

UNF			
Thread size	Threads per inch	Tapping Drill size Imperial	Tapping Drill size Metric
1/4-28	28	#3	
5/16-24	24	I	
3/8-24	24	Q	
7/16-20	20	25/64	
1/2-20	20	29/64	
9/16-18	18	33/64	
5/8-18	18	37/64	
3/4-16	16	11/16	
7/8-14	14	13/16	
1-14	14	15/16	
1 1/8-12	12	1 3/64	

UNC			
Thread size	Threads per inch	Tapping Drill size Imperial	Tapping Drill size Metric
1/4-20	20	#7	
5/16-18	18	F	
3/8-16	16	5/16	
7/16-14	14	U	
1/2-13	13	27/64	
9/16-12	12	31/64	
5/8-11	11	17/32	
3/4-10	10	21/32	
7/8-9	9	49/64	
1-8	8	7/8	
1 1/8-7	7	63/64	

$1 \frac{1}{4}-7$	7	$1 \frac{7}{64}$	
$1 \frac{3}{8}-6$	6	$1 \frac{13}{64}$	
$1 \frac{1}{2}-6$	6	$1 \frac{11}{32}$	
$1 \frac{3}{4}-5$	5	$1 \frac{35}{64}$	
2-4.5	$4 \frac{1}{2}$	$1 \frac{25}{32}$	