

TAP DRILL CHART — UNC / UNF

Unified UN · classes 2B · cutting tap

Drill = standard drill nearest the middle of the internal thread minor Ø tolerance band
57 threads · 2026-10-21

Thread · **Tap drill** · Drill Ø · start drill for BORE · % of thread — diameters in in**BORE** = no standard drill fits: bore or ream to the size shown, starting from the drill after it

#0-80 UNF	3/64	0.0469	81%	1/2-13 UNC	27/64	0.4219	78%
#1-72 UNF	#53	0.0595	75%	9/16-18 UNF	12.9 mm	0.5079	76%
#1-64 UNC	#53	0.0595	67%	9/16-12 UNC	31/64	0.4844	72%
#2-64 UNF	#49	0.0730	64%	5/8-18 UNF	14.5 mm	0.5709	75%
#2-56 UNC	#50	0.0700	69%	5/8-11 UNC	17/32	0.5313	79%
#3-56 UNF	#45	0.0820	73%	3/4-16 UNF	11/16	0.6875	77%
#3-48 UNC	#46	0.0810	67%	3/4-10 UNC	21/32	0.6563	72%
#4-48 UNF	#42	0.0935	68%	7/8-14 UNF	13/16	0.8125	67%
#4-40 UNC	#43	0.0890	71%	7/8-9 UNC	49/64	0.7656	76%
#5-44 UNF	#37	0.1040	71%	1-12 UNF	59/64	0.9219	72%
#5-40 UNC	#38	0.1015	72%	1-8 UNC	7/8	0.8750	77%
#6-40 UNF	#32	0.1160	68%	1-1/8-12 UNF	1-3/64	1.0469	72%
#6-32 UNC	7/64	0.1094	71%	1-1/8-7 UNC	63/64	0.9844	76%
#8-36 UNF	#29	0.1360	78%	1-1/4-12 UNF	1-11/64	1.1719	72%
#8-32 UNC	#29	0.1360	69%	1-1/4-7 UNC	1-7/64	1.1094	76%
#10-32 UNF	#21	0.1590	76%	1-3/8-12 UNF	1-19/64	1.2969	72%
#10-24 UNC	#25	0.1495	75%	1-3/8-6 UNC	1-13/64	1.2031	79%
#12-28 UNF	#14	0.1820	73%	1-1/2-12 UNF	1-27/64	1.4219	72%
#12-24 UNC	#16	0.1770	72%	1-1/2-6 UNC	1-21/64	1.3281	79%
1/4-28 UNF	#3	0.2130	80%	1-3/4-5 UNC	1-35/64	1.5469	78%
1/4-20 UNC	#7	0.2010	75%	2-4.5 UNC	1-25/32	1.7813	76%
5/16-24 UNF	I	0.2720	75%	2-1/4-4.5 UNC	2-1/32	2.0313	76%
5/16-18 UNC	F	0.2570	77%	2-1/2-4 UNC	2-1/4	2.2500	77%
3/8-24 UNF	Q	0.3320	79%	2-3/4-4 UNC	2-1/2	2.5000	77%
3/8-16 UNC	5/16	0.3125	77%	3-4 UNC	2-3/4	2.7500	77%
7/16-20 UNF	25/64	0.3906	72%	3-1/4-4 UNC	3	3.0000	77%
7/16-14 UNC	U	0.3680	75%	3-1/2-4 UNC	3-1/4	3.2500	77%
1/2-20 UNF	29/64	0.4531	72%	3-3/4-4 UNC	3-1/2	3.5000	77%