

# DRILL DIAMETERS FOR PREPARED HOLES

## ● Metric Coarse Screw Thread

Nominal	Drill Diameter	
	HSS	Carbide
M1 x0.25	0.75	0.75
M1.1x0.25	0.85	0.85
M1.2x0.25	0.95	0.95
M1.4x0.3	1.10	1.10
M1.6x0.35	1.25	1.30
M1.7x0.35	1.35	1.40
M1.8x0.35	1.45	1.50
M2 x0.4	1.60	1.65
M2.2x0.45	1.75	1.80
M2.3x0.4	1.90	1.95
M2.5x0.45	2.10	2.15
M2.6x0.45	2.15	2.20
M3 x0.5	2.50	2.55
M3.5x0.6	2.90	2.95
M4 x0.7	3.3	3.4
M4.5x0.75	3.8	3.9
M5 x0.8	4.2	4.3
M6 x1.0	5.0	5.1
M7 x1.0	6.0	6.1
M8 x1.25	6.8	6.9
M9 x1.25	7.8	7.9
M10 x1.5	8.5	8.7
M11 x1.5	9.5	9.7
M12 x1.75	10.3	10.5
M14 x2.0	12.0	12.2
M16 x2.0	14.0	14.2
M18 x2.5	15.5	15.7
M20 x2.5	17.5	17.7
M22 x2.5	19.5	19.7
M24 x3.0	21.0	—
M27 x3.0	24.0	—
M30 x3.5	26.5	—
M33 x3.5	29.5	—
M36 x4.0	32.0	—
M39 x4.0	35.0	—
M42 x4.5	37.5	—
M45 x4.5	40.5	—
M48 x5.0	43.0	—

## ● Metric Fine Screw Thread

Nominal	Drill Diameter		Nominal	Drill Diameter		Nominal	Drill Diameter		Nominal	Drill Diameter	
	HSS	Carbide		HSS	Carbide		HSS	Carbide		HSS	Carbide
M1 x0.2	0.80	0.80	M20 x2.0	18.0	18.3	M42 x3.0	39.0	—	M42 x3.0	39.0	—
M1.1x0.2	0.90	0.90	M20 x1.5	18.5	18.7	M42 x2.0	40.0	—	M42 x2.0	40.0	—
M1.2x0.2	1.00	1.00	M20 x1.0	19.0	19.1	M42 x1.5	40.5	—	M42 x1.5	40.5	—
M1.4x0.2	1.20	1.20	M22 x2.0	20.0	—	M45 x4.0	41.0	—	M45 x4.0	41.0	—
M1.6x0.2	1.40	1.40	M22 x1.5	20.5	—	M45 x3.0	42.0	—	M45 x3.0	42.0	—
M1.8x0.2	1.60	1.60	M22 x1.0	21.0	—	M45 x2.0	43.0	—	M45 x2.0	43.0	—
M2 x0.25	1.75	1.75	M24 x2.0	22.0	—	M45 x1.5	43.5	—	M45 x1.5	43.5	—
M2.2x0.25	1.95	2.00	M24 x1.5	22.5	—	M48 x4.0	44.0	—	M48 x4.0	44.0	—
M2.5x0.35	2.20	2.20	M24 x1.0	23.0	—	M48 x3.0	45.0	—	M48 x3.0	45.0	—
M3 x0.35	2.70	2.70	M25 x2.0	23.0	—	M48 x2.0	46.0	—	M48 x2.0	46.0	—
M3.5x0.35	3.20	3.20	M25 x1.5	23.5	—	M48 x1.5	46.5	—	M48 x1.5	46.5	—
M4 x0.5	3.50	3.55	M25 x1.0	24.0	—	M50 x3.0	47.0	—	M50 x3.0	47.0	—
M4.5x0.5	4.00	4.05	M26 x1.5	24.5	—	M50 x2.0	48.0	—	M50 x2.0	48.0	—
M5 x0.5	4.50	4.55	M27 x2.0	25.0	—	M50 x1.5	48.5	—	M50 x1.5	48.5	—
M5.5x0.5	5.00	5.05	M27 x1.5	25.5	—						
M6 x0.75	5.30	5.35	M27 x1.0	26.0	—						
M7 x0.75	6.30	6.35	M28 x2.0	26.0	—						
M8 x1.0	7.00	7.10	M28 x1.5	26.5	—						
M8 x0.75	7.30	7.35	M28 x1.0	27.0	—						
M9 x1.0	8.00	8.10	M30 x3.0	27.0	—						
M9 x0.75	8.30	8.35	M30 x2.0	28.0	—						
M10 x1.25	8.80	8.90	M30 x1.5	28.5	—						
M10 x1.0	9.00	9.10	M30 x1.0	29.0	—						
M10 x0.75	9.30	9.35	M32 x2.0	30.0	—						
M11 x1.0	10.0	10.1	M32 x1.5	30.5	—						
M11 x0.75	10.3	10.3	M33 x3.0	30.0	—						
M12 x1.5	10.5	10.7	M33 x2.0	31.0	—						
M12 x1.25	10.8	10.9	M33 x1.5	31.5	—						
M12 x1.0	11.0	11.1	M35 x1.5	33.5	—						
M14 x1.5	12.5	12.7	M36 x3.0	33.0	—						
M14 x1.0	13.0	13.1	M36 x2.0	34.0	—						
M15 x1.5	13.5	13.7	M36 x1.5	34.5	—						
M15 x1.0	14.0	14.1	M38 x1.5	36.5	—						
M16 x1.5	14.5	14.7	M39 x3.0	36.0	—						
M16 x1.0	15.0	15.1	M39 x2.0	37.0	—						
M17 x1.5	15.5	15.7	M39 x1.5	37.5	—						
M17 x1.0	16.0	16.1	M40 x3.0	37.0	—						
M18 x2.0	16.0	16.3	M40 x2.0	38.0	—						
M18 x1.5	16.5	16.7	M40 x1.5	38.5	—						
M18 x1.0	17.0	17.1	M42 x4.0	38.0	—						

(Note) When using the drill diameters shown in this table, that the processed hole should be measured since the size accuracy of a drill hole may change due to the drilling condition, and that if found to be inappropriate for a prepared hole, the drill diameter must be corrected accordingly.