5-44 Tap Drill Chart

Unified National Fine (UNF) · 44 threads per inch · ASME B1.1

TAP DRILL (71% THREAD)

#37 = 0.1040 in = 2.64 mm

Drills for 5-44 (50–85% thread)

DRILL	INCH	MM	% THREAD	
#35	0.1100	2.79	51%	
7/64"	0.1094	2.78	53%	
#36	0.1065	2.71	63%	
#37	0.1040	2.64	71%	Recommended
#38	0.1015	2.58	80%	

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)	0.1102	2.80
Minor diameter, internal (basic)	0.1004	2.55
Pitch (1/44 in)	0.0227	0.58

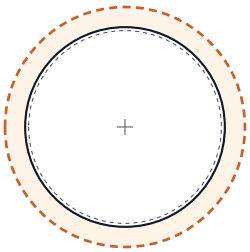
Actual size

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

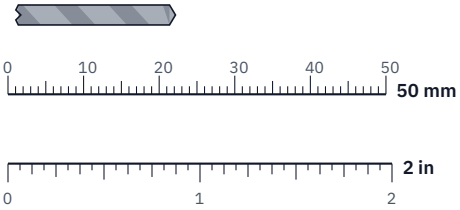


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 10x:



Tap drill, actual size (2.64 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/5-44/

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/