

**Tapping & Clearance Hole Information**

Machine Screw Size		Number of Threads Per Inch	Minor Dia.	Tap Drills				Clearance Hole Drills			
				Aluminum, Brass & Plastics		Stainless Steel, Steels & Iron		All Materials			
				75% Thread		50% Thread		Close Fit		Free Fit	
No. or Dia.	Major Dia.			Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.
0	.0600	80	.0447	3/64	.0469	55	.0520	52	.0635	50	.0700
1	.0730	64	.0538	53	.0595	1/16	.0625	48	.0760	46	.0810
		72	.0560	53	.0595	52	.0635				
2	.0860	56	.0641	50	.0700	49	.0730	43	.0890	41	.0960
		64	.0668	50	.0700	48	.0760				
3	.0990	48	.0734	47	.0785	44	.0860	37	.1040	35	.1100
		56	.0771	45	.0820	43	.0890				
4	.1120	40	.0813	43	.0890	41	.0960	32	.1160	30	.1285
		48	.0864	42	.0935	40	.0980				
5	.1250	40	.0943	38	.1015	7/64	.1094	30	.1285	29	.1360
		44	.0971	37	.1040	35	.1100				
6	.1380	32	.0997	36	.1065	32	.1160	27	.1440	25	.1495

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8	.1640	32	.1257	29	.1360	27	.1440	18	.1695	16	.1770
		36	.1299	29	.1360	26	.1470				
10	.1900	24	.1389	25	.1495	20	.1610	9	.1960	7	.2010
		32	.1517	21	.1590	18	.1695				
12	.2160	24	.1649	16	.1770	12	.1890	2	.2210	1	.2280
		28	.1722	14	.1820	10	.1935				
		32	.1777	13	.1850	9	.1960				
1/4	.2500	20	.1887	7	.2010	7/32	.2188	F	.2570	H	.2660
		28	.2062	3	.2130	1	.2280				
		32	.2117	7/32	.2188	1	.2280				
5/16	.3125	18	.2443	F	.2570	J	.2770	P	.3230	Q	.3320
		24	.2614	I	.2720	9/32	.2812				
		32	.2742	9/32	.2812	L	.2900				
3/8	.3750	16	.2983	5/16	.3125	Q	.3320	W	.3860	X	.3970
		24	.3239	Q	.3320	S	.3480				
		32	.3367	11/32	.3438	T	.3580				

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7/16	.4375	14	.3499	U	.3680	25/64	.3906	29/64	.4531	15/32	.4687
		20	.3762	25/64	.3906	13/32	.4062				
		28	.3937	Y	.4040	Z	.4130				
1/2	.5000	13	.4056	27/64	.4219	29/64	.4531	33/64	.5156	17/32	.5312
		20	.4387	29/64	.4531	15/32	.4688				
		28	.4562	15/32	.4688	15/32	.4688				
9/16	.5625	12	.4603	31/64	.4844	33/64	.5156	37/64	.5781	19/32	.5938
		18	.4943	33/64	.5156	17/32	.5312				
		24	.5114	33/64	.5156	17/32	.5312				
5/8	.6250	11	.5135	17/32	.5312	9/16	.5625	41/64	.6406	21/32	.6562
		18	.5568	37/64	.5781	19/32	.5938				
		24	.5739	37/64	.5781	19/32	.5938				
11/16	.6875	24	.6364	41/64	.6406	21/32	.6562	45/64	.7031	23/32	.6562

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3/4	.7500	10	.6273	21/32	.6562	11/16	.6875	49/64	.7656	25/32	.7812
		16	.6733	11/16	.6875	45/64	.7031				
		20	.6887	45/64	.7031	23/32	.7188				
13/16	.8125	20	.7512	49/64	.7656	25/32	.7812	53/64	.8281	27/32	.8438
7/8	.8750	9	.7387	49/64	.7656	51/64	.7969	57/64	.8906	29/32	.9062
		14	.7874	13/16	.8125	53/64	.8281				
		20	.8137	53/64	.8281	27/32	.8438				
15/16	.9375	20	.8762	57/64	.8906	29/32	.9062	61/64	.9531	31/32	.9688
1	1.000	8	.8466	7/8	.8750	59/64	.9219	1-1/64	1.0156	1-1/32	1.0313
		12	.8978	15/16	.9375	61/64	.9531				
		20	.9387	61/64	.9531	31/32	.9688				
1-1/16	1.0625	18	.9943	1.000	1.000	1-1/64	1.0156	1-5/64	1.0781	1-3/32	1.0938
1-1/8	1.1250	7	.9497	63/64	.9844	1-1/32	1.0313	1-9/64	1.1406	1-5/32	1.1562
		12	1.0228	1-3/64	1.0469	1-5/64	1.0781				
		18	1.0568	1-1/16	1.0625	1-5/64	1.0781				
1-3/16	1.1875	18	1.1193	1-1/8	1.1250	1-9/64	1.1406	1-13/64	1.2031	1-7/32	1.2188

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1-1/4	1.2500	7	1.0747	1-7/64	1.1094	1-5/32	1.1562	1-17/64	1.2656	1-9/32	1.2812
		12	1.1478	1-11/64	1.1719	1-13/64	1.2031				
		18	1.1818	1-3/16	1.1875	1-13/64	1.2031				
1-5/16	1.3125	18	1.2443	1-1/4	1.2500	1-17/64	1.2656	1-21/64	1.3281	1-11/32	1.3438
1-3/8	1.3750	6	1.1705	1-7/32	1.2187	1-17/64	1.2656	1-25/64	1.3906	1-13/32	1.4062
		12	1.2728	1-19/64	1.2969	1-21/64	1.3281				
		18	1.3068	1-5/16	1.3125	1-21/64	1.3281				
1-7/16	1.4375	18	1.3693	1-3/8	1.3750	1-25/64	1.3906	1-29/64	1.4531	1-15/32	1.4688
1-1/2	1.500	6	1.2955	1-11/32	1.3437	1-25/64	1.3906	1-33/64	1.5156	1-17/32	1.5312
		12	1.3978	1-27/64	1.4219	1-7/16	1.4375				
		18	1.4318	1-7/16	1.4375	1-29/64	1.4531				
1-9/16	1.5625	18	1.4943	1-12	1.500	1-33/64	1.5156	1-37/64	1.5781	1-19/32	1.5938
1-5/8	1.625	18	1.5568	1-9/16	1.5625	1-37/64	1.5781	1-41/64	1.6406	1-21/32	1.6562
1-11/16	1.6875	18	1.6193	1-5/8	1.6250	1-41/64	1.6406	1-45/64	1.7031	1-23/32	1.7188
1-3/4	1.750	5	1.5046	1-9/16	1.5625	1-5/8	1.6250	1-49/64	1.7659	1-25/32	1.7812