10-24 Tap Drill Chart

Unified National Coarse (UNC) · 24 threads per inch · ASME B1.1

TAP DRILL (75% THREAD)

#25 = 0.1495 in = 3.80 mm

Drills for 10-24 (50–85% thread)

DRILL	INCH	MM	% THREAD	
#20	0.1610	4.09	54%	
#21	0.1590	4.04	57%	
#22	0.1570	3.99	61%	
5/32"	0.1563	3.97	62%	
#23	0.1540	3.91	67%	
#24	0.1520	3.86	70%	
#25	0.1495	3.80	75%	Recommended
#26	0.1470	3.73	79%	
#27	0.1440	3.66	85%	

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	13/64"	0.2031	5.16
Normal	#3	0.2130	5.41
Loose	#1	0.2280	5.79

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.1900	4.83
Pitch diameter (basic)	0.1629	4.14
Minor diameter, internal (basic)	0.1449	3.68
Pitch (1/24 in)	0.0417	1.06

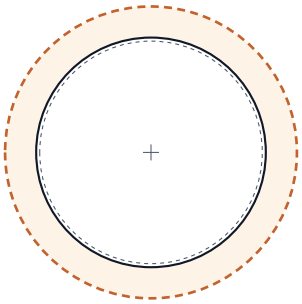
Actual size

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

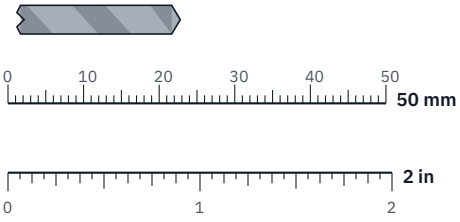


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 8x:



Tap drill, actual size (3.80 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/10-24/

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/