# 3/8-24 Tap Drill Chart

Unified National Fine (UNF) · 24 threads per inch · ASME B1.1

TAP DRILL (79% THREAD)

**Q = 0.3320 in = 8.43 mm**

## Drills for 3/8-24 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| 11/32" | 0.3438 | 8.73 | 58% | |
| R | 0.3390 | 8.61 | 67% | |
| Q | 0.3320 | 8.43 | 79% | Recommended |

## Clearance hole (bolt passes through)

| FIT | DRILL | INCH | MM |
|---|---|---|---|
| Close | X | 0.3970 | 10.08 |
| Normal | 27/64" | 0.4219 | 10.72 |
| Loose | 15/32" | 0.4688 | 11.91 |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| Major diameter (basic) | 0.3750 | 9.53 |
| Pitch diameter (basic) | 0.3479 | 8.84 |
| Minor diameter, internal (basic) | 0.3299 | 8.38 |
| Pitch (1/24 in) | 0.0417 | 1.06 |

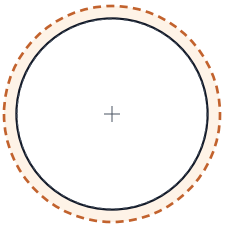
## Actual size

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 3x:**



**Tap drill, actual size (8.43 mm):**









Scan for the interactive version:

**whatsizeis.com/tap-drill/3-8-24/**

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/