5/16-24 Tap Drill Chart

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

TAP DRILL (75% THREAD)

I = 0.2720 in = 6.91 mm

Drills for 5/16-24 (50–85% thread)

DRILL	INCH	MM	% THREAD	
9/32"	0.2813	7.14	58%	
K	0.2810	7.14	58%	
J	0.2770	7.04	66%	
I	0.2720	6.91	75%	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)	0.2854	7.25
Minor diameter, internal (basic)	0.2674	6.79
Pitch (1/24 in)	0.0417	1.06

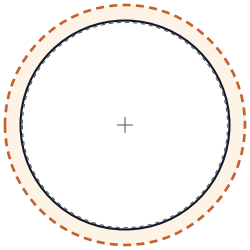
Actual size

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 4x:



Tap drill, actual size (6.91 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/5-16-24/

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/