13/16-20 Tap Drill Chart

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

TAP DRILL (72% THREAD)

49/64" = 0.7656 in = 19.45 mm

Drills for 13/16-20 (50–85% thread)

DRILL	INCH	MM	% THREAD	
49/64"	**0.7656**	**19.45**	**72%**	Recommended

Clearance hole (bolt passes through)

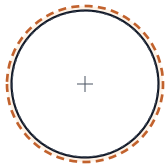
FIT	DRILL	INCH	MM
Close	55/64"	**0.8594**	**21.83**
Normal	29/32"	**0.9063**	**23.02**
Loose	63/64"	**0.9844**	**25.00**

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	**0.8125**	**20.64**
Pitch diameter (basic)	**0.7800**	**19.81**
Minor diameter, internal (basic)	**0.7584**	**19.26**
Pitch (1/20 in)	**0.0500**	**1.27**

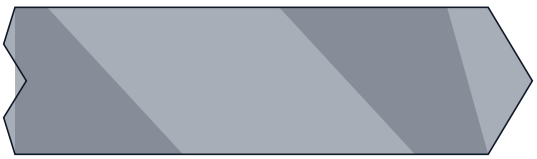
Actual size

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 (19.45 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/13-16-20/

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/