# 5/16-18 Tap Drill Chart

Unified National Coarse (UNC) · 18 threads per inch · ASME B1.1

TAP DRILL (77% THREAD)

**F = 0.2570 in = 6.53 mm**

## Drills for 5/16-18 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| I | 0.2720 | 6.91 | 56% | |
| H | 0.2660 | 6.76 | 64% | |
| 17/64" | 0.2656 | 6.75 | 65% | |
| G | 0.2610 | 6.63 | 71% | |
| F | 0.2570 | 6.53 | 77% | Recommended |

## Clearance hole (bolt passes through)

| FIT | DRILL | INCH | MM |
|---|---|---|---|
| Close | Q | 0.3320 | 8.43 |
| Normal | T | 0.3580 | 9.09 |
| Loose | 25/64" | 0.3906 | 9.92 |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| Major diameter (basic) | 0.3125 | 7.94 |
| Pitch diameter (basic) | 0.2764 | 7.02 |
| Minor diameter, internal (basic) | 0.2524 | 6.41 |
| Pitch (1/18 in) | 0.0556 | 1.41 |

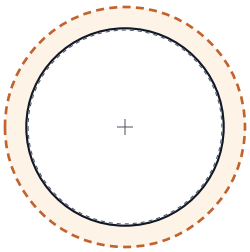
## Actual size

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

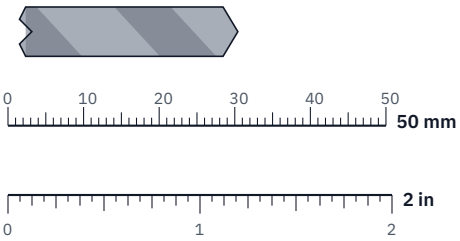


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

**Enlarged 4x:**



**Tap drill, actual size (6.53 mm):**




Scan for the interactive version:

**whatsizeis.com/tap-drill/5-16-18/**

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/