0-80 Tap Drill Chart

Unified National Fine (UNF) · 80 threads per inch · ASME B1.1

TAP DRILL (81% THREAD)

3/64" = 0.0469 in = 1.19 mm

Drills for 0-80 (50–85% thread)

DRILL	INCH	MM	% THREAD	
3/64"	0.0469	1.19	81%	Recommended
#56	0.0465	1.18	83%	

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	#51	0.0670	1.70
Normal	#50	0.0700	1.78
Loose	#48	0.0760	1.93

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.0600	1.52
Pitch diameter (basic)	0.0519	1.32
Minor diameter, internal (basic)	0.0465	1.18
Pitch (1/80 in)	0.0125	0.32

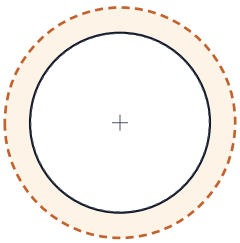
Actual size

Print at 100% scale ("Actual size", not "Fit to page"). Check with the rulers below.

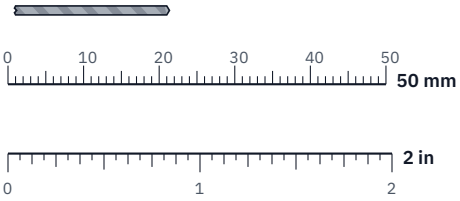


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 20x:



Tap drill, actual size (1.19 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/0-80/

Values from the ASME B1.1, ISO 261/68-1 and ASME B1.20.1 thread formulas; drill sizes per ASME B94.11M; clearance holes per ISO 273. Method: whatsizeis.com/how-we-calculate/