

# TECHNICAL DATA

## INCH TAP DRILL SIZES



Nominal Size	Threads per Inch		Drills for Regular Taps				Drills for Roll Taps
	NC/UNC	NF/UNF	Drill Size	Inch Equiv.	Probable Hole Size (Inches)	Probable Percent of Thread	Drill for 50-65%
0		80	3/36	.0469	.0484	71	54
1	64	72	53	.0595	.0610	59	51
2	56	64	50	.0700	.0717	62	47
3	48	56	47	.0785	.0804	69	2.0mm
4	40	48	45	.0820	.0839	65	2.3mm
5	40	44	43	.0890	.0910	65	38
6	32	40	42	.0935	.0955	61	2.6mm
8	32	36	38	.1015	.1038	65	2.9mm
10	24	32	37	.1040	.1063	63	32
12	24	28	36	.1065	.1088	72	1/8
1/4	20	28	33	.1130	.1156	69	3.25mm
5/16	18	24	29	.1360	.1389	62	3.8mm
3/8	16	24	29	.1360	.1389	70	24
7/16	14	20	25	.1495	.1527	69	11/64
1/2	13	20	21	.1590	.1622	68	16
9/16	12	18	16	.1770	.1805	66	8
5/8	11	18	14	.1820	.1855	66	7
3/4	10	16	7	.2010	.2048	70	1
7/8	9	14	3	.2130	.2168	72	15/64
1	8	12	F	.2570	.2608	72	L
1 1/8	7	12	1	.2720	.2761	67	7.5mm
1 1/4	7	12	5/16	.3125	.3169	72	8.9mm
1 3/8	6	12	Q	.3320	.3364	71	T
1 1/2	6	12	U	.3680	.3726	70	Z
			25/64	.3906	.3952	65	27/64
			27/64	.4219	.4266	73	15/32
			29/64	.4531	.4578	65	31/64
			31/64	.4844	.4892	68	17/32
			33/64	.5156	.5204	58	35/64
			17/32	.5312	.5362	75	15mm
			37/64	.5781	.5831	58	19/32
			21/32	.6562	.6613	68	18mm
			11/16	.6875	.6925	71	18.5mm
			49/64	.7656	.7708	72	
			13/16	.8125	.8177	62	
			7/8	.8750	.8809	73	
			59/64	.9219	.9279	67	
			63/64	.9844	.9911	72	
			1 3/64	1.0469	1.0541	65	
			1 7/64	1.1094			
			1 11/64	1.1719			
			1 7/64	1.2187			
			1 1/19/64	1.2969			
			1 11/32	1.3437			
			1 27/64	1.4219			

# TECHNICAL DATA

## SCREW THREAD INSERT (STI) TAPS

### STI DRILL SIZES



Unified Coarse				
Nominal Thread Size	Minor Diameter (After Tapping)		Suggested Drill Size	
	Min.	Max.	Aluminum	Steel, Magnesium, Plastic
2 (.086)-56	.0899	.0961	3/32 (.0938)	#41 (.0960)
3 (.099)-40	.10367	.1104	#36 (.1065)	7/64 (.1092)
4 (.112)-40	.1175	.1252	#31 (.1200)	#31 (.1200)
5 (.125)-40	.1305	.1373	3.4mm (.1339)	#29 (.1360)
6 (.138)-32	.1448	.1527	#26 (.1470)	#25 (.1495)
8 (.164)-32	.1708	.1781	#17 (.1730)	#16 (.1770)
10 (.190)-24	.1990	.2000	13/64 (.2031)	#5 (.2055)
12 (.216)-24	.2250	.2340	#1 (.2280)	#1 (.2280)
1/4 (.250)-20	.2608	.2704	H (.2660)	H (.2660)
5/16 (.3125)-18	.3245	.3342	Q (.3320)	Q (.3320)
3/8 (.3750)-16	.3885	.3987	X (.3970)	X (.3970)
7/16 (.4375)-14	.4530	.4639	29/64 (.4531)	29/64 (.4531)
1/2 (.5000)-13	.5166	.5273	33/64 (.5156)	17/32 (.5312)

Unified Fine				
Nominal Thread Size	Minor Diameter (After Tapping)		Suggested Drill Size	
	Min.	Max.	Aluminum	Steel, Magnesium, Plastic
3 (.099)-56	.1029	.1086	#37 (.1040)	#36 (.1065)
4 (.112)-48	.1166	.1229	3mm (.1181)	#31 (.1200)
6 (.138)-40	.1435	.1503	#26 (.1470)	#25 (.1495)
8 (.164)-36	.1701	.1771	#17 (.1730)	#16 (.1770)
10 (.190)-32	.1968	.2041	#7 (.2010)	13/64 (.2031)
1/4 (.2500)-28	.2577	.2646	G (.2610)	6.7mm (.2638)
5/16 (.3125)-24	.3215	.3288	21/64 (.3281)	21/64 (.3281)
3/8 (.3750)-24	.3840	.3910	25/64 (.3906)	25/64 (.3906)
7/16 (.4375)-20	.4483	.4561	29/64 (.4531)	29/64 (.4531)
1/2 (.5000)-20	.5108	.5186	33/64 (.5156)	33/64 (.5156)