

METRIC TAP DRILL SIZES & DECIMAL EQUIVALENTS

Drill (mm)	Decimal equivalent	Tap	Drill (mm)	Decimal equivalent	Tap	Drill (mm)	Decimal equivalent	Tap
1.25	0.0492	M1.6 x 0.35	8.50	0.3346	M10 x 1.5	20.50	0.8071	M22 x 1.5
1.45	0.0571	M1.8 x 0.35	8.70	0.3425	M10 x 1.25	21.00	0.8268	M24 x 3.0
1.60	0.0630	M2 x 0.4	10.20	0.4016	M12 x 1.75	22.00	0.8661	M24 x 2.0
1.75	0.0689	M2.2 x 0.45	10.80	0.4252	M12 x 1.25	24.00	0.9449	M27 x 3.0
2.05	0.0807	M2.5 x 0.45	12.00	0.4724	M14 x 2.0	25.00	0.9843	M27 x 2.0
2.50	0.0984	M3 x 0.5	12.50	0.4921	M14 x 1.5	26.50	1.0433	M30 x 3.5
2.90	0.1142	M3.5 x 0.6	14.00	0.5512	M16 x 2.0	28.00	1.1024	M30 x 2.0
3.30	0.1299	M4 x 0.7	14.50	0.5709	M16 x 1.5	29.50	1.1614	M33 x 3.5
3.70	0.1457	M4.5 x 0.75	15.50	0.6102	M18 x 2.5	31.00	1.2205	M33 x 2.0
4.20	0.1654	M5 x 0.8	16.50	0.6496	M18 x 1.5	32.00	1.2598	M36 x 4.0
5.00	0.1969	M6 x 1.0	17.50	0.6890	M20 x 2.5	33.00	1.2992	M36 x 3.0
6.00	0.2362	M7 x 1.0	18.50	0.7283	M20 x 1.5	35.00	1.3780	M39 x 4.0
6.75	0.2657	M8 x 1.25	19.50	0.7677	M22 x 2.5	36.00	1.4173	M39 x 3.0
7.00	0.2756	M8 x 1.0						

FIND ANY METRIC TAP DRILL SIZE:

ISO METRIC tap drill size = major dia. ***less*** thread pitch

Example: M18 , 1.5 (18.0 - 1.5) = M16.5 tap drill for 75% thread.

FOR ANY SIZE THREAD AT ANY PERCENTAGE OF DEPTH:

Percentages other than 75%, change the (.75) in the equation below.

Major Dia. less (1.082 x pitch (in metric) x .75) = tap drill

ISO METRIC TAP DRILL SIZES FOR FORMING TAPS:

(based on the recommended 65% thread)

Hole size = basic tap O.D. ***less*** (.75 x pitch (in metric) x .65)