MAX MACHINING

Inch Tap Drill Chart

Unified coarse and fine, #0 to 1 inch. Tap drills at about 75 percent thread with close and free fit clearance drills.

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HOW TO READ IT

Tap drill gives about 75 percent of full thread, the usual shop target. **Close fit** clearance holes are for located hardware, **free fit** for easy assembly. Decimals are nominal drill sizes; the hole a drill actually cuts runs a little larger. Formula: `drill = major - 0.01299 x percent / TPI`

THREAD	TPI	MAJOR in	TAP DRILL 75% thread	CLOSE FIT clearance	FREE FIT clearance
#0-80 UNF	80	.0600	3/64 .0469 1.19 mm	#52 .0635 1.61 mm	#50 .0700 1.78 mm
#1-64 UNC	64	.0730	#53 .0595 1.51 mm	#48 .0760 1.93 mm	#46 .0810 2.06 mm
#1-72 UNF	72	.0730	#53 .0595 1.51 mm	#48 .0760 1.93 mm	#46 .0810 2.06 mm
#2-56 UNC	56	.0860	#50 .0700 1.78 mm	#43 .0890 2.26 mm	#41 .0960 2.44 mm
#2-64 UNF	64	.0860	#50 .0700 1.78 mm	#43 .0890 2.26 mm	#41 .0960 2.44 mm
#3-48 UNC	48	.0990	#47 .0785 1.99 mm	#37 .1040 2.64 mm	#35 .1100 2.79 mm
#3-56 UNF	56	.0990	#45 .0820 2.08 mm	#37 .1040 2.64 mm	#35 .1100 2.79 mm
#4-40 UNC	40	.1120	#43 .0890 2.26 mm	#32 .1160 2.95 mm	#30 .1285 3.26 mm
#4-48 UNF	48	.1120	#42 .0935 2.37 mm	#32 .1160 2.95 mm	#30 .1285 3.26 mm
#5-40 UNC	40	.1250	#38 .1015 2.58 mm	#30 .1285 3.26 mm	#29 .1360 3.45 mm
#5-44 UNF	44	.1250	#37 .1040 2.64 mm	#30 .1285 3.26 mm	#29 .1360 3.45 mm
#6-32 UNC	32	.1380	#36 .1065 2.71 mm	#27 .1440 3.66 mm	#25 .1495 3.80 mm
#6-40 UNF	40	.1380	#33 .1130 2.87 mm	#27 .1440 3.66 mm	#25 .1495 3.80 mm
#8-32 UNC	32	.1640	#29 .1360 3.45 mm	#18 .1695 4.31 mm	#16 .1770 4.50 mm
#8-36 UNF	36	.1640	#29 .1360 3.45 mm	#18 .1695 4.31 mm	#16 .1770 4.50 mm
#10-24 UNC	24	.1900	#25 .1495 3.80 mm	#9 .1960 4.98 mm	#7 .2010 5.11 mm
#10-32 UNF	32	.1900	#21 .1590 4.04 mm	#9 .1960 4.98 mm	#7 .2010 5.11 mm
#12-24 UNC	24	.2160	#16 .1770 4.50 mm	#2 .2210 5.61 mm	#1 .2280 5.79 mm
#12-28 UNF	28	.2160	#14 .1820 4.62 mm	#2 .2210 5.61 mm	#1 .2280 5.79 mm
1/4-20 UNC	20	.2500	#7 .2010 5.11 mm	F .2570 6.53 mm	H .2660 6.76 mm
1/4-28 UNF	28	.2500	#3 .2130 5.41 mm	F .2570 6.53 mm	H .2660 6.76 mm
5/16-18 UNC	18	.3125	F .2570 6.53 mm	P .3230 8.20 mm	Q .3320 8.43 mm
5/16-24 UNF	24	.3125	I .2720 6.91 mm	P .3230 8.20 mm	Q .3320 8.43 mm
3/8-16 UNC	16	.3750	5/16 .3125 7.94 mm	W .3860 9.80 mm	X .3970 10.08 mm
3/8-24 UNF	24	.3750	Q .3320 8.43 mm	W .3860 9.80 mm	X .3970 10.08 mm
7/16-14 UNC	14	.4375	U .3680 9.35 mm	29/64 .4531 11.51 mm	15/32 .4688 11.91 mm
7/16-20 UNF	20	.4375	25/64 .3906 9.92 mm	29/64 .4531 11.51 mm	15/32 .4688 11.91 mm
1/2-13 UNC	13	.5000	27/64 .4219 10.72 mm	33/64 .5156 13.10 mm	17/32 .5312 13.49 mm
1/2-20 UNF	20	.5000	29/64 .4531 11.51 mm	33/64 .5156 13.10 mm	17/32 .5312 13.49 mm
9/16-12 UNC	12	.5625	31/64 .4844 12.30 mm	37/64 .5781 14.68 mm	19/32 .5938 15.08 mm
9/16-18 UNF	18	.5625	33/64 .5156 13.10 mm	37/64 .5781 14.68 mm	19/32 .5938 15.08 mm
5/8-11 UNC	11	.6250	17/32 .5312 13.49 mm	41/64 .6406 16.27 mm	21/32 .6562 16.67 mm
5/8-18 UNF	18	.6250	37/64 .5781 14.68 mm	41/64 .6406 16.27 mm	21/32 .6562 16.67 mm
3/4-10 UNC	10	.7500	21/32 .6562 16.67 mm	49/64 .7656 19.45 mm	25/32 .7812 19.84 mm
3/4-16 UNF	16	.7500	11/16 .6875 17.46 mm	49/64 .7656 19.45 mm	25/32 .7812 19.84 mm
7/8-9 UNC	9	.8750	49/64 .7656 19.45 mm	57/64 .8906 22.62 mm	29/32 .9062 23.02 mm
7/8-14 UNF	14	.8750	13/16 .8125 20.64 mm	57/64 .8906 22.62 mm	29/32 .9062 23.02 mm
1-8 UNC	8	1.0000	7/8 .8750 22.22 mm	1-1/64 1.0156 25.80 mm	1-1/32 1.0312 26.19 mm
1-12 UNF	12	1.0000	59/64 .9219 23.42 mm	1-1/64 1.0156 25.80 mm	1-1/32 1.0312 26.19 mm