1-1/8-18 Tap Drill Chart

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

TAP DRILL (65% THREAD)

1-5/64" = 1.0781 in = 27.38 mm

Drills for 1-1/8-18 (50–85% thread)

DRILL	INCH	MM	% THREAD	
1-5/64"	**1.0781**	**27.38**	**65%**	Recommended

Clearance hole (bolt passes through)

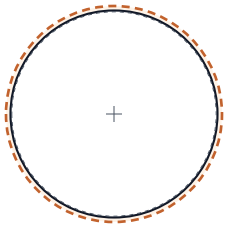
FIT	DRILL	INCH	MM
Close	1-11/64"	**1.1719**	**29.77**
Normal	1-1/4"	**1.2500**	**31.75**
Loose	1-21/64"	**1.3281**	**33.73**

Thread dimensions (basic)

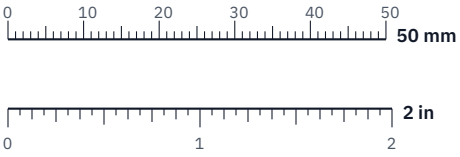
DIMENSION	INCH	MM
Major diameter (basic)	**1.1250**	**28.58**
Pitch diameter (basic)	**1.0889**	**27.66**
Minor diameter, internal (basic)	**1.0649**	**27.05**
Pitch (1/18 in)	**0.0556**	**1.41**

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/1-1-8-18/

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/