

Tap Drill Size Chart

The drill bit for tapping common UNC, UNF, and metric threads at about 75 percent engagement.

Thread	Tap drill	Thread	Tap drill
1/4-20 UNC	#7 (0.201 in)	M3 x 0.5	2.5 mm
5/16-18 UNC	F (0.257 in)	M4 x 0.7	3.3 mm
3/8-16 UNC	5/16 in	M5 x 0.8	4.2 mm
7/16-14 UNC	U (0.368 in)	M6 x 1.0	5.0 mm
1/2-13 UNC	27/64 in	M8 x 1.25	6.8 mm
10-32 UNF	#21 (0.159 in)	M10 x 1.5	8.5 mm
1/4-28 UNF	#3 (0.213 in)	M12 x 1.75	10.2 mm

Note: Metric rule of thumb: tap drill equals maj

Reference values only — verify against the governing standard or manufacturer before use.