

HOLE SIZES FOR TAPPING SCREWS

TYPE A

DIAM. OF SCREW	THICKNESS OF METAL		PIERCED HOLE	DRILLED OR CLEAN PUNCHED HOLE	
	U.S.S. GAGE #	EQUIVALENT	HOLE DIAM.	HOLE DIAM.	DRILL SIZE
4 .112	28	.0156	.086	.0860	44
	26	.0188	.086	.0860	44
	24	.0250	.093	.0935	42
	22	.0313	.098	.0935	42
	20	.0375	.100	.0980	40
6 .138	28	.0156	.111	.0995	39
	26	.0188	.111	.0995	39
	24	.0250	.111	.0995	39
	22	.0313	.111	.1015	38
	20	.0375	.111	.1065	36
7 .155	28	.0156	.121	.1040	37
	26	.0188	.121	.1040	37
	24	.0250	.121	.1100	35
	22	.0313	.121	.1130	33
	20	.0375	.121	.1160	32
18	.0500	-	.1200	31	

DIAM. OF SCREW	THICKNESS OF METAL		PIERCED HOLE	DRILLED OR CLEAN PUNCHED HOLE	
	U.S.S. GAGE #	EQUIVALENT	HOLE DIAM.	HOLE DIAM.	DRILL SIZE
8 .165	26	.0188	.137	.1130	33
	24	.0250	.137	.1130	33
	22	.0313	.137	.1160	32
	20	.0375	.137	.1200	31
	18	.0500	-	.1280	30
10 .191	26	.0188	.158	.1285	30
	24	.0250	.158	.1285	30
	22	.0313	.158	.1285	30
	20	.0375	.158	.1360	29
	18	.0500	.158	.1495	25
12 .218	24	.0250	-	.1470	26
	22	.0313	.185	.1495	25
	20	.0375	.185	.1520	24
	18	.0500	.185	.1570	22
14 .251	24	.0250	-	.1800	15
	22	.0313	.212	.1890	12
	20	.0375	.212	.1910	11
	18	.0500	.212	.1960	9

TYPE B

AND

TYPE AB

DIAM. OF SCREW	THICKNESS OF METAL		PIERCED HOLE	DRILLED OR CLEAN PUNCHED HOLE	
	U.S.S. GAGE #	EQUIVALENT	HOLE DIAM.	HOLE DIAM.	DRILL SIZE
2 .086	28	.0156	-	.0635	52
	26	.0188	-	.0635	52
	24	.0250	-	.0670	51
	22	.0313	-	.0700	50
	20	.0375	-	.0730	49
	18	.0500	-	.0730	49
	16	.0625	-	.0760	48
4 .122	28	.0156	.086	.0860	44
	26	.0188	.086	.0860	44
	24	.0250	.093	.0890	43
	22	.0313	.098	.0935	42
	20	.0375	.100	.0935	42
	18	.0500	-	.0960	41
	16	.0625	-	.0995	39
6 .137	14	.0781	-	.1015	38
	28	.0156	.106	.1040	37
	26	.0188	.106	.1040	37
	24	.0250	.106	.1065	36
	22	.0313	.110	.1065	36
	20	.0375	.110	.1100	35
	18	.0500	-	.1110	34
7 .151	16	.0625	-	.1160	32
	14	.0781	-	.1200	31
	12	.1094	-	.1285	30
	26	.0188	.121	.1160	32
	24	.0250	.121	.1160	32
	22	.0313	.121	.1160	32
	20	.0375	.121	.1160	32
8 .163	18	.0500	.121	.1200	31
	16	.0625	-	.1285	30
	14	.0781	-	.1360	29
	12	.1094	-	.1405	28
	26	.0188	.131	.1160	32
	24	.0250	.131	.1160	32
	22	.0313	.131	.1160	32
20	.0375	.136	.1160	32	
18	.0500	.140	.1285	30	

DIAM. OF SCREW	THICKNESS OF METAL		PIERCED HOLE	DRILLED OR CLEAN PUNCHED HOLE	
	U.S.S. GAGE #	EQUIVALENT	HOLE DIAM.	HOLE DIAM.	DRILL SIZE
8 .163	16	.0625	-	.1360	29
	14	.0781	-	.1405	28
	12	.1094	-	.1495	25
	1/8	.1250	-	.1495	25
	10	.1406	-	.1520	24
	26	.0188	.144	.1440	27
	24	.0250	.144	.1440	27
10 .186	22	.0313	.144	.1440	27
	20	.0375	.147	.1440	27
	18	.0500	.155	.1440	27
	16	.0625	-	.1520	24
	14	.0781	-	.1570	22
	12	.1094	-	.1610	20
	1/8	.1250	-	.1695	18
12 .212	10	.1406	-	.1695	18
	8	.1719	-	.1730	17
	24	.0250	.185	.1660	19
	22	.0313	.185	.1660	19
	20	.0375	.185	.1660	19
	18	.0500	.185	.1695	18
	16	.0625	-	.1770	16
1/4 .243	14	.0781	-	.1820	14
	12	.1094	-	.1850	13
	1/8	.1250	-	.1960	9
	10	.1406	-	.1960	9
	8	.1719	-	.2010	7
	22	.0313	.209	.1850	13
	20	.0375	.209	.1850	13
1/4 .243	18	.0500	.209	.1910	11
	16	.0625	-	.1990	8
	14	.0781	-	.2040	6
	12	.1094	-	.2090	4
	1/8	.1250	-	.2280	1
	10	.1406	-	.2280	1
	8	.1719	-	.2343	15/64
3/16	.1875	-	.2343	15/64	
6	.2031	-	.2343	15/64	

Sizes of holes recommended for average application. Slightly larger or smaller holes may be required.