

Tap Drill Size Calculator

Find the drill size for a tapped hole, in metric and imperial threads. Sizes are set for roughly 75% thread engagement - the usual balance of strength and tapping effort.

How it works

Metric tap drills equal the major diameter minus one thread pitch. Imperial sizes use the standard published drill for ~75% thread engagement. For shallow or blind holes, consider 50% engagement (a slightly larger drill) to reduce tapping torque and breakage.

For live values, use the interactive calculator: bookoffasteners.com/calculators/tap-drill-calculator/

Reference values only — verify against the governing standard or manufacturer before use.