M20x2 Tap Drill Chart

Metric fine (ISO) · 2 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

18 mm = 0.7087 in = 18.00 mm

Drills for M20x2 (50–85% thread)

DRILL	INCH	MM	% THREAD	
18.5 mm	0.7283	18.50	58%	
18 mm	0.7087	18.00	77%	Recommended

Clearance hole (bolt passes through)

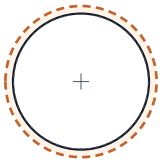
FIT	DRILL	INCH	MM
Close	21 mm	0.8268	21.00
Normal	22 mm	0.8661	22.00
Loose	24 mm	0.9449	24.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.7874	20.00
Pitch diameter (basic)	0.7363	18.70
Minor diameter, internal (basic)	0.7022	17.83
Pitch	0.0787	2.00

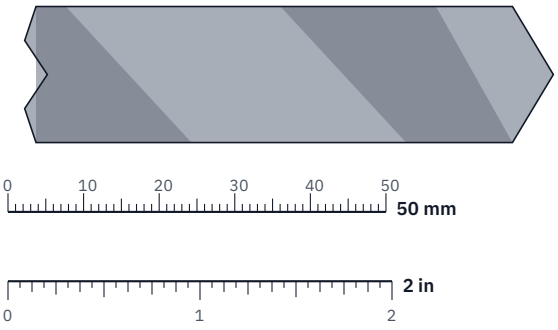
Actual size

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 (18.00 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m20x2/

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/