Metric thread chart: tap drills and clearance holes

The tap drill for cutting taps is ≈ D − P (nominal diameter minus pitch). Forming taps need a larger drill – see the tap maker's data. Clearance holes follow ISO 273 (fine, medium and coarse series).

Coarse pitch metric threads (ISO 261)

THREAD	PITCH P, MM	TAP DRILL, MM	CLEARANCE FINE	MEDIUM	COARSE
M1.6	0,35	1,25	–	–	–
M2	0,40	1,60	–	–	–
M2.5	0,45	2,05	–	–	–
M3	0,50	2,50	3,2	3,4	3,6
M4	0,70	3,30	4,3	4,5	4,8
M5	0,80	4,20	5,3	5,5	5,8
M6	1	5	6,4	6,6	7
M8	1,25	6,80	8,4	9	10
M10	1,50	8,50	10,5	11	12
M12	1,75	10,20	13	13,5	14,5
M14	2	12	15	15,5	16,5
M16	2	14	17	17,5	18,5
M18	2,50	15,50	19	20	21
M20	2,50	17,50	21	22	24
M22	2,50	19,50	23	24	26
M24	3	21	25	26	28
M27	3	24	28	30	32
M30	3,50	26,50	31	33	35

Fine pitch threads

THREAD	TAP DRILL, MM
M8×1	7
M10×1	9
M10×1.25	8,80
M12×1.25	10,80
M12×1.5	10,50
M14×1.5	12,50
M16×1.5	14,50
M18×1.5	16,50
M20×1.5	18,50
M22×1.5	20,50

THREAD	TAP DRILL, MM
M24×2	22
M30×2	28

© CNC Pasaulis · cncpasaulis.lt/en/charts/metric-thread-tap-drill-chart/