5/8-18 Tap Drill Chart

Unified National Fine (UNF) · 18 threads per inch · ASME B1.1

TAP DRILL (65% THREAD)

37/64" = 0.5781 in = 14.68 mm

Drills for 5/8-18 (50–85% thread)

DRILL	INCH	MM	% THREAD	
37/64"	**0.5781**	**14.68**	**65%**	Recommended

Clearance hole (bolt passes through)

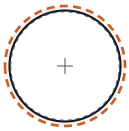
FIT	DRILL	INCH	MM
Close	43/64"	**0.6719**	**17.07**
Normal	11/16"	**0.6875**	**17.46**
Loose	47/64"	**0.7344**	**18.65**

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	**0.6250**	**15.88**
Pitch diameter (basic)	**0.5889**	**14.96**
Minor diameter, internal (basic)	**0.5649**	**14.35**
Pitch (1/18 in)	**0.0556**	**1.41**

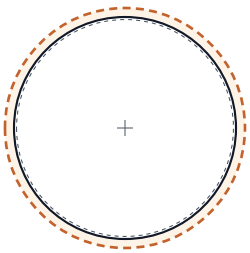
Actual size

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 2x:



Tap drill, actual size (14.68 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/5-8-18/

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/