Metric Tap Drill Chart

Metric coarse tap drill chart, M1 to M30

Drill sizes for 50%, 60%, 75% and 80% thread, with the published tap drill and the thread it gives.

Thread	Pitch (mm)	Major (mm)	Drill for 50% (mm)	Drill for 60% (mm)	Drill for 75% (mm)	Drill for 80% (mm)	Published tap drill (mm)	Thread at that drill
M1	0.25	1	0.84	0.81	0.76	0.74	0.75	77%
M1.1	0.25	1.1	0.94	0.91	0.86	0.84	0.85	77%
M1.2	0.25	1.2	1.04	1.01	0.96	0.94	0.95	77%
M1.4	0.3	1.4	1.21	1.17	1.11	1.09	1.1	77%
M1.6	0.35	1.6	1.37	1.33	1.26	1.24	1.25	77%
M1.8	0.35	1.8	1.57	1.53	1.46	1.44	1.45	77%
M2	0.4	2	1.74	1.69	1.61	1.58	1.6	77%
M2.2	0.45	2.2	1.91	1.85	1.76	1.73	1.75	77%
M2.5	0.45	2.5	2.21	2.15	2.06	2.03	2.05	77%
M3	0.5	3	2.68	2.61	2.51	2.48	2.5	77%
M3.5	0.6	3.5	3.11	3.03	2.92	2.88	2.9	77%
M4	0.7	4	3.55	3.45	3.32	3.27	3.3	77%
M4.5	0.75	4.5	4.01	3.92	3.77	3.72	3.7	82%
M5	0.8	5	4.48	4.38	4.22	4.17	4.2	77%
M6	1	6	5.35	5.22	5.03	4.96	5	77%
M7	1	7	6.35	6.22	6.03	5.96	6	77%
M8	1.25	8	7.19	7.03	6.78	6.70	6.8	74%
M9	1.25	9	8.19	8.03	7.78	7.70	7.8	74%
M10	1.5	10	9.03	8.83	8.54	8.44	8.5	77%
M11	1.5	11	10.03	9.83	9.54	9.44	9.5	77%
M12	1.75	12	10.86	10.64	10.30	10.18	10.2	79%
M14	2	14	12.70	12.44	12.05	11.92	12	77%
M16	2	16	14.70	14.44	14.05	13.92	14	77%
M18	2.5	18	16.38	16.05	15.56	15.40	15.5	77%
M20	2.5	20	18.38	18.05	17.56	17.40	17.5	77%
M22	2.5	22	20.38	20.05	19.56	19.40	19.5	77%
M24	3	24	22.05	21.66	21.08	20.88	21	77%
M27	3	27	25.05	24.66	24.08	23.88	24	77%
M30	3.5	30	27.73	27.27	26.59	26.36	26.5	77%

Metric fine tap drill chart

Fine pitches listed by at least two sources.

Thread	Pitch (mm)	Major (mm)	Drill for 50% (mm)	Drill for 60% (mm)	Drill for 75% (mm)	Drill for 80% (mm)	Published tap drill (mm)	Thread at that drill
M4×0.5	0.5	4	3.68	3.61	3.51	3.48	3.5	77%
M5×0.5	0.5	5	4.68	4.61	4.51	4.48	4.5	77%
M6×0.75	0.75	6	5.51	5.42	5.27	5.22	5.25	77%
M8×1	1	8	7.35	7.22	7.03	6.96	7	77%
M8×0.75	0.75	8	7.51	7.42	7.27	7.22	7.25	77%
M10×1.25	1.25	10	9.19	9.03	8.78	8.70	8.8	74%
M10×1	1	10	9.35	9.22	9.03	8.96	9	77%
M10×0.75	0.75	10	9.51	9.42	9.27	9.22	9.25	77%
M12×1.5	1.5	12	11.03	10.83	10.54	10.44	10.5	77%
M12×1.25	1.25	12	11.19	11.03	10.78	10.70	10.8	74%
M12×1	1	12	11.35	11.22	11.03	10.96	11	77%

Thread	Pitch (mm)	Major (mm)	Drill for 50% (mm)	Drill for 60% (mm)	Drill for 75% (mm)	Drill for 80% (mm)	Published tap drill (mm)	Thread at that drill
M14×1.5	1.5	14	13.03	12.83	12.54	12.44	12.5	77%
M14×1.25	1.25	14	13.19	13.03	12.78	12.70	12.8	74%
M16×1.5	1.5	16	15.03	14.83	14.54	14.44	14.5	77%
M18×1.5	1.5	18	17.03	16.83	16.54	16.44	16.5	77%
M20×2	2	20	18.70	18.44	18.05	17.92	18	77%
M20×1.5	1.5	20	19.03	18.83	18.54	18.44	18.5	77%
M22×1.5	1.5	22	21.03	20.83	20.54	20.44	20.5	77%
M24×2	2	24	22.70	22.44	22.05	21.92	22	77%
M24×1.5	1.5	24	23.03	22.83	22.54	22.44	22.5	77%
M27×2	2	27	25.70	25.44	25.05	24.92	25	77%
M30×2	2	30	28.70	28.44	28.05	27.92	28	77%

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