

| Machine Screw Size | Threads per Inch | Tap Drills | | | | Clearance Hole Drills | | | | |
|--------------------------|------------------------|---------------------------|-------------------|---------------|-------------------|-----------------------|-------------------|---------------|-------------------|-------|
| | | Non Ferrous & Plastics | | Steels & Iron | | All Materials | | | | |
| | | 75% Thread | | 50% Thread | | | | | | |
| | | Drill Size | Decimal Equiv. | Drill Size | Decimal Equiv. | Drill Size | Decimal Equiv. | Drill Size | Decimal Equiv. | |
| # or Dia. | | | | | | | | | | |
| | | | | | | 52 | .0635 | 50 | .0700 | |
| | | | | | | 48 | .0760 | 46 | .0810 | |
| | | | | | | 43 | .0890 | 41 | .0960 | |
| | | | | | | 37 | .1040 | 35 | .1100 | |
| 4 | 40 | 43 | .0890 | 41 | .0960 | 32 | .1160 | 30 | .1285 | |
| | 48 | 42 | .0935 | 40 | .0980 | | | | | |
| 5 | 40 | 38 | .1015 | 7/64 | .1094 | 30 | .1285 | 29 | .1360 | |
| | 44 | 37 | .1040 | 35 | .1100 | | | | | |
| 6 | 32 | 36 | .1065 | 32 | .1160 | 27 | .1440 | 25 | .1495 | |
| | | 40 | 33 | .1130 | 31 | | | | | .1200 |
| 8 | 32 | 29 | .136 | 27 | .1440 | 18 | .1695 | 16 | .1770 | |
| | | 36 | 29 | .136 | 26 | | | | | .1470 |
| 10 | 24 | 25 | .1495 | 20 | .1610 | 9 | .1960 | 7 | .2010 | |
| | | 32 | 21 | .1590 | 18 | | | | | .1695 |
| 12 | 24 | 16 | .1770 | 12 | .1890 | 2 | .2210 | 1 | .2280 | |
| | | 28 | 14 | .1820 | 10 | | | | | .1935 |
| | | 32 | 13 | .1850 | 9 | | | | | .1960 |
| 1/4 | 20 | 7 | .2010 | 7/32 | .2188 | F | .2570 | H | .2660 | |
| | | 28 | 3 | .2130 | 1 | | | | | .2280 |
| | | 32 | 7/32 | .2188 | 1 | | | | | .2280 |
| 5/16 | 18 | F | .2570 | J | .2770 | P | .3230 | Q | .3320 | |
| | | 24 | I | .2720 | 9/32 | | | | | .2812 |
| | | 32 | 9/32 | .2812 | L | | | | | .2900 |
| 3/8 | 16 | 5/16 | .3125 | Q | .3320 | W | .3860 | X | .3970 | |
| | | 24 | Q | .3320 | S | | | | | .3480 |
| | | 32 | 11/32 | .3438 | T | | | | | .3580 |
| 7/16 | 14 | U | .3680 | 25/64 | .3906 | 29/64 | .4531 | 15/32 | .4687 | |
| | | 20 | 25/64 | .3906 | 13/32 | | | | | .4062 |
| | | 28 | Y | .4040 | Z | | | | | .4130 |
| 1/2 | 13 | 27/64 | .4219 | 29/64 | .4531 | 33/64 | .5156 | 17/32 | .5312 | |
| | | 20 | 29/64 | .4531 | 15/32 | | | | | .4688 |
| | | 28 | 15/32 | .4688 | 15/32 | | | | | .4688 |
| 9/16 | 12 | 31/64 | .4844 | 33/64 | .5156 | 37/64 | .5781 | 19/32 | .5938 | |
| | | 18 | 33/64 | .5156 | 17/32 | | | | | .5312 |
| | | 24 | 33/64 | .5156 | 17/32 | | | | | .5312 |
| 5/8 | 11 | 17/32 | .5312 | 9/16 | .5625 | 41/64 | .6406 | 21/32 | .6562 | |
| | | 18 | 37/64 | .5781 | 19/32 | | | | | .5938 |
| | | 24 | 37/64 | .5781 | 19/32 | | | | | .5938 |
| 11/16 | 24 | 41/64 | .6406 | 21/32 | .6562 | 45/64 | .7031 | 23/32 | .6562 | |
| 3/4 | 10 | 21/32 | .6562 | 11/16 | .6875 | 49/64 | .7656 | 25/32 | .7812 | |
| | | 16 | 11/16 | .6875 | 45/64 | | | | | .7031 |
| | | 20 | 45/64 | .7031 | 23/32 | | | | | .7188 |
| 13/16 | 20 | 49/64 | .7656 | 25/32 | .7812 | 53/64 | .8281 | 27/32 | .8438 | |
| 7/8 | 9 | 49/64 | .7656 | 51/64 | .7969 | 57/64 | .8906 | 29/32 | .9062 | |
| | | 14 | 13/16 | .8125 | 53/64 | | | | | .8281 |
| | | 20 | 53/64 | .8281 | 27/32 | | | | | .8438 |
| 15/16 | 20 | 57/64 | .8906 | 29/32 | .9062 | 61/64 | .9531 | 31/32 | .9688 | |
| 1 | 8 | 7/8 | .8750 | 59/64 | .9219 | 1-1/64 | 1.0156 | 1-1/32 | 1.0313 | |
| | | 12 | 15/16 | .9375 | 61/64 | | | | | .9531 |
| | | 20 | 61/64 | .9531 | 31/32 | | | | | .9688 |