

Metric Tap Drill Sizes

Tap size	Major Dia (mm)	Threads per	Tap Drill (mm)	Tap Drill (inch)	Clearance (mm)	Clearance (inch)
M1.6 x 0.35	1.6	0.35	1.25	#55	1.8	#49
M2 x 0.4	2	0.4	1.6	#52	2.4	#41
M2.5 x 0.45	2.5	0.45	2.05	#46	2.9	#32
M3 x .05	3	0.5	2.5	#39	3.4	#29
M3.5 x 0.6	3.5	0.6	2.9	#32	3.9	#23
M4 x 0.7	4	0.7	3.3	#30	4.5	#16
M5 x 0.8	5	0.8	4.2	#19	5.5	7/32
M6 x 1	6	1	5	#8	6.6	G
M8 x 1.25	8	1.25	6.8	H	9	T
M8 x 1	8	1	7	J	9	T
M10 x 1.5	10	1.5	8.5	R	12	31/64
M10 x 1.25	10	1.25	8.8	11/32	12	31/64
M12 x 1.75	12	1.75	10.2	13/32	14	35/64
M12 x 1.25	12	1.25	10.8	27/64	14	35/64
M14 x 2	14	2	12	15/32	16	5/8
M14 x 1.5	14	1.5	12.5	1/2	16	5/8
M16 x 2	16	2	14	35/64	18	45/64
M16 x 1.5	16	1.5	14.5	37/64	18	45/64
M18 x 2.5	18	2.5	15.5	39/64	20	51/64
M18 x 1.5	18	1.5	16.5	21/32	20	51/64
M20 x 2.5	20	2.5	17.5	11/16	22	7/8
M20 x 1.5	20	1.5	18.5	47/64	22	7/8
M22 x 2.5	22	2.5	19.5	49/64	25	1
M22 x 1.5	22	1.5	20.5	13/16	25	1
M24 x 3	24	3	21	53/64	27	1-5/64
M24 x 2	24	2	22	7/8	27	1-5/64
M27 x 3	27	3	24	15/16	30	1-3/16
M27 x 2	27	2	25	1	30	1-3/16