MAX MACHINING

Metric Tap Drill Chart

M1.6 to M24, coarse and fine pitch. Tap drill at about 75 percent thread, clearance drills, nearest inch drill.

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THREAD	PITCH mm	MAJOR mm	TAP DRILL 75% thread	NEAREST INCH DRILL	CLOSE FIT clearance	MEDIUM FIT clearance
M1.6 × 0.35	0.35	1.6	**1.25 mm** 0.0492 in	3/64 .0469 1.19 mm	1.7 mm	1.8 mm
M2 × 0.4	0.40	2.0	**1.60 mm** 0.0630 in	1/16 .0625 1.59 mm	2.2 mm	2.4 mm
M2.5 × 0.45	0.45	2.5	**2.05 mm** 0.0807 in	#46 .0810 2.06 mm	2.7 mm	2.9 mm
M3 × 0.5	0.50	3.0	**2.50 mm** 0.0984 in	#40 .0980 2.49 mm	3.2 mm	3.4 mm
M3.5 × 0.6	0.60	3.5	**2.90 mm** 0.1142 in	#33 .1130 2.87 mm	3.7 mm	3.9 mm
M4 × 0.7	0.70	4.0	**3.30 mm** 0.1299 in	#30 .1285 3.26 mm	4.3 mm	4.5 mm
M5 × 0.8	0.80	5.0	**4.20 mm** 0.1654 in	#19 .1660 4.22 mm	5.3 mm	5.5 mm
M6 × 1.0	1.00	6.0	**5.00 mm** 0.1969 in	#9 .1960 4.98 mm	6.4 mm	6.6 mm
M8 × 1.25	1.25	8.0	**6.80 mm** 0.2677 in	H .2660 6.76 mm	8.4 mm	9.0 mm
M8 × 1.0 fine	1.00	8.0	**7.00 mm** 0.2756 in	J .2770 7.04 mm	8.4 mm	9.0 mm
M10 × 1.5	1.50	10.0	**8.50 mm** 0.3346 in	Q .3320 8.43 mm	10.5 mm	11.0 mm
M10 × 1.25 fine	1.25	10.0	**8.80 mm** 0.3465 in	S .3480 8.84 mm	10.5 mm	11.0 mm
M10 × 1.0 fine	1.00	10.0	**9.00 mm** 0.3543 in	T .3580 9.09 mm	10.5 mm	11.0 mm
M12 × 1.75	1.75	12.0	**10.20 mm** 0.4016 in	Y .4040 10.26 mm	13.0 mm	13.5 mm
M12 × 1.5 fine	1.50	12.0	**10.50 mm** 0.4134 in	Z .4130 10.49 mm	13.0 mm	13.5 mm
M12 × 1.25 fine	1.25	12.0	**10.80 mm** 0.4252 in	27/64 .4219 10.72 mm	13.0 mm	13.5 mm
M14 × 2.0	2.00	14.0	**12.00 mm** 0.4724 in	15/32 .4688 11.91 mm	15.0 mm	15.5 mm
M14 × 1.5 fine	1.50	14.0	**12.50 mm** 0.4921 in	31/64 .4844 12.30 mm	15.0 mm	15.5 mm
M16 × 2.0	2.00	16.0	**14.00 mm** 0.5512 in	35/64 .5469 13.89 mm	17.0 mm	17.5 mm
M16 × 1.5 fine	1.50	16.0	**14.50 mm** 0.5709 in	37/64 .5781 14.68 mm	17.0 mm	17.5 mm
M18 × 2.5	2.50	18.0	**15.50 mm** 0.6102 in	39/64 .6094 15.48 mm	19.0 mm	20.0 mm
M20 × 2.5	2.50	20.0	**17.50 mm** 0.6890 in	11/16 .6875 17.46 mm	21.0 mm	22.0 mm
M20 × 1.5 fine	1.50	20.0	**18.50 mm** 0.7283 in	47/64 .7344 18.65 mm	21.0 mm	22.0 mm
M24 × 3.0	3.00	24.0	**21.00 mm** 0.8268 in	53/64 .8281 21.03 mm	25.0 mm	26.0 mm

HOW TO READ IT

Coarse pitch is the default; fine pitches are marked. The **nearest inch drill** column is for when the metric drill is not in the cabinet; check the thread percentage before committing. Formula: `drill = major - pitch x percent / 76.98`