1-8 Tap Drill Chart

Unified National Coarse (UNC) · 8 threads per inch · ASME B1.1

TAP DRILL (77% THREAD)

7/8" = 0.8750 in = 22.23 mm

Drills for 1-8 (50–85% thread)

DRILL	INCH	MM	% THREAD	
29/32"	0.9063	23.02	58%	
57/64"	0.8906	22.62	67%	
7/8"	0.8750	22.23	77%	Recommended

Clearance hole (bolt passes through)

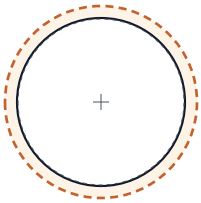
FIT	DRILL	INCH	MM
Close	1-3/64"	1.0469	26.59
Normal	1-7/64"	1.1094	28.18
Loose	1-3/16"	1.1875	30.16

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.0000	25.40
Pitch diameter (basic)	0.9188	23.34
Minor diameter, internal (basic)	0.8647	21.96
Pitch (1/8 in)	0.1250	3.18

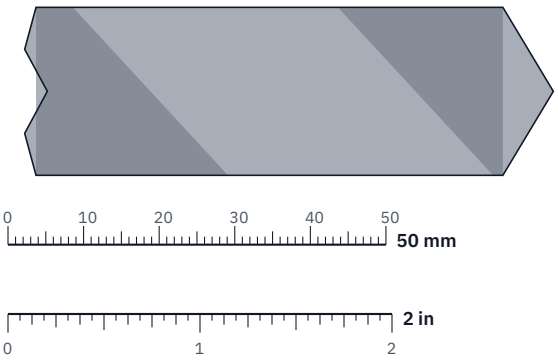
Actual size

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.

Tap drill, actual size (22.22 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/1-8/

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/