

RECOMMENDED DRILLING SIZES FOR TAPPING IMPERIAL THREADS

UNC				UNF			
Unified National Coarse				Unified National Fine			
Tap Size	t.p.i	Tapping Drill mm	Clearance Drill mm	Tap Size	t.p.i	Tapping Drill mm	Clearance Drill mm
No.1	64	1.55	2.10	No.0	80	1.20	1.90
No.2	56	1.85	2.50	No.1	72	1.50	2.10
No.3	48	2.10	2.80	No.2	64	1.80	2.50
No.4	40	2.35	3.30	No.3	56	2.10	2.80
No.5	40	2.65	3.50	No.4	48	2.40	3.30
No.6	32	2.85	3.80	No.5	44	2.70	3.50
No.8	32	3.50	4.50	No.6	40	2.90	3.80
No.10	24	3.90	5.10	No.8	36	3.50	4.50
No.12	24	4.50	5.80	No.10	32	4.10	5.10
1/4	20	5.10	6.80	No.12	28	4.70	5.80
5/16	18	6.60	8.50	1/4	28	5.50	6.80
3/8	16	8.00	10.00	5/16	24	6.90	8.50
7/16	14	9.40	12.00	3/8	24	8.50	10.00
1/2	13	10.80	13.50	7/16	20	9.90	12.00
9/16	12	12.20	15.50	1/2	20	11.50	13.50
5/8	11	13.50	17.50	9/16	18	12.90	15.50
3/4	10	16.50	20.50	5/8	18	14.50	17.50
7/8	9	19.50	23.50	3/4	16	17.50	20.50
1	8	22.25	27.50	7/8	14	20.50	23.50
1-1/8	7	25.00	31.00	1	12	23.25	27.50
1-1/4	7	28.00	34.00	1*	14	23.50	27.50
1-3/8	6	30.50	38.00	1-1/8	12	26.50	31.00
1-1/2	6	34.00	41.00	1-1/4	12	29.50	34.00
1-3/4	5	39.50	48.00	1-3/8	12	32.75	38.00
2	4.5	45.00	54.00	1-1/2	12	36.00	41.00

