

Tapping Drill Sizes

Metric Tap & Clearance Drill Sizes		Tap Drill				Clearance Drill			
		75% Thread for Aluminum, Brass, & Plastics		50% Thread for Steel, Stainless, & Iron		Close Fit		Standard Fit	
Screw Size (mm)	Thread Pitch (mm)	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American Drill	Drill Size (mm)	Closest American 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
M 1.8	0.35	1.45	53	1.55	1/16	1.90	49	2.00	5/64
M 2	0.45	1.55	1/16	1.70	51	2.10	45	2.20	44
	0.40	1.60	52	1.75	50				
M 2.2	0.45	1.75	50	1.90	48	2.30	3/32	2.40	41
M 2.5	0.45	2.05	46	2.20	44	2.65	37	2.75	7/64
M 3	0.60	2.40	41	2.60	37	3.15	1/8	3.30	30
	0.50	2.50	39	2.70	36				
M 3.5	0.60	2.90	32	3.10	31	3.70	27	3.85	24
M 4	0.75	3.25	30	3.50	28	4.20	19	4.40	17
	0.70	3.30	30	3.50	28				
M 4.5	0.75	3.75	25	4.00	22	4.75	13	5.00	9
M 5	1.00	4.00	21	4.40	11/64	5.25	5	5.50	7/32
	0.90	4.10	20	4.40	17				
	0.80	4.20	19	4.50	16				
M 5.5	0.90	4.60	14	4.90	10	5.80	1	6.10	B
M 6	1.00	5.00	8	5.40	4	6.30	E	6.60	G
	0.75	5.25	4	5.50	7/32				
M 7	1.00	6.00	B	6.40	E	7.40	L	7.70	N
	0.75	6.25	D	6.50	F				
M 8	1.25	6.80	H	7.20	J	8.40	Q	8.80	S
	1.00	7.00	J	7.40	L				
M 9	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				
M 10	1.50	8.50	R	9.00	T	10.50	Z	11.00	7/16
	1.25	8.80	11/32	9.20	23/64				
	1.00	9.00	T	9.40	U				
M 11	1.50	9.50	3/8	10.00	X	11.60	29/64	12.10	15/32
M 12	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				
M 14	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				
M 15	1.50	13.50	17/32	14.00	35/64	15.75	5/8	16.50	21/32
M 16	2.00	14.00	35/64	14.75	37/64	16.75	21/32	17.50	11/16
	1.50	14.50	37/64	15.00	19/32				
M 17	1.50	15.50	39/64	16.00	5/8	18.00	45/64	18.50	47/64
M 18	2.50	15.50	39/64	16.50	41/64	19.00	3/4	20.00	25/32
	2.00	16.00	5/8	16.75	21/32				
	1.50	16.50	21/32	17.00	43/64				
M 19	2.50	16.50	21/32	17.50	11/16	20.00	25/32	21.00	53/64
M 20	2.50	17.50	11/16	18.50	23/32	21.00	53/64	22.00	55/64
	2.00	18.00	45/64	18.50	47/64				
	1.50	18.50	47/64	19.00	3/4				