7/8-9 Tap Drill Chart

Unified National Coarse (UNC) · 9 threads per inch · ASME B1.1

TAP DRILL (76% THREAD)

49/64" = 0.7656 in = 19.45 mm

Drills for 7/8-9 (50–85% thread)

DRILL	INCH	MM	% THREAD	
51/64"	0.7969	20.24	54%	
25/32"	0.7813	19.84	65%	
49/64"	0.7656	19.45	76%	Recommended

Clearance hole (bolt passes through)

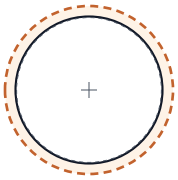
FIT	DRILL	INCH	MM
Close	59/64"	0.9219	23.42
Normal	31/32"	0.9688	24.61
Loose	1-3/64"	1.0469	26.59

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.8750	22.23
Pitch diameter (basic)	0.8028	20.39
Minor diameter, internal (basic)	0.7547	19.17
Pitch (1/9 in)	0.1111	2.82

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.

Tap drill, actual size (19.45 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/7-8-9/

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/