

BattleBots IQ

Tap Drill Selection Chart

Machine Screw Thread		Tap Drill		Body Drill	
National Fine Thread	National Coarse Thread	National Fine Thread	National Coarse Thread	National Fine Thread	National Coarse Thread

8-36	8-32	#29 - .1360"	#29 - .1360"	#18 - .1695	#18 - .1695
10-32	10-24	#21 - .1590"	#25 - .1495"	#9 - .1960	#9 - .1960
1/4-28	1/4-20	#3 - .2130"	#7 - .2010"	17/64 .2656	17/64 .2656
5/16-24	5/16-18	#1 - .2720"	F - .2570"	21/64-.3281	21/64-.3281
3/8-24	3/8-16	Q - .3322"	5/16 .3125"	25/64-.3906	25/64-.3906
7/16-20	7/16-14	25/64"- .3906	U .3680"	29/64-.4531	29/64-.4531
1/2-20	1/2-13	29/64"- .4531	27/64- .4219"	33/64-5156	33/64-5156

Using this Chart

This chart is useful for selecting the correct tap drill size for a given machine screw specification.

- 1.) Locate the Machine Screw (size and thread pitch) desired. Example: 1/4" x 20
- 2.) Determine if this is a UNC coarse or UNF fine thread.
- 3.) Read across the chart to find the appropriate tap drill and tap drill chart.
- 4.) The body drill is the size drill bit required to cut a clearance hole for a bolt or machine screw to pass through.