1-3/8-6 Tap Drill Chart

Unified National Coarse (UNC) · 6 threads per inch · ASME B1.1

TAP DRILL (72% THREAD)

1-7/32" = 1.2188 in = 30.96 mm

Drills for 1-3/8-6 (50–85% thread)

DRILL	INCH	MM	% THREAD	
1-17/64"	1.2656	32.15	51%	
1-1/4"	1.2500	31.75	58%	
1-15/64"	1.2344	31.35	65%	
1-7/32"	1.2188	30.96	72%	Recommended
1-13/64"	1.2031	30.56	79%	

Clearance hole (bolt passes through)

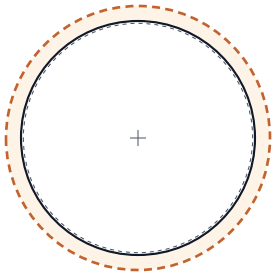
FIT	DRILL	INCH	MM
Close	1-27/64"	1.4219	36.12
Normal	1-1/2"	1.5000	38.10
Loose	1-39/64"	1.6094	40.88

Thread dimensions (basic)

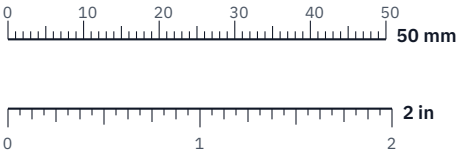
DIMENSION	INCH	MM
Major diameter (basic)	1.3750	34.93
Pitch diameter (basic)	1.2667	32.18
Minor diameter, internal (basic)	1.1946	30.34
Pitch (1/6 in)	0.1667	4.23

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/1-3-8-6/

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/