/64 (.422)	33/64 (.515)
½-20	29/64 (.453)	33/64 (.515)
5/8-11	17/32 (.531)	41/64 (.641)
5/8-18	37/64 (.578)	41/64 (.641)
¾-10	21/32 (.656)	49/64 (.766)
¾-16	11/16 (.687)	49/64 (.766)
7/8-14	13/16 (.812)	57/64 (.890)
1”-8	7/8 (.875)	1-1/32 (1.032)
1”-12	59/64 (.922)	1-1/32 (1.032)

The values listed in the chart above are the recommended values for a class 2 Thread fit. The clearance drill sizes listed are the most commonly used sizes.

#0 DIA = .059	#1 DIA = .073	#2 DIA = .086	#3 DIA = .099	#4 DIA = .112
#5 DIA = .125	#6 DIA = .138	#8 DIA = .164	#10 DIA = .189	#12 DIA = .216