

Tap Drill Charts | **Unified National - J Series**

UNJC		Minor Ø		Recommended Drill Size	
Ø	Pitch (TPI)	Min	Max	Drill Size	Decimal (in)
#4	40	.0877	.0942	2.30mm	.0906
#5	40	.1007	.1072	2.60mm	.1024
#6	32	.1076	.1157	#33	.1130
#8	32	.1336	.1417	3.50mm	.1378
#10	24	.1494	.1600	3.90mm	.1535
#12	24	.1754	.1852	4.60mm	.1811
1/4	20	.2013	.2121	5.30mm	.2087
5/16	18	.2584	.2690	6.70mm	.2638
3/8	16	.3141	.3250	8.10mm	.3189
7/16	14	.3680	.3795	9.50mm	.3740
1/2	13	.4251	.4368	10.90mm	.4291
9/16	12	.4814	.4914	31/64"	.4844
5/8	11	.5365	.5474	13.80mm	.5433
3/4	10	.6526	.6646	16.75mm	.6594
7/8	9	.7668	.7801	19.60mm	.7717
1	8	.8783	.8933	22.50mm	.8858
	IJF	Min	or Ø	Recommend	ded Drill Size
UN Ø	IJF Pitch (TPI)				
Ø #4	Pitch (TPI) 48	Min Min .0917	or Ø Max .0971	Recommend Drill Size 2.40mm	ded Drill Size
Ø #4 #5	Pitch (TPI)	Min Min	or Ø Max	Recommend Drill Size	ded Drill Size Decimal (in)
Ø #4 #5 #6	Pitch (TPI) 48	Min Min .0917	or Ø Max .0971	Recommend Drill Size 2.40mm	ded Drill Size Decimal (in) .0945
Ø #4 #5	Pitch (TPI) 48 44 40 36	Min .0917 .1029	or Ø Max .0971 .1088	Recommend Drill Size 2.40mm 2.70mm	ded Drill Size Decimal (in) .0945 .1063
Ø #4 #5 #6	Pitch (TPI) 48 44 40 36 32	Min .0917 .1029 .1137	or Ø Max .0971 .1088 .1202	Recommend Drill Size 2.40mm 2.70mm 3.00mm	Decimal (in) .0945 .1063 .1181
Ø #4 #5 #6 #8	Pitch (TPI) 48 44 40 36 32 28	Min .0917 .1029 .1137 .1370	or Ø Max .0971 .1088 .1202 .1442	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405
#4 #5 #6 #8 #10	Pitch (TPI) 48 44 40 36 32	Min .0917 .1029 .1137 .1370 .1596	or Ø Max .0971 .1088 .1202 .1442 .1675	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654
#4 #5 #6 #8 #10 #12	Pitch (TPI) 48 44 40 36 32 28	Min .0917 .1029 .1137 .1370 .1596 .1812	or Ø Max .0971 .1088 .1202 .1442 .1675 .1896	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850
#4 #5 #6 #8 #10 #12 1/4	Pitch (TPI) 48 44 40 36 32 28 28	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152	or Ø Max .0971 .1088 .1202 .1442 .1675 .1896 .2229	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32"	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188
#4 #5 #6 #8 #10 #12 1/4 5/16	Pitch (TPI) 48 44 40 36 32 28 28 24	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152	or Ø Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756
#4 #5 #6 #8 #10 #12 1/4 5/16 3/8	Pitch (TPI) 48 44 40 36 32 28 28 24 24	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152 .2719 .3344	or Ø Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799 .3417	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm 8.60mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756 .3386
#4 #5 #6 #8 #10 #12 1/4 5/16 3/8 7/16	Pitch (TPI) 48 44 40 36 32 28 28 24 24 20	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152 .2719 .3344 .3888	Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799 .3417 .3970	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm 8.60mm 10.00mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756 .3386 .3937
#4 #5 #6 #8 #10 #12 1/4 5/16 3/8 7/16 1/2	Pitch (TPI) 48 44 40 36 32 28 28 24 24 20 20	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152 .2719 .3344 .3888 .4513	or Ø Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799 .3417 .3970 .4591	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm 8.60mm 10.00mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756 .3386 .3937 .4567
#4 #5 #6 #8 #10 #12 1/4 5/16 3/8 7/16 1/2 9/16	Pitch (TPI) 48 44 40 36 32 28 28 24 24 20 20 18	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152 .2719 .3344 .3888 .4513	Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799 .3417 .3970 .4591 .5166	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm 8.60mm 10.00mm 11.60mm 13.00mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756 .3386 .3937 .4567 .5118
#4 #5 #6 #8 #10 #12 1/4 5/16 3/8 7/16 1/2 9/16 5/8	Pitch (TPI) 48 44 40 36 32 28 28 24 24 20 20 18 18	Min .0917 .1029 .1137 .1370 .1596 .1812 .2152 .2719 .3344 .3888 .4513 .5084 .5709	Max .0971 .1088 .1202 .1442 .1675 .1896 .2229 .2799 .3417 .3970 .4591 .5166 .5788	Recommend Drill Size 2.40mm 2.70mm 3.00mm #28 4.20mm #13 7/32" 7.00mm 8.60mm 10.00mm 11.60mm 13.00mm 14.60mm	ded Drill Size Decimal (in) .0945 .1063 .1181 .1405 .1654 .1850 .2188 .2756 .3386 .3937 .4567 .5118 .5748