# 15/16-20 Tap Drill Chart

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

TAP DRILL (72% THREAD)

**57/64"** = 0.8906 in = 22.62 mm

## Drills for 15/16-20 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| **57/64"** | **0.8906** | **22.62** | **72%** | Recommended |

## Clearance hole (bolt passes through)

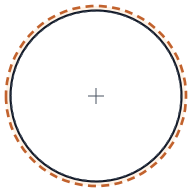
| FIT | DRILL | INCH | MM |
|---|---|---|---|
| **Close** | 63/64" | **0.9844** | **25.00** |
| **Normal** | 1-1/32" | **1.0313** | **26.19** |
| **Loose** | 1-7/64" | **1.1094** | **28.18** |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| **Major diameter (basic)** | **0.9375** | **23.81** |
| **Pitch diameter (basic)** | **0.9050** | **22.99** |
| **Minor diameter, internal (basic)** | **0.8834** | **22.44** |
| **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 (22.62 mm):**









Scan for the interactive version:

**whatsizeis.com/tap-drill/15-16-20/**

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/