# 3-48 Tap Drill Chart

Unified National Coarse (UNC) · 48 threads per inch · ASME B1.1

TAP DRILL (76% THREAD)

**#47** = 0.0785 in = 1.99 mm

## Drills for 3-48 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| #45 | 0.0820 | 2.08 | 63% | |
| #46 | 0.0810 | 2.06 | 67% | |
| #47 | 0.0785 | 1.99 | 76% | Recommended |
| 5/64" | 0.0781 | 1.98 | 77% | |
| #48 | 0.0760 | 1.93 | 85% | |

## Clearance hole (bolt passes through)

| FIT | DRILL | INCH | MM |
|---|---|---|---|
| Close | 7/64" | 0.1094 | 2.78 |
| Normal | #32 | 0.1160 | 2.95 |
| Loose | 1/8" | 0.1250 | 3.18 |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| Major diameter (basic) | 0.0990 | 2.51 |
| Pitch diameter (basic) | 0.0855 | 2.17 |
| Minor diameter, internal (basic) | 0.0764 | 1.94 |
| Pitch (1/48 in) | 0.0208 | 0.53 |

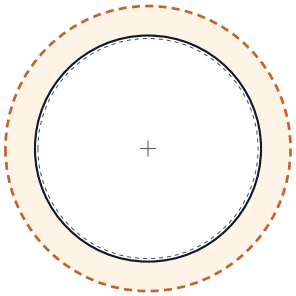
## Actual size

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

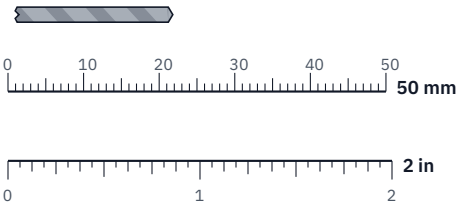


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

**Enlarged 15x:**



**Tap drill, actual size (1.99 mm):**




Scan for the interactive version:

**whatsizeis.com/tap-drill/3-48/**

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/