

Please note, this information is for general recommendation and may not be applicable for every application.

| Nominal size | Threads per Inch |     | Basic Major Diameter in inches | Suggested |     |     |               |     |    |     | Recommended Drill Sizes |                         |                                      |                              | Taps suggested for class of thread |    |
|--------------|------------------|-----|--------------------------------|-----------|-----|-----|---------------|-----|----|-----|-------------------------|-------------------------|--------------------------------------|------------------------------|------------------------------------|----|
|              | UNC              | UNF |                                | Plug Tap  |     |     | Bottoming Tap |     |    |     | Theoretical drill size  |                         | Recom. drill size approx. 65% thread | decimal equivalent in inches |                                    |    |
|              |                  |     |                                |           |     |     |               |     |    |     |                         | Max. Approx. 55% thread |                                      |                              | Min. Approx. 55% thread            |    |
| 0            | --               | 80  | 0.0600                         | --        | --  | --  | H2            | --  | -- | --  | 0.0553                  | 0.0537                  | 54                                   | 0.0550                       | --                                 | H2 |
| 1            | 64               | --  | 0.0730                         | --        | --  | --  | H2            | --  | -- | --  | 0.0671                  | 0.0652                  | 51                                   | 0.0670                       | --                                 | H2 |
| 1            | --               | 72  | 0.0730                         | --        | --  | --  | H2            | --  | -- | --  | 0.0678                  | 0.0661                  | 51                                   | 0.0670                       | --                                 | H2 |
| 2            | 56               | --  | 0.0860                         | --        | --  | --  | H2            | H3  | -- | --  | 0.0793                  | 0.0771                  | 5/64                                 | 0.0781                       | H3                                 | H2 |
| 2            | --               | 64  | 0.0860                         | --        | --  | --  | H2            | H3  | -- | --  | 0.0801                  | 0.0782                  | 47                                   | 0.0785                       | H3                                 | H2 |
| 3            | 48               | --  | 0.0990                         | --        | --  | --  | H2            | H3  | -- | --  | 0.0912                  | 0.0886                  | 43                                   | 0.0890                       | H3                                 | H2 |
| 3            | --               | 56  | 0.0990                         | --        | --  | --  | H2            | H3  | -- | --  | 0.0923                  | 0.0901                  | 2.3mm                                | 0.0905                       | H3                                 | H2 |
| 4            | 40               | --  | 0.1120                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1026                  | 0.0995                  | 38                                   | 0.1015                       | H5                                 | H3 |
| 4            | --               | 48  | 0.1120                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1042                  | 0.1016                  | 2.6mm                                | 0.1024                       | H5                                 | H3 |
| 5            | 40               | --  | 0.1250                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1156                  | 0.1125                  | 2.9mm                                | 0.1142                       | H5                                 | H3 |
| 5            | --               | 44  | 0.1250                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1165                  | 0.1136                  | 32                                   | 0.1160                       | H5                                 | H3 |
| 6            | 32               | --  | 0.1380                         | H3        | H5  | H10 | --            | H3  | H5 | H10 | 0.1273                  | 0.1224                  | 1/8                                  | 0.1250                       | H5                                 | H3 |
| 6            | --               | 40  | 0.1380                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1286                  | 0.1255                  | 3.25mm                               | 0.1280                       | H5                                 | H3 |
| 8            | 32               | --  | 0.1640                         | H3        | H5  | H10 | --            | H3  | H5 | H10 | 0.1532                  | 0.1484                  | 25                                   | 0.1495                       | H5                                 | H3 |
| 8            | --               | 36  | 0.1640                         | H3        | H5  | --  | --            | H3  | H5 | --  | 0.1536                  | 0.1501                  | 24                                   | 0.1520                       | H5                                 | H3 |
