M20x1 Tap Drill Chart

Metric fine (ISO) · 1 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

19 mm = 0.7480 in = 19.00 mm

Drills for M20x1 (50–85% thread)

DRILL	INCH	MM	% THREAD	
19 mm	0.7480	19.00	77%	Recommended

Clearance hole (bolt passes through)

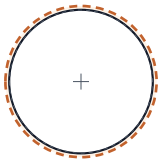
FIT	DRILL	INCH	MM
Close	21 mm	0.8268	21.00
Normal	22 mm	0.8661	22.00
Loose	24 mm	0.9449	24.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.7874	20.00
Pitch diameter (basic)	0.7618	19.35
Minor diameter, internal (basic)	0.7448	18.92
Pitch	0.0394	1.00

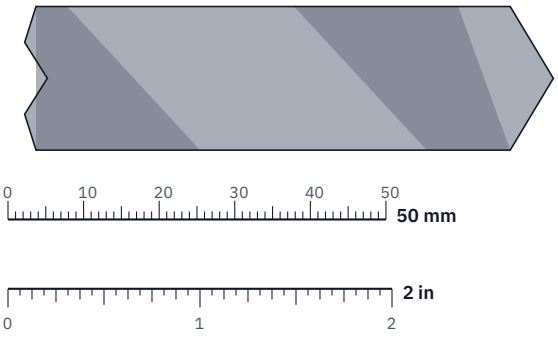
Actual size

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 (19.00 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m20x1/

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/