

Drill hole Size for Metric Screw Threads in Accordance with 2nd Class of Limits

□ Straight Tap, Spiral tap

Thread Size	Drill Size(mm)	mm	
		Min	Max
M3 X 0.5	2.50	2.459	2.599
M4 X 0.7	3.30	3.242	3.422
M5 X 0.8	4.20	4.134	4.334
M6 X 1.0	5.00	4.917	5.153
M8 X 1.25	6.80	6.647	6.912
M10 X 1.25	8.80	8.647	8.912
M10 X 1.5	8.50	8.376	8.676
M12 X 1.0	11.00	10.917	11.153
M12 X 1.25	10.80	10.647	10.912
M12 X 1.5	10.50	10.376	10.676
M12 X 1.75	10.30	10.106	10.441
M14 X 1.5	12.50	12.376	12.676
M14 X 2.0	12.00	11.835	12.21
M16 X 1.5	14.50	14.376	14.676
M16 X 2.0	14.00	13.835	14.21
M18 X 1.5	16.50	16.376	16.676
M18 X 2.5	15.50	15.294	15.744
M20 X 1.5	18.50	18.376	18.676
M20 X 2.5	17.50	17.294	17.744

□ Roll tap

Thread Size	Drill Size(mm)	mm	
		Min	Max
M3 X 0.5	2.80	2.76	2.81
M4 X 0.7	3.70	3.65	3.7
M5 X 0.8	4.60	4.59	4.66
M6 X 1.0	5.50	5.48	5.57
M8 X 1.25	7.40	7.34	7.41
M10 X 1.25	9.40	9.34	9.41
M10 X 1.5	9.20	9.18	9.28
M12 X 1.0	11.50	11.48	11.57
M12 X 1.25	11.40	11.34	11.41
M12 X 1.5	11.20	11.18	11.28
M12 X 1.75	11.10	11.05	11.15