M1 Tap Drill Chart

Metric coarse (ISO) · 0.25 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

0.75 mm = 0.0295 in = 0