

Determination of the tap drill size

For all metric threads, the tap drill size is determined as follows:

nominal (major) diameter of the thread (in mm) – pitch (in mm) = tap drill size (in mm)

e. g. M6 x 1; 6 - 1 = 5mm

Determine the pitch of the appropriate thread with the help of your Mechanical and Metal Trades Handbook and complete the table.

nominal (major) diameter of the thread	pitch (in mm)	tap drill size
M3	.5	2.5
M4	.7	3.3
M5	.8	4.2
M6	1.0	5.0
M8	1.25	6.8
M10	1.50	8.5
M12	1.75	10.25
M14	2.0	12.0
M18	2.5	15.5