UNC / UNF tap drill chart

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UNC

THREAD	TPI	TAP DRILL	DECIMAL (IN)	MM	CLEARANCE DRILL, CLOSE / FREE
#1-64 UNC	64	#53	0.0595	1.51	#48 / #46
#2-56 UNC	56	#50	0.0700	1.78	#43 / #41
#3-48 UNC	48	#47	0.0785	1.99	#37 / #35
#4-40 UNC	40	#43	0.0890	2.26	#32 / #30
#5-40 UNC	40	#38	0.1015	2.58	#30 / #29
#6-32 UNC	32	#36	0.1065	2.71	#27 / #25
#8-32 UNC	32	#29	0.1360	3.45	#18 / #16
#10-24 UNC	24	#25	0.1495	3.8	#9 / #7
#12-24 UNC	24	#16	0.1770	4.5	#2 / #1
1/4-20 UNC	20	#7	0.2010	5.11	F / H
5/16-18 UNC	18	F	0.2570	6.53	P / Q
3/8-16 UNC	16	5/16"	0.3125	7.94	W / X
7/16-14 UNC	14	U	0.3680	9.35	29/64" / 15/32"
1/2-13 UNC	13	27/64"	0.4219	10.72	33/64" / 17/32"
9/16-12 UNC	12	31/64"	0.4844	12.3	37/64" / 19/32"
5/8-11 UNC	11	17/32"	0.5313	13.49	41/64" / 21/32"
3/4-10 UNC	10	21/32"	0.6563	16.67	49/64" / 25/32"
7/8-9 UNC	9	49/64"	0.7656	19.45	57/64" / 29/32"
1"-8 UNC	8	7/8"	0.8750	22.23	1-1/64" / 1-1/32"

UNF

THREAD	TPI	TAP DRILL	DECIMAL (IN)	MM	CLEARANCE DRILL, CLOSE / FREE
#0-80 UNF	80	3/64"	0.0469	1.19	#52 / #50
#1-72 UNF	72	#53	0.0595	1.51	#48 / #46
#2-64 UNF	64	#50	0.0700	1.78	#43 / #41
#3-56 UNF	56	#45	0.0820	2.08	#37 / #35
#4-48 UNF	48	#42	0.0935	2.37	#32 / #30
#5-44 UNF	44	#37	0.1040	2.64	#30 / #29
#6-40 UNF	40	#33	0.1130	2.87	#27 / #25
#8-36 UNF	36	#29	0.1360	3.45	#18 / #16
#10-32 UNF	32	#21	0.1590	4.04	#9 / #7
#12-28 UNF	28	#14	0.1820	4.62	#2 / #1
1/4-28 UNF	28	#3	0.2130	5.41	F / H
5/16-24 UNF	24	I	0.2720	6.91	P / Q
3/8-24 UNF	24	Q	0.3320	8.43	W / X
7/16-20 UNF	20	25/64"	0.3906	9.92	29/64" / 15/32"
1/2-20 UNF	20	29/64"	0.4531	11.51	33/64" / 17/32"
9/16-18 UNF	18	33/64"	0.5156	13.1	37/64" / 19/32"
5/8-18 UNF	18	37/64"	0.5781	14.68	41/64" / 21/32"
3/4-16 UNF	16	11/16"	0.6875	17.46	49/64" / 25/32"
7/8-14 UNF	14	13/16"	0.8125	20.64	57/64" / 29/32"
1"-12 UNF	12	59/64"	0.9219	23.42	1-1/64" / 1-1/32"

Tap drills from the standard 75% thread chart for Unified threads (ASME B1.1). Clearance drills: close fit / free fit.

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