

Tap Drill Sizes — ISO 2306 (reference)

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Engineering Reference · Tap Drill Sizes

Tap Drill Sizes to ISO 2306 (reference). Full dimensional table, materials, finishes and quotation. 47 sizes listed.



Tap Drill Sizes (ISO 2306 (reference)) are a type of engineering reference used across industrial assembly. Below is the complete size table together with material, standard and application guidance.

About This Reference

This is an engineering reference table for tap drill sizes based on ISO 2306 (reference). Use it alongside our fastener catalog when selecting and specifying parts.

Reference Data (ISO 2306 (reference))

Thread size	Pitch (mm)	Drill 75% thread (mm)	Drill 50% thread (mm)	Description
M1	0.25	0.75	0.8	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M1.2	0.25	0.95	1.0	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M1.4	0.3	1.1	1.15	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M1.6	0.35	1.25	1.3	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M1.8	0.35	1.45	1.5	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M2	0.4	1.6	1.65	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M2.5	0.45	2.05	2.1	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M3	0.5	2.5	2.55	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M3.5	0.6	2.9	2.95	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M4	0.7	3.3	3.4	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M4.5	0.75	3.7	3.8	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M5	0.8	4.2	4.3	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M6	1.0	5.0	5.1	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M7	1.0	6.0	6.1	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M8	1.25	6.8	6.9	Hand tapping: 75%; machine tapping 50% to reduce tool wear

Thread size	Pitch (mm)	Drill 75% thread (mm)	Drill 50% thread (mm)	Description
M8	1.0	7.0	7.1	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M9	1.25	7.8	7.9	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M10	1.5	8.5	8.7	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M10	1.25	8.8	8.9	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M11	1.5	9.5	9.7	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M12	1.75	10.2	10.4	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M12	1.5	10.5	10.7	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M14	2.0	12.0	12.2	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M14	1.5	12.5	12.7	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M16	2.0	14.0	14.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M16	1.5	14.5	14.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M18	2.5	15.5	15.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M18	1.5	16.5	16.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M20	2.5	17.5	17.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M20	1.5	18.5	18.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear

Thread size	Pitch (mm)	Drill 75% thread (mm)	Drill 50% thread (mm)	Description
M22	2.5	19.5	19.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M22	1.5	20.5	20.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M24	3.0	21.0	21.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M24	2.0	22.0	22.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M27	3.0	24.0	24.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M30	3.5	26.5	26.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M30	2.0	28.0	28.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M33	3.5	29.5	29.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M36	4.0	32.0	32.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M39	4.0	35.0	35.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M42	4.5	37.5	37.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M45	4.5	40.5	40.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M48	5.0	43.0	43.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M52	5.0	47.0	47.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M56	5.5	50.5	50.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear

Thread size	Pitch (mm)	Drill 75% thread (mm)	Drill 50% thread (mm)	Description
M60	5.5	54.5	54.75	Hand tapping: 75%; machine tapping 50% to reduce tool wear
M64	6.0	58.0	58.25	Hand tapping: 75%; machine tapping 50% to reduce tool wear

Related Fasteners

- [Clearance Hole Sizes — ISO 273](#)
- [Metric Fine Thread Dimensions — ISO 724](#)
- [Metric Thread Dimensions — ISO 724 / ISO 965](#)
- [Tightening Torque Reference — ISO 898 \(reference\)](#)
- [Bolt Property Classes — ISO 898-1](#)

Frequently Asked Questions

What does the Tap Drill Sizes reference table cover?

Tap Drill Sizes is an engineering reference table aligned with ISO 2306 (reference). Use the values alongside our fastener catalog when selecting and specifying parts.

How do I request a quotation?

Use the parametric drawing on this page to set the exact configuration (size, material, finish) and click "Request this configuration" — a specialist from engineeringhardware.com will respond within one business day.

More Engineering Reference

[← Previous](#)[Metric Fine Thread DimensionsISO 724](#)[Next →](#)[Clearance Hole SizesISO 273](#)