1-72 Tap Drill Chart

Unified National Fine (UNF) · 72 threads per inch · ASME B1.1

TAP DRILL (75% THREAD)

#53 = 0.0595 in = 1.51 mm

Drills for 1-72 (50–85% thread)

DRILL	INCH	MM	% THREAD	
#52	0.0635	1.61	53%	
1/16"	0.0625	1.59	58%	
#53	0.0595	1.51	75%	Recommended

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	#46	0.0810	2.06
Normal	#44	0.0860	2.18
Loose	#41	0.0960	2.44

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.0730	1.85
Pitch diameter (basic)	0.0640	1.63
Minor diameter, internal (basic)	0.0580	1.47
Pitch (1/72 in)	0.0139	0.35

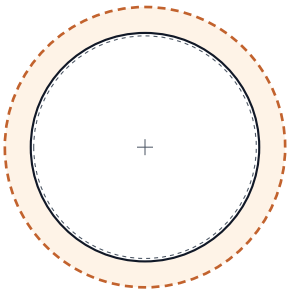
Actual size

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

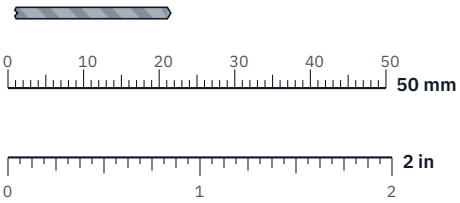


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 20x:



Tap drill, actual size (1.51 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/1-72/

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/