1-20 Tap Drill Chart

Unified National Extra Fine (UNEF) · 20 threads per inch · ASME B1.1

TAP DRILL (72% THREAD)

61/64" = 0.9531 in = 24.21 mm

Drills for 1-20 (50–85% thread)

DRILL	INCH	MM	% THREAD	
61/64"	0.9531	24.21	72%	Recommended

Clearance hole (bolt passes through)

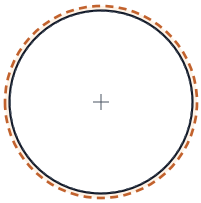
FIT	DRILL	INCH	MM
Close	1-3/64"	1.0469	26.59
Normal	1-7/64"	1.1094	28.18
Loose	1-3/16"	1.1875	30.16

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.0000	25.40
Pitch diameter (basic)	0.9675	24.58
Minor diameter, internal (basic)	0.9459	24.03
Pitch (1/20 in)	0.0500	1.27

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 (24.21 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/1-20/

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/