3/4-20 Tap Drill Chart

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

TAP DRILL (72% THREAD)

45/64" = 0.7031 in = 17.86 mm

Drills for 3/4-20 (50–85% thread)

DRILL	INCH	MM	% THREAD	
45/64"	0.7031	17.86	72%	Recommended

Clearance hole (bolt passes through)

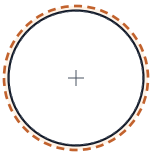
FIT	DRILL	INCH	MM
Close	51/64"	0.7969	20.24
Normal	27/32"	0.8438	21.43
Loose	57/64"	0.8906	22.62

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.7500	19.05
Pitch diameter (basic)	0.7175	18.23
Minor diameter, internal (basic)	0.6959	17.68
Pitch (1/20 in)	0.0500	1.27

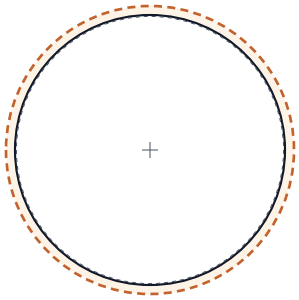
Actual size

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

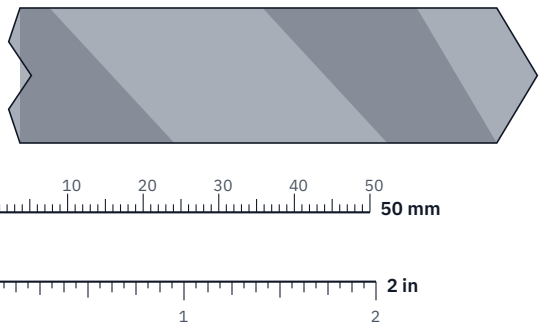


Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 2x:



Tap drill, actual size (17.86 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/3-4-20/

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/