9/16-18 Tap Drill Chart

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

TAP DRILL (65% THREAD)

33/64" = 0.5156 in = 13.10 mm

Drills for 9/16-18 (50–85% thread)

DRILL	INCH	MM	% THREAD	
33/64"	0.5156	13.10	65%	Recommended

Clearance hole (bolt passes through)

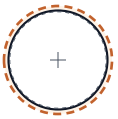
FIT	DRILL	INCH	MM
Close	39/64"	0.6094	15.48
Normal	5/8"	0.6250	15.88
Loose	43/64"	0.6719	17.07

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.5625	14.29
Pitch diameter (basic)	0.5264	13.37
Minor diameter, internal (basic)	0.5024	12.76
Pitch (1/18 in)	0.0556	1.41

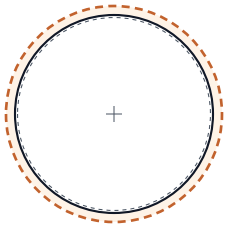
Actual size

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

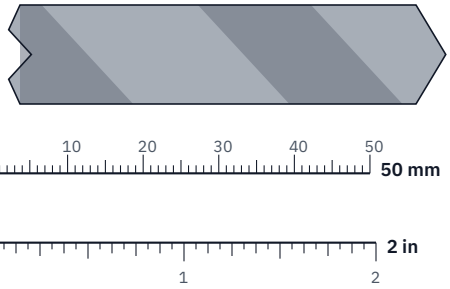


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 2x:



Tap drill, actual size (13.10 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/9-16-18/

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/