

Metric Screw Thread Chart

Metric Tap Size	Tap Drill (Inches)	Clearance Drill (Inches)
M1.6 x 0.35	#55 (0.052)	#50 (0.070)
M1.8 x 0.35	#53 (0.057)	#48 (0.076)
M2 x 0.4	#52 (0.063)	#45 (0.082)
M3 x 0.5	#39 (0.0995)	1/8 (0.125)
M3.5 x 0.6	#32 (0.116)	#28 (0.140)
M4 x 0.7	#29 (0.136)	#19 (0.166)
M4.5 x 0.75	#25 (0.1495)	#14 (0.182)
M5 x 0.8	#18 (0.169)	#7 (0.201)
M6 x 1	#8 (0.199)	"C" (0.242)
M7 x 1	"B" (0.238)	9/32 (0.281)
M8 x 1.25	"I" (0.272)	"P" (0.323)
M8 x 1	"J" (0.277)	"P" (0.323)
M10 x 1.5	"K" (0.339)	13/32 (0.406)
M10 x 1.25	"S" (0.348)	13/32 (0.406)
M12 x 1.75	13/32 (0.406)	31/64 (0.484)
M12 x 1.25	27/64 (0.421)	31/64 (0.484)
M14 x 2	31/64 (0.484)	9/16 (0.562)
M14 x 1.5	1/2 (0.500)	9/16 (0.562)
M16 x 2	9/16 (0.562)	41/64 (0.640)
M16 x 1.5	37/64 (0.578)	41/64 (0.640)
M18 x 2.5	5/8 (0.625)	23/32 (0.718)
M18 x 1.5	21/32 (0.656)	23/32 (0.718)
M20 x 2.5	45/64 (0.703)	13/16 (0.812)
M20 x 1.5	47/64 (0.734)	13/16 (0.812)

Outside Diameter of Screws

mm	inch	mm	inch
1.6	0.063	8.0	0.315
1.8	0.071	10	0.394
2.0	0.078	12	0.472
3.0	0.118	14	0.551
3.5	0.138	16	0.630
4.0	0.157	18	0.708
4.5	0.177	19	0.748
5.0	0.197	20	0.787
6.0	0.236	21	0.827
7.0	0.275	22	0.866

Standard Screw Thread Chart

Standard Thread Size	Tap Drill Size (Inches)	Clearance Drill Size (Inches)
#0-08	#56 (0.046)	1/16 (0.062)
#1-64	#53 (0.059)	#49 (.073)
#1-72	#53 (0.059)	#49 (.073)
#2-56	#50 (0.070)	#43 (.089)
#2-64	#50 (0.070)	#43 (.089)
#3-48	#47 (0.078)	#39 (.099)
#3-56	#46 (0.081)	#39 (.099)
#4-40	#43 (0.089)	1/8 (0.125)
#4-48	#42 (0.093)	1/8 (0.125)
#5-40	#39 (0.099)	#30 (0.128)
#6-32	#36 (0.106)	#27 (0.144)
#6-40	#33 (0.113)	#27 (0.144)
#8-32	#29 (0.136)	#17 (0.173)
#10-24	#25 (0.149)	#7 (0.201)
#10-32	#21 (0.159)	#7 (0.201)
1/4-20	#7 (0.201)	"G" (0.261)
1/4-28	#3 (0.213)	"G" (0.261)
5/16-18	"F" (0.257)	"P" (0.323)
5/16-24	"I" (0.272)	"P" (0.323)
3/8-16	5/16 (0.312)	"V" (0.377)
3/8-24	"Q" (0.332)	"V" (0.377)
7/16-14	"U" (0.368)	29/64 (0.453)
7/16-20	"W" (0.386)	29/64 (0.453)
1/2-13	27/64 (0.442)	33/64 (0.515)
1/2-20	29/64 (0.453)	33/64 (0.515)
5/8-11	17/32 (0.531)	41/64 (0.641)
5/8-18	37/64 (0.578)	41/64 (0.641)
3/4-10	21/32 (0.656)	49/64 (0.766)
3/4-16	11/16 (0.687)	49/64 (0.766)
7/8-14	13/16 (0.812)	57/64 (0.890)
1"-8	7/8 (0.875)	1-1/32 (1.032)
1"-12	59/64 (0.922)	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 = 0.059	#1 DIA = 0.073	#2 DIA = 0.086	#3 DIA = 0.099	#4 DIA = 0.112
#5 DIA = 0.125	#6 DIA = 0.138	#8 DIA = 0.164	#10 DIA = 0.189	#12 DIA = 0.216