| 10           | 24               | --  | 0.1900                         | H4        | H6  | H10 | --            | H4  | H6 | H10 | 0.1744                  | 0.1692                  | 11/64                                | 0.1719                       | H6                                 | H4 |
| 10           | --               | 32  | 0.1900                         | H4        | H6  | H10 | --            | H4  | H6 | H10 | 0.1783                  | 0.1744                  | 16                                   | 0.1770                       | H6                                 | H4 |
| 12           | 24               | --  | 0.2160                         | H4        | H6  | --  | --            | H4  | H6 | --  | 0.2004                  | 0.1952                  | 8                                    | 0.1990                       | H6                                 | H4 |
| 12           | --               | 28  | 0.2160                         | H4        | H6  | --  | --            | H4  | H6 | --  | 0.2026                  | 0.1982                  | 7                                    | 0.2010                       | H6                                 | H4 |
| 1/4          | 20               | --  | 0.2500                         | H4        | H6  | H10 | --            | H4  | H6 | H10 | 0.2312                  | 0.2250                  | 1                                    | 0.2280                       | H6                                 | H4 |
| 1/4          | --               | 28  | 0.2500                         | H4        | H6  | --  | --            | H4  | H6 | --  | 0.2366                  | 0.2322                  | 15/64                                | 0.2344                       | H6                                 | H4 |
| 5/16         | 18               | --  | 0.3125                         | --        | H5  | H7  | --            | H5  | H7 | --  | 0.2917                  | 0.2847                  | L                                    | 0.2900                       | H7                                 | H5 |
| 5/16         | --               | 24  | 0.3125                         | --        | H5  | H7  | --            | H5  | H7 | --  | 0.2969                  | 0.2917                  | M                                    | 0.2950                       | H7                                 | H5 |
| 3/8          | 16               | --  | 0.3750                         | --        | H5  | H7  | --            | H5  | H7 | --  | 0.3516                  | 0.3428                  | S                                    | 0.3480                       | H7                                 | H5 |
| 3/8          | --               | 24  | 0.3750                         | --        | H5  | H7  | --            | H5  | H7 | --  | 0.3594                  | 0.3542                  | T                                    | 0.3580                       | H7                                 | H5 |
| 7/16         | 14               | --  | 0.4375                         | --        | H5  | H8  | --            | H5  | H8 | --  | 0.4107                  | 0.4018                  | 13/32                                | 0.4062                       | H8                                 | H5 |
| 7/16         | --               | 20  | 0.4375                         | --        | H5  | H8  | --            | H5  | H8 | --  | 0.4187                  | 0.4125                  | Z                                    | 0.4130                       | H8                                 | H5 |
| 1/2          | 13               | --  | 0.5000                         | --        | H5  | H8  | --            | H5  | H8 | --  | 0.4712                  | 0.4615                  | 15/32                                | 0.4682                       | H8                                 | H5 |
| 1/2          | --               | 20  | 0.5000                         | --        | H5  | H8  | --            | H5  | H8 | --  | 0.4830                  | 0.4750                  | 12.25mm                              | 0.4823                       | H8                                 | H5 |
| 9/16         | 12               | --  | 0.5625                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.5313                  | 0.5200                  | 17/32                                | 0.5313                       | H10                                | H7 |
| 9/16         | --               | 18  | 0.5625                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.5417                  | 0.5342                  | 13.65mm                              | 0.5374                       | H10                                | H7 |
| 5/8          | 11               | --  | 0.6250                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.5910                  | 0.5786                  | 14.85mm                              | 0.5846                       | H10                                | H7 |
| 5/8          | --               | 18  | 0.6250                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.6042                  | 0.5967                  | 15.25mm                              | 0.6004                       | H10                                | H7 |
| 3/4          | 10               | --  | 0.7500                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.7126                  | 0.6990                  | 45/64                                | 0.7031                       | H10                                | H7 |
| 3/4          | --               | 16  | 0.7500                         | H7        | H10 | --  | H7            | H10 | -- | --  | 0.7266                  | 0.7181                  | 23/32                                | 0.7188                       | H10                                | H7 |