

# Tap Drill Sizes – STI (Screw Thread Insert) Taps

STI TAP SIZE	ALUMINUM		STEEL, PLASTIC, MAGNESIUM		MINOR DIA. LIMITS (AFTER TAPPING)	
	TAP DRILL SIZE	DECIMAL EQUIV. OF TAP DRILL (INCHES)	TAP DRILL SIZE	DECIMAL EQUIV. OF TAP DRILL (INCHES)	MIN.	MAX.
2 - 56	$\frac{3}{32}$	.0938	#41	.0960	.0899	.0961
4 - 40	#31	.1200	#31	.1200	.1175	.1252
5 - 40	3.4mm	.1339	#29	.1360	.1305	.1373
6 - 32	#26	.1470	#25	.1495	.1448	.1527
6 - 40	#26	.1470	#25	.1495	.1435	.1503
8 - 32	#17	.1730	#16	.1770	.1708	.1781
10 - 24	$\frac{13}{64}$	.2031	#5	.2055	.1990	.2080
10 - 32	#7	.2010	$\frac{13}{64}$	.2031	.1968	.2041
12 - 24	#1	.2280	#1	.2280	.2250	.2340
$\frac{1}{4}$ - 20	H	.2660	H	.2660	.2608	.2704
$\frac{1}{4}$ - 28	G	.2610	6.7mm	.2638	.2577	.2646
$\frac{5}{16}$ - 18	Q	.3320	Q	.3320	.3245	.3342
$\frac{5}{16}$ - 24	$\frac{21}{64}$	.3281	$\frac{21}{64}$	.3281	.3215	.3288
$\frac{3}{8}$ - 16	X	.3970	X	.3970	.3885	.3987
$\frac{3}{8}$ - 24	$\frac{25}{64}$	.3906	$\frac{25}{64}$	.3906	.3840	.3910
$\frac{7}{16}$ - 14	$\frac{29}{64}$	.4531	$\frac{29}{64}$	.4531	.4530	.4639
$\frac{7}{16}$ - 20	$\frac{29}{64}$	.4531	$\frac{29}{64}$	.4531	.4483	.4561
$\frac{1}{2}$ - 13	$\frac{33}{64}$	.5156	$\frac{17}{32}$	.5312	.5166	.5273
$\frac{1}{2}$ - 20	$\frac{33}{64}$	.5156	$\frac{33}{64}$	.5156	.5108	.5186

Recommended tap drill sizes may vary slightly from recommended minor diameter limits to enable use of standard stock drill sizes. This variance does not cause any issues in most applications.

Drill sizes shown for steel, plastic and magnesium are such as to allow for material contraction in softer materials and to provide increased tap life. Variations in material and equipment may require the use of drills which are larger or smaller than those recommended.

Threads produced should be checked with thread plug gages to ensure that the threads meet required specifications.

**NOTE:** Information in this chart is for reference only. We will not be held liable for any consequential damages or economic loss due to the use of information contained within this chart.