

PRE-DRILL (PILOT) SIZES FOR THREAD CUTTING SCREWS, TYPE-F, TYPE-1, ETC.

Nominal Screw Size & Thread Pitch	Thickness			Hole Size	
	Gage	Max	Min	Drill Size	Hole Diam.
2-56	18	.0800	.0760	49	0.0730
4-40	18	.1110	.1070	41	0.0960
5-40	18	.1110	.1070	37	0.1010
6-32	14	.1425	.1385	31	0.1200
8-32	14	.1905	.1845	26	0.1470
10-24	1/8	.1905	.1845	17	0.1730
10-32	1/8	.1905	.1845	16	0.1770
12-24	1/8	.1905	.1845	8	0.1990
1/4-20	3/16	.2530	.2470	1	0.2280
5/16-18	3/16	.3155	.3095	L	0.2900
3/8-16	3/16	.3780	.3720	T	0.3580