

RECOMMENDED DRILLING SIZES FOR TAPPING (USING STANDARD DRILLS)

M ISO Metric Coarse					
Tap Size	Pitch	Tapping Drill	Clearance Drill		
		mm	mm		
M 1.6	0.35	1.25	1.80		
M 2	0.40	1.60	2.40		
M 2.5	0.45	2.05	2.90		
M 3	0.50	2.50	3.40		
M 3.5	0.60	2.90	3.90		
M 4	0.70	3.30	4.50		
M 5	0.80	4.20	5.50		
M 6	1.00	5.00	6.60		
M 8	1.25	6.80	9.00		
M 10	1.50	8.50	11.00		
M 12	1.75	10.30	13.50		
M 14	2.00	12.00	15.50		
M 16	2.00	14.00	17.50		
M 18	2.50	15.50	20.00		
M 20	2.50	17.50	22.00		
M 22	2.50	19.50	24.00		
M 24	3.00	21.00	26.00		
M 27	3.00	24.00	30.00		
M 30	3.50	26.50	33.00		
M 33	3.50	29.50	36.00		
M 36	4.00	32.00	39.00		
M 42	4.50	37.50	45.00		
M 48	5.00	43.00	52.00		
M 52	5.00	47.50	56.50		
M 56	5.50	50.00	62.00		
M ISO Metric Fine					
MF 8	1.0	7.0	9.00		
MF 10	1.25	8.8	11.00		
MF 12	1.25	10.8	13.50		
MF 12**	1.5	10.5	13.50		
MF 14	1.5	12.5	15.50		
MF 16	1.5	14.5	17.50		
MF 18	1.5	16.5	20.00		
MF 20	1.5	18.5	22.00		
MF 22	1.5	20.5	24.00		