

KASPERCALC

TAP DRILL CHART — UNC / UNF / UNEF

Unified UN · classes 2B, 3B · cutting tap

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

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

#0-80 UNF	2B	3/64	0.0469	81%	0.0519–0.0542	0.0465–0.0514	5/8-11 UNC	3B	17/32	0.5313	79%	0.5660–0.5714	0.5270–0.5391
#0-80 UNF	3B	3/64	0.0469	81%	0.0519–0.0536	0.0465–0.0514	11/16-24 UNEF	2B	16.5 mm	0.6496	70%	0.6604–0.6657	0.6420–0.6520
#1-72 UNF	2B	#53	0.0595	75%	0.0640–0.0665	0.0580–0.0635	11/16-24 UNEF	3B	BORE	0.6457	41/64	0.6604–0.6643	0.6420–0.6494
#1-72 UNF	3B	#53	0.0595	75%	0.0640–0.0659	0.0580–0.0635	3/4-20 UNEF	2B	45/64	0.7031	72%	0.7175–0.7232	0.6960–0.7070
#1-64 UNC	2B	#53	0.0595	67%	0.0629–0.0655	0.0561–0.0623	3/4-20 UNEF	3B	45/64	0.7031	72%	0.7175–0.7218	0.6960–0.7037
#1-64 UNC	3B	#53	0.0595	67%	0.0629–0.0648	0.0561–0.0623	3/4-16 UNF	2B	11/16	0.6875	77%	0.7094–0.7159	0.6820–0.6960
#2-64 UNF	2B	#49	0.0730	64%	0.0759–0.0786	0.0691–0.0753	3/4-16 UNF	3B	11/16	0.6875	77%	0.7094–0.7143	0.6820–0.6908
#2-64 UNF	3B	#49	0.0730	64%	0.0759–0.0779	0.0691–0.0753	3/4-10 UNC	2B	21/32	0.6563	72%	0.6850–0.6927	0.6420–0.6630
#2-56 UNC	2B	#50	0.0700	69%	0.0744–0.0772	0.0667–0.0737	3/4-10 UNC	3B	16.5 mm	0.6496	77%	0.6850–0.6907	0.6420–0.6545
#2-56 UNC	3B	#50	0.0700	69%	0.0744–0.0765	0.0667–0.0737	13/16-20 UNEF	2B	49/64	0.7656	72%	0.7800–0.7858	0.7580–0.7700
#3-56 UNF	2B	#45	0.0820	73%	0.0874–0.0902	0.0797–0.0865	13/16-20 UNEF	3B	49/64	0.7656	72%	0.7800–0.7843	0.7580–0.7662
#3-56 UNF	3B	#45	0.0820	73%	0.0874–0.0895	0.0797–0.0865	7/8-20 UNEF	2B	53/64	0.8281	72%	0.8425–0.8483	0.8210–0.8320
#3-48 UNC	2B	#46	0.0810	67%	0.0855–0.0885	0.0764–0.0845	7/8-20 UNEF	3B	53/64	0.8281	72%	0.8425–0.8469	0.8210–0.8287
#3-48 UNC	3B	#46	0.0810	67%	0.0855–0.0877	0.0764–0.0845	7/8-14 UNF	2B	13/16	0.8125	67%	0.8286–0.8356	0.7980–0.8130
#4-48 UNF	2B	#42	0.0935	68%	0.0985–0.1016	0.0894–0.0968	7/8-14 UNF	3B	BORE	0.8024	51/64	0.8286–0.8339	0.7980–0.8068
#4-48 UNF	3B	#42	0.0935	68%	0.0985–0.1008	0.0894–0.0968	7/8-9 UNC	2B	49/64	0.7656	76%	0.8028–0.8110	0.7550–0.7780
#4-40 UNC	2B	#43	0.0890	71%	0.0958–0.0991	0.0849–0.0939	7/8-9 UNC	3B	49/64	0.7656	76%	0.8028–0.8089	0.7550–0.7681
#4-40 UNC	3B	#43	0.0890	71%	0.0958–0.0982	0.0849–0.0939	15/16-20 UNEF	2B	57/64	0.8906	72%	0.9050–0.9109	0.8830–0.8950
#5-44 UNF	2B	#37	0.1040	71%	0.1102–0.1134	0.1004–0.1079	15/16-20 UNEF	3B	57/64	0.8906	72%	0.9050–0.9094	0.8830–0.8912
#5-44 UNF	3B	#37	0.1040	71%	0.1102–0.1126	0.1004–0.1079	1-20 UNEF	2B	61/64	0.9531	72%	0.9675–0.9734	0.9460–0.9570
#5-40 UNC	2B	#38	0.1015	72%	0.1088–0.1121	0.0979–0.1062	1-20 UNEF	3B	61/64	0.9531	72%	0.9675–0.9719	0.9460–0.9537
#5-40 UNC	3B	#38	0.1015	72%	0.1088–0.1113	0.0979–0.1062	1-12 UNF	2B	59/64	0.9219	72%	0.9459–0.9535	0.9100–0.9280
#6-40 UNF	2B	#32	0.1160	68%	0.1218–0.1252	0.1110–0.1190	1-12 UNF	3B	BORE	0.9149	29/32	0.9459–0.9516	0.9100–0.9198
#6-40 UNF	3B	#32	0.1160	68%	0.1218–0.1243	0.1110–0.1186	1-8 UNC	2B	7/8	0.8750	77%	0.9188–0.9276	0.8650–0.8900
#6-32 UNC	2B	7/64	0.1094	71%	0.1177–0.1214	0.1040–0.1140	1-8 UNC	3B	7/8	0.8750	77%	0.9188–0.9254	0.8650–0.8797
#6-32 UNC	3B	7/64	0.1094	71%	0.1177–0.1205	0.1040–0.1140	1-1/16-18 UNEF	2B	25.5 mm	1.0039	81%	1.0264–1.0326	1.0020–1.0150
#8-36 UNF	2B	#29	0.1360	78%	0.1460–0.1496	0.1340–0.1420	1-1/16-18 UNEF	3B	25.5 mm	1.0039	81%	1.0264–1.0311	1.0020–1.0105
#8-36 UNF	3B	#29	0.1360	78%	0.1460–0.1487	0.1340–0.1416	1-1/8-18 UNEF	2B	BORE	1.0715	1-1/16	1.0889–1.0951	1.0650–1.0780
#8-32 UNC	2B	#29	0.1360	69%	0.1437–0.1475	0.1300–0.1390	1-1/8-18 UNEF	3B	BORE	1.0690	1-1/16	1.0889–1.0936	1.0650–1.0730
#8-32 UNC	3B	#29	0.1360	69%	0.1437–0.1465	0.1300–0.1389	1-1/8-12 UNF	2B	1-3/64	1.0469	72%	1.0709–1.0787	1.0350–1.0530
#10-32 UNF	2B	#21	0.1590	76%	0.1697–0.1736	0.1560–0.1640	1-1/8-12 UNF	3B	26.5 mm	1.0433	75%	1.0709–1.0768	1.0350–1.0448
#10-32 UNF	3B	#20	0.1610	71%	0.1697–0.1726	0.1560–0.1641	1-1/8-7 UNC	2B	63/64	0.9844	76%	1.0322–1.0416	0.9700–0.9980
#10-24 UNC	2B	#25	0.1495	75%	0.1629–0.1672	0.1450–0.1550	1-1/8-7 UNC	3B	63/64	0.9844	76%	1.0322–1.0393	0.9700–0.9875
#10-24 UNC	3B	#25	0.1495	75%	0.1629–0.1661	0.1450–0.1555	1-3/16-18 UNEF	2B	BORE	1.1335	1-1/8	1.1514–1.1577	1.1270–1.1400
#12-32 UNEF	2B	#13	0.1850	76%	0.1957–0.1998	0.1820–0.1900	1-3/16-18 UNEF	3B	BORE	1.1313	1-1/8	1.1514–1.1561	1.1270–1.1355
#12-32 UNEF	3B	#13	0.1850	76%	0.1957–0.1988	0.1820–0.1895	1-1/4-18 UNEF	2B	30.5 mm	1.2008	68%	1.2139–1.2202	1.1900–1.2030
#12-28 UNF	2B	#14	0.1820	73%	0.1928–0.1970	0.1770–0.1860	1-1/4-18 UNEF	3B	BORE	1.1940	1-3/16	1.2139–1.2186	1.1900–1.1980
#12-28 UNF	3B	#14	0.1820	73%	0.1928–0.1959	0.1770–0.1857	1-1/4-12 UNF	2B	1-11/64	1.1719	72%	1.1959–1.2039	1.1600–1.1780
#12-24 UNC	2B	#16	0.1770	72%	0.1889–0.1933	0.1710–0.1810	1-1/4-12 UNF	3B	29.5 mm	1.1614	82%	1.1959–1.2019	1.1600–1.1698
#12-24 UNC	3B	#16	0.1770	72%	0.1889–0.1922	0.1710–0.1807	1-1/4-7 UNC	2B	1-7/64	1.1094	76%	1.1572–1.1668	1.0950–1.1230
1/4-32 UNEF	2B	#2	0.2210	71%	0.2297–0.2339	0.2160–0.2240	1-1/4-7 UNC	3B	1-7/64	1.1094	76%	1.1572–1.1644	1.0950–1.1125
1/4-32 UNEF	3B	7/32	0.2188	77%	0.2297–0.2328								