

# Drill and Tap Size Chart

Recommended tap drill sizes for Metric, UNC, and UNF threads (approx. 75% engagement).

## Metric

Thread	Pitch	Drill
M3	0.5	2.5mm
M4	0.7	3.3mm
M5	0.8	4.2mm
M6	1.0	5.0mm
M8	1.25	6.8mm
M10	1.5	8.5mm
M12	1.75	10.2mm

## UNC

Thread	TPI	Drill
4-40	40	#43
6-32	32	#36
8-32	32	#29
10-24	24	#25
1/4-20	20	#7
5/16-18	18	F
3/8-16	16	5/16"
1/2-13	13	27/64"

## UNF

Thread	TPI	Drill
10-32	32	#21
1/4-28	28	#3
5/16-24	24	I
3/8-24	24	Q
1/2-20	20	29/64"
5/8-18	18	37/64"
3/4-16	16	11/16"

## Formulas (75% Engagement)

Imperial: Drill = Major Dia - (0.01299 \* % / TPI)

Metric: Drill (mm) = Major Dia - (1.08253 \* Pitch \* % / 100)