



# Tap & Drill Chart

| METRIC<br>Tap & Clearance Drill<br>Sizes |                      | Tap Drill                                       |                              |  |                              | Clearance Drill    |                           |                    |                              |
|--|----------------------|---|------------------------------|--|------------------------------|--------------------|---------------------------|--------------------|------------------------------|
|  |                      | 75% Thread for<br>Aluminum, Brass<br>& Plastics |                              | 50% Thread for<br>Steel, Stainless<br>& Iron |                              | Close Fit          |                           | Free Fit           |                              |
| Screw Size<br>(mm)                       | Thread Pitch<br>(mm) | Drill Size<br>(mm)                              | Closest<br>American<br>Drill | Drill Size<br>(mm)                           | Closest<br>American<br>Drill | Drill Size<br>(mm) | Closest<br>American Drill | Drill Size<br>(mm) | Closest<br>American<br>Drill |
| M1.5                                     | 0.35                 | 1.15  | 56                           | 1.25   | 55                           | 1.60               | 1/16                      | 1.65               | 52                           |
| M1.6                                     | 0.35                 | 1.25  | 55                           | 1.35   | 54                           | 1.70               | 51                        | 1.75               | 50                           |
| M1.8                                     | 0.35                 | 1.45  | 53                           | 1.55   | 1/16                         | 1.90               | 49                        | 2.00               | 5/64                         |
| M2                                       | 0.45                 | 1.55  | 1/16                         | 1.70   | 51                           | 2.10               | 45                        | 2.20               | 44                           |
|  | 0.40                 | 1.60  | 52                           | 1.75   | 50                           |                    |                           |                    |                              |
| M2.2                                     | 0.45                 | 1.75  | 50                           | 1.90   | 48                           | 2.30               | 3/32                      | 2.40               | 41                           |
| M2.5                                     | 0.45                 | 2.05  | 46                           | 2.20   | 44                           | 2.65               | 37                        | 2.75               | 7/64                         |
| M3                                       | 0.60                 | 2.40  | 41                           | 2.60   | 37                           | 3.15               | 1/8                       | 3.30               | 30                           |
|  | 0.50                 | 2.50  | 39                           | 2.70   | 36                           |                    |                           |                    |                              |
| M3.5                                     | 0.60                 | 2.90  | 32                           | 3.10   | 31                           | 3.70               | 27                        | 3.85               | 24                           |
| M4                                       | 0.75                 | 3.25  | 30                           | 3.50   | 28                           | 4.20               | 19                        | 4.40               | 17                           |
|  | 0.70                 | 3.30  | 30                           | 3.50   | 28                           |                    |                           |                    |                              |
| M4.5                                     | 0.75                 | 3.75  | 25                           | 4.00   | 22                           | 4.75               | 13                        | 5.00               | 9                            |
| M5                                       | 1.00                 | 4.00  | 21                           | 4.40   | 11/64                        | 5.25               | 5                         | 5.50               | 0.22                         |
|  | 0.90                 | 4.10  | 20                           | 4.40   | 17                           |                    |                           |                    |                              |
|  | 0.80                 | 4.20  | 19                           | 4.50   | 16                           |                    |                           |                    |                              |
| M5.5                                     | 0.90                 | 4.60  | 14                           | 4.90   | 10                           | 5.80               | 1                         | 6.10               | B                            |
| M6                                       | 1.00                 | 5.00  | 8                            | 5.40   | 4                            | 6.30               | E                         | 6.60               | G                            |
|  | 0.75                 | 5.25  | 4                            | 5.50   | 7/32                         |                    |                           |                    |                              |
| M7                                       | 1.00                 | 6.00  | B                            | 6.40   | E                            | 7.40               | L                         | 7.70               | N                            |
|  | 0.75                 | 6.25  | D                            | 6.50   | F                            |                    |                           |                    |                              |
| M8                                       | 1.25                 | 6.80  | H                            | 7.20   | J                            | 8.40               | Q                         | 8.80               | S                            |
|  | 1.00                 | 7.00  | J                            | 7.40   | L                            |                    |                           |                    |                              |
| M9                                       | 1.25                 | 7.80  | N                            | 8.20   | P                            | 9.50               | 3/8                       | 9.90               | 25/64                        |
|  | 1.00                 | 8.00  | O                            | 8.40   | 21/64                        |                    |                           |                    |                              |
| M10                                      | 1.50                 | 8.50  | R                            | 9.00   | T                            | 10.50              | Z                         | 11.00              | 0.4375                       |
|  | 1.25                 | 8.80  | 11/32                        | 9.20   | 23/64                        |                    |                           |                    |                              |
|  | 1.00                 | 9.00  | T                            | 9.40   | U                            |                    |                           |                    |                              |
| M11                                      | 1.50                 | 9.50  | 3/8                          | 10.00  | X                            | 11.60              | 29/64                     | 12.10              | 15/32                        |
| M12                                      | 1.75                 | 10.30   | 13/32                        | 10.90  | 27/64                        | 12.60              | 1/2                       | 13.20              | 33/64                        |
|  | 1.50                 | 10.50   | Z                            | 11.00  | 7/16                         |                    |                           |                    |                              |
|  | 1.25                 | 10.80   | 27/64                        | 11.20  | 7/16                         |                    |                           |                    |                              |
| M14                                      | 2.00                 | 12.10   | 15/32                        | 12.70  | 1/2                          | 14.75              | 37/64                     | 15.50              | 39/64                        |
|  | 1.50                 | 12.50   | 1/2                          | 13.00  | 33/64                        |                    |                           |                    |                              |
|  | 1.25                 | 12.80   | 1/2                          | 13.20  | 33/64                        |                    |                           |                    |                              |
| M15                                      | 1.50                 | 13.50   | 17/32                        | 14.00  | 35/64                        | 15.75              | 5/8                       | 16.50              | 21/32                        |
| M16                                      | 2.00                 | 14.00   | 35/64                        | 14.75  | 37/64                        | 16.75              | 21/32                     | 17.50              | 0.6875                       |
|  | 1.50                 | 14.50   | 37/64                        | 15.00  | 19/32                        |                    |                           |                    |                              |
| M17                                      | 1.50                 | 15.50   | 39/64                        | 16.00  | 5/8                          | 18.00              | 45/64                     | 18.50              | 47/64                        |
|  | 2.50                 | 15.50   | 39/64                        | 16.50  | 41/64                        |                    |                           |                    |                              |
| M18                                      | 2.00                 | 16.00   | 5/8                          | 16.75  | 21/32                        | 19.00              | 3/4                       | 20.00              | 25/32                        |
|  | 1.50                 | 16.50   | 21/32                        | 17.00  | 43/64                        |                    |                           |                    |                              |
| M19                                      | 2.50                 | 16.50   | 21/32                        | 17.50  | 11/16                        | 20.00              | 25/32                     | 21.00              | 53/64                        |
|  | 2.50                 | 17.50   | 11/16                        | 18.50  | 23/32                        |                    |                           |                    |                              |
| M20                                      | 2.00                 | 18.00   | 45/64                        | 18.50  | 47/64                        | 21.00              | 53/64                     | 22.00              | 55/64                        |
|  | 1.50                 | 18.50   | 47/64                        | 19.00  | 3/4                          |                    |                           |                    |                              |