# 5/8-24 Tap Drill Chart

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

TAP DRILL (87% THREAD)

**37/64"** = 0.5781 in = 14.68 mm

## Drills for 5/8-24 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| 19/32" | 0.5938 | 15.08 | 58% | |
| 37/64" | 0.5781 | 14.68 | 87% | Recommended |

## Clearance hole (bolt passes through)

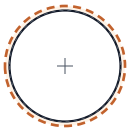
| FIT | DRILL | INCH | MM |
|---|---|---|---|
| Close | 43/64" | 0.6719 | 17.07 |
| Normal | 11/16" | 0.6875 | 17.46 |
| Loose | 47/64" | 0.7344 | 18.65 |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| Major diameter (basic) | 0.6250 | 15.88 |
| Pitch diameter (basic) | 0.5979 | 15.19 |
| Minor diameter, internal (basic) | 0.5799 | 14.73 |
| Pitch (1/24 in) | 0.0417 | 1.06 |

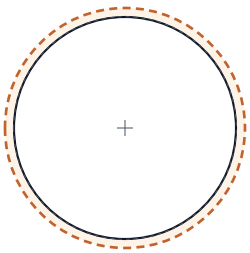
## Actual size

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 2x:**



**Tap drill, actual size (14.68 mm):**









Scan for the interactive version:

**whatsizeis.com/tap-drill/5-8-24/**

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/