1-1/8-7 Tap Drill Chart

Unified National Coarse (UNC) · 7 threads per inch · ASME B1.1

TAP DRILL (76% THREAD)

63/64" = 0.9844 in = 25.00 mm

Drills for 1-1/8-7 (50–85% thread)

DRILL	INCH	MM	% THREAD	
1-1/32"	1.0313	26.19	51%	
1-1/64"	1.0156	25.80	59%	
1"	1.0000	25.40	67%	
63/64"	0.9844	25.00	76%	Recommended
31/32"	0.9688	24.61	84%	

Clearance hole (bolt passes through)

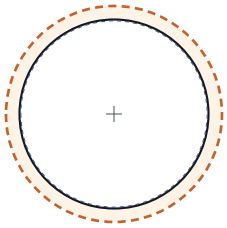
FIT	DRILL	INCH	MM
Close	1-11/64"	1.1719	29.77
Normal	1-1/4"	1.2500	31.75
Loose	1-21/64"	1.3281	33.73

Thread dimensions (basic)

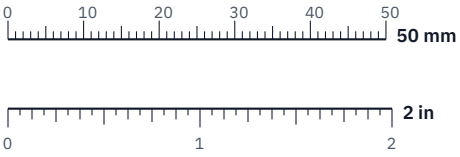
DIMENSION	INCH	MM
Major diameter (basic)	1.1250	28.58
Pitch diameter (basic)	1.0322	26.22
Minor diameter, internal (basic)	0.9704	24.65
Pitch (1/7 in)	0.1429	3.63

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/1-1-8-7/

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/