1-1/2-18 Tap Drill Chart

Unified National Extra Fine (UNEF) · 18 threads per inch · ASME B1.1

TAP DRILL (65% THREAD)

1-29/64" = 1.4531 in = 36.91 mm

Drills for 1-1/2-18 (50–85% thread)

DRILL	INCH	MM	% THREAD	
1-29/64"	**1.4531**	**36.91**	**65%**	Recommended

Clearance hole (bolt passes through)

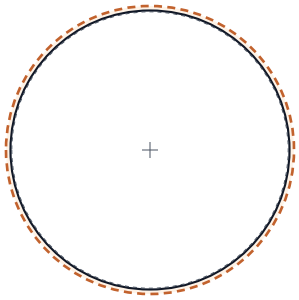
FIT	DRILL	INCH	MM
Close	1-35/64"	**1.5469**	**39.29**
Normal	1-5/8"	**1.6250**	**41.28**
Loose	1-3/4"	**1.7500**	**44.45**

Thread dimensions (basic)

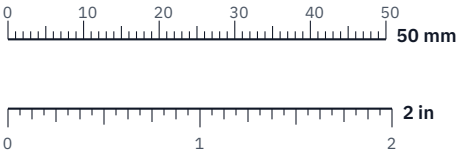
DIMENSION	INCH	MM
Major diameter (basic)	**1.5000**	**38.10**
Pitch diameter (basic)	**1.4639**	**37.18**
Minor diameter, internal (basic)	**1.4399**	**36.57**
Pitch (1/18 in)	**0.0556**	**1.41**

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.



Scan for the interactive version:

whatsizeis.com/tap-drill/1-1-2-18/

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/