

# Technical Details



Inch

Roll Tap Drill Size Chart					
Size & Pitch	Drill Size	Actual % Thread	Size & Pitch	Drill Size	Actual % Thread
#2-56	5/64"	65.06	5/16-24	7.4 mm	74.69
#2-64	2.0 mm	68.33	3/8-16	8.8 mm	67.16
#3-48	#40	70.59	3/8-24	9 mm	72.95
#3-56	2.3 mm	69.58	7/16-14	10.3 mm	65.86
#4-40	#39	73.53	7/16-20	10.5 mm	70.92
#4-48	2.6 mm	68.03	1/2-13	11.8 mm	67.74
#5-40	2.9 mm	63.69	1/2-20	12.1 mm	69.48
#5-44	2.9 mm	70.06	9/16-12	13.3 mm	68.61
#6-32	3.1 mm	75.07	9/16-18	13.6 mm	71.65
#6-40	3.2 mm	70.68	5/8-11	14.8 mm	68.46
#8-32	3.8 mm	67.74	5/8-18	15.2 mm	70.35
#8-36	3.8 mm	76.20	3/4-10	17.9 mm	66.58
#10-24	4.3 mm	73.09	3/4-16	18.3 mm	69.48
#10-32	4.4 mm	78.93	7/8-9	21.0 mm	63.83
#12-24	5 mm	67.59	7/8-14	21.4 mm	66.87
#12-28	5.1 mm	62.64	1-8	24.0 mm	64.84
1/4-20	5.8 mm	63.69	1-12	24.4 mm	69.48
1/4-28	5.9 mm	72.95	1-14	24.6 mm	64.84
5/16-18	7.3 mm	66.44			

**NOTE:**

The recommended practice for roll taps is to drill and ream the hole. The thread dimensions are formed by a combination of the tap and tap drill size; this recommendation chart is a starting point. The tap hole size may need to be adjusted based on your specific tolerance, material, and hardness. Converting between inch and metric will help finding drills of similar size.



# Technical Details



## Metric

Roll Tap Drill Size Chart					
Size & Pitch	Drill Size	Actual % Thread	Size & Pitch	Drill Size	Actual % Thread
M2.5x0.45	2.3 mm	65.36	M12x1.5	11.3 mm	68.63
M3x0.5	7/64"	64.71	M12x1.75	11.2 mm	67.23
M3.5x0.6	3.2 mm	73.53	M14x1.25	13.4 mm	70.59
M4x0.7	3.7 mm	63.03	M14x1.5	13.3 mm	68.63
M5x0.8	4.6 mm	73.53	M14x2	13.1 mm	66.18
M6x0.75	#2	76.47	M16x1.5	15.3 mm	68.63
M6x1	5.5 mm	73.53	M16x2	15.1 mm	66.18
M7x1	6.5 mm	73.53	M18x1.5	17.3 mm	68.63
M8x1	7.5 mm	73.53	M18x2.5	16.9 mm	64.71
M8x1.25	7.4 mm	70.59	M20x1.5	19.3 mm	68.63
M9x1	8.5 mm	73.53	M20x2.5	18.9 mm	64.71
M9x1.25	8.4 mm	70.59	M22x1.5	21.3 mm	68.63
M10x1	9.5 mm	73.53	M22x2.5	20.9 mm	64.71
M10x1.25	9.4 mm	70.59	M24x1.5	23.3 mm	68.63
M10x1.5	9.3 mm	68.63	M24x3	22.6 mm	68.63
M12x1.25	11.4 mm	70.59			

### NOTE:

The recommended practice for roll taps is to drill and ream the hole. The thread dimensions are formed by a combination of the tap and tap drill size; this recommendation chart is a starting point. The tap hole size may need to be adjusted based on your specific tolerance, material, and hardness. Converting between inch and metric will help finding drills of similar size.

