

DRILL DIAMETERS FOR TAPPING

● Metric Coarse Screw Thread

Nominal	Drill Diameter	
	HSS	Carbide
M1 ×0.25	0.75	0.75
M1.1×0.25	0.85	0.85
M1.2×0.25	0.95	0.95
M1.4×0.3	1.10	1.10
M1.6×0.35	1.25	1.30
M1.7×0.35	1.35	1.40
M1.8×0.35	1.45	1.50
M2 ×0.4	1.60	1.65
M2.2×0.45	1.75	1.80
M2.3×0.4	1.90	1.95
M2.5×0.45	2.10	2.15
M2.6×0.45	2.15	2.20
M3 ×0.5	2.50	2.55
M3.5×0.6	2.90	2.95
M4 ×0.7	3.3	3.4
M4.5×0.75	3.8	3.9
M5 ×0.8	4.2	4.3
M6 ×1.0	5.0	5.1
M7 ×1.0	6.0	6.1
M8 ×1.25	6.8	6.9
M9 ×1.25	7.8	7.9
M10×1.5	8.5	8.7
M11×1.5	9.5	9.7
M12×1.75	10.3	10.5
M14×2.0	12.0	12.2
M16×2.0	14.0	14.2
M18×2.5	15.5	15.7
M20×2.5	17.5	17.7
M22×2.5	19.5	19.7
M24×3.0	21.0	—
M27×3.0	24.0	—
M30×3.5	26.5	—
M33×3.5	29.5	—
M36×4.0	32.0	—
M39×4.0	35.0	—
M42×4.5	37.5	—
M45×4.5	40.5	—
M48×5.0	43.0	—

● Metric Fine Screw Thread

Nominal	Drill Diameter		Nominal	Drill Diameter		Nominal	Drill Diameter	
	HSS	Carbide		HSS	Carbide		HSS	Carbide
M1 ×0.2	0.80	0.80	M20 ×2.0	18.0	18.3	M42 ×3.0	39.0	—
M1.1×0.2	0.90	0.90	M20 ×1.5	18.5	18.7	M42 ×2.0	40.0	—
M1.2×0.2	1.00	1.00	M20 ×1.0	19.0	19.1	M42 ×1.5	40.5	—
M1.4×0.2	1.20	1.20	M22 ×2.0	20.0	—	M45 ×4.0	41.0	—
M1.6×0.2	1.40	1.40	M22 ×1.5	20.5	—	M45 ×3.0	42.0	—
M1.8×0.2	1.60	1.60	M22 ×1.0	21.0	—	M45 ×2.0	43.0	—
M2 ×0.25	1.75	1.75	M24 ×2.0	22.0	—	M45 ×1.5	43.5	—
M2.2×0.25	1.95	2.00	M24 ×1.5	22.5	—	M48 ×4.0	44.0	—
M2.5×0.35	2.20	2.20	M24 ×1.0	23.0	—	M48 ×3.0	45.0	—
M3 ×0.35	2.70	2.70	M25 ×2.0	23.0	—	M48 ×2.0	46.0	—
M3.5×0.35	3.20	3.20	M25 ×1.5	23.5	—	M48 ×1.5	46.5	—
M4 ×0.5	3.50	3.55	M25 ×1.0	24.0	—	M50 ×3.0	47.0	—
M4.5×0.5	4.00	4.05	M26 ×1.5	24.5	—	M50 ×2.0	48.0	—
M5 ×0.5	4.50	4.55	M27 ×2.0	25.0	—	M50 ×1.5	48.5	—
M5.5×0.5	5.00	5.05	M27 ×1.5	25.5	—			
M6 ×0.75	5.30	5.35	M27 ×1.0	26.0	—			
M7 ×0.75	6.30	6.35	M28 ×2.0	26.0	—			
M8 ×1.0	7.00	7.10	M28 ×1.5	26.5	—			
M8 ×0.75	7.30	7.35	M28 ×1.0	27.0	—			
M9 ×1.0	8.00	8.10	M30 ×3.0	27.0	—			
M9 ×0.75	8.30	8.35	M30 ×2.0	28.0	—			
M10×1.25	8.80	8.90	M30 ×1.5	28.5	—			
M10×1.0	9.00	9.10	M30 ×1.0	29.0	—			
M10×0.75	9.30	9.35	M32 ×2.0	30.0	—			
M11×1.0	10.0	10.1	M32 ×1.5	30.5	—			
M11×0.75	10.3	10.3	M33 ×3.0	30.0	—			
M12×1.5	10.5	10.7	M33 ×2.0	31.0	—			
M12×1.25	10.8	10.9	M33 ×1.5	31.5	—			
M12×1.0	11.0	11.1	M35 ×1.5	33.5	—			
M14×1.5	12.5	12.7	M36 ×3.0	33.0	—			
M14×1.0	13.0	13.1	M36 ×2.0	34.0	—			
M15×1.5	13.5	13.7	M36 ×1.5	34.5	—			
M15×1.0	14.0	14.1	M38 ×1.5	36.5	—			
M16×1.5	14.5	14.7	M39 ×3.0	36.0	—			
M16×1.0	15.0	15.1	M39 ×2.0	37.0	—			
M17×1.5	15.5	15.7	M39 ×1.5	37.5	—			
M17×1.0	16.0	16.1	M40 ×3.0	37.0	—			
M18×2.0	16.0	16.3	M40 ×2.0	38.0	—			
M18×1.5	16.5	16.7	M40 ×1.5	38.5	—			
M18×1.0	17.0	17.1	M42 ×4.0	38.0	—			

(Note) Hole sizes should be measured since the accuracy of a drilled hole may change due to the drilling conditions, and if found to be inappropriate for a tapping hole, the drill diameter must be corrected accordingly.