5-40 Tap Drill Chart

Unified National Coarse (UNC) · 40 threads per inch · ASME B1.1

TAP DRILL (72% THREAD)

#38 = 0.1015 in = 2.58 mm

Drills for 5-40 (50–85% thread)

DRILL	INCH	MM	% THREAD	
#36	0.1065	2.71	57%	
#37	0.1040	2.64	65%	
#38	0.1015	2.58	72%	Recommended
#39	0.0995	2.53	79%	
#40	0.0980	2.49	83%	

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	#29	0.1360	3.45
Normal	#27	0.1440	3.66
Loose	#24	0.1520	3.86

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.1250	3.18
Pitch diameter (basic)	0.1088	2.76
Minor diameter, internal (basic)	0.0979	2.49
Pitch (1/40 in)	0.0250	0.64

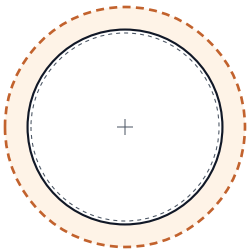
Actual size

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

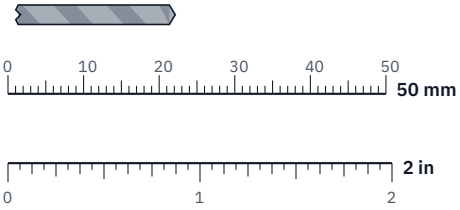


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 10x:



Tap drill, actual size (2.58 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/5-40/

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/