

Tapping and Clearance Drills for **METRIC** Machine Screws

Screw Size			Tapping Drills		Clearance Drills			
Nominal Diam. (mm)	Pitch (mm)	Series	Drill Size		Close Fit		Free Fit	
			(65-75% thread)	Dec. Equiv.	Drill Size	Dec. Equiv.	Drill Size	Dec. Equiv.
1	0.20	Fine	0.80	0.0315	1.05	0.0413	1.20	0.0472
	0.25	Coarse	0.75	0.0295				
1.1	0.20	Fine	0.90	0.0354	1.15	0.0453	1.30	0.0512
	0.25	Coarse	0.85	0.0335				
1.2	0.20	Fine	1.00	0.0394	1.30	0.0512	1.50	0.0590
	0.25	Coarse	0.95	0.0374				
1.4	0.20	Fine	1.20	0.0472	1.50	0.0591	1.70	0.0669
	0.30	Coarse	1.10	0.0433				
1.6	0.20	Fine	1.40	0.0551	1.70	0.0669	2.00	0.0787
	0.35	Coarse	1.25	0.0492				
1.8	0.20	Fine	1.60	0.0630	1.90	0.0748	2.20	0.0866
	0.35	Coarse	1.45	0.0571				
2	0.25	Fine	1.75	0.0689	2.20	0.0866	2.60	0.1024
	0.40	Coarse	1.60	0.0630				
2.2	0.25	Fine	1.95	0.0768	2.40	0.0945	2.80	0.1102
	0.45	Coarse	1.75	0.0689				
2.5	0.35	Fine	2.15	0.0846	2.70	0.1063	3.10	0.1220
	0.45	Coarse	2.05	0.0807				
3	0.35	Fine	2.65	0.1043	3.20	0.1260	3.60	0.1417
	0.50	Coarse	2.50	0.0984				
3.5	0.35	Fine	3.15	0.1240	3.70	0.1457	4.20	0.1653
	0.60	Coarse	2.90	0.1142				
4	0.50	Fine	3.50	0.1378	4.30	0.1693	4.80	0.1890
	0.70	Coarse	3.30	0.1299				
4.5	0.50	Fine	4.00	0.1575	4.80	0.1890	5.30	0.2087
	0.75	Coarse	3.70	0.1457				
5	0.50	Fine	4.50	0.1772	5.30	0.2087	5.80	0.2283
	0.80	Coarse	4.20	0.1654				
6	0.75	Fine	5.25	0.2067	6.40	0.2520	7.00	0.2756
	1.00	Coarse	5.00	0.1969				
7	0.75	Fine	6.25	0.2461	7.40	0.2913	8.00	0.3150
	1.00	Coarse	6.00	0.2362				
8	0.75	Fine	7.25	0.2854	8.40	0.3307	10.00	0.3937
	1.00	Fine	7.50	0.2953				
9	1.25	Coarse	6.80	0.2677	9.50	0.3740	10.50	0.4134
	0.75	Fine	8.25	0.3248				
10	1.00	Fine	8.00	0.3150	10.50	0.4134	12.00	0.4724
	1.25	Coarse	7.80	0.3071				
11	0.75	Fine	9.25	0.3642	12.00	0.4724	13.00	0.5118
	1.00	Fine	9.00	0.3543				
12	1.25	Fine	9.00	0.3543	13.00	0.5118	15.00	0.5905
	1.50	Fine	8.80	0.3465				
14	1.50	Fine	8.50	0.3346	15.00	0.5905	17.00	0.6693
	2.00	Coarse	13.00	0.5118				
15	1.00	Fine	12.80	0.5039	16.00	0.6299	18.00	0.7087
	1.50	Fine	12.50	0.4921				
16	1.00	Fine	12.00	0.4724	17.00	0.6693	19.00	0.7480
	1.50	Fine	14.00	0.5512				
17	1.00	Fine	14.00	0.5512	18.00	0.7087	20.00	0.7874
	1.50	Fine	15.00	0.5906				
18	1.00	Fine	15.00	0.5906	19.00	0.7480	21.00	0.8268
	1.50	Fine	14.50	0.5709				
20	2.00	Coarse	14.00	0.5512	21.00	0.8268	24.00	0.9449
	1.00	Fine	16.00	0.6299				
22	1.50	Fine	15.50	0.6103	23.00	0.9055	26.00	1.0236
	1.00	Fine	17.00	0.6693				
24	1.50	Fine	16.50	0.6496	25.00	0.9842	28.00	1.1024
	2.00	Fine	16.00	0.6299				
25	2.50	Coarse	15.50	0.6102	26.00	1.0236	30.00	1.1811
	1.00	Fine	19.00	0.7480				
25	1.50	Fine	18.50	0.7283	26.00	1.0236	30.00	1.1811
	2.00	Fine	18.00	0.7087				
25	2.00	Fine	17.50	0.6890	26.00	1.0236	30.00	1.1811
	1.00	Fine	21.00	0.8268				
25	1.50	Fine	20.50	0.8071	26.00	1.0236	30.00	1.1811
	2.00	Fine	20.00	0.7874				
25	2.50	Coarse	19.50	0.7677	26.00	1.0236	30.00	1.1811
	1.00	Fine	23.00	0.9055				
25	1.50	Fine	22.50	0.8858	26.00	1.0236	30.00	1.1811
	2.00	Fine	22.00	0.8661				
25	3.00	Coarse	21.00	0.8268	26.00	1.0236	30.00	1.1811
	1.00	Fine	24.00	0.9449				
25	1.50	Fine	23.50	0.9252	26.00	1.0236	30.00	1.1811
	2.00	Fine	23.00	0.9055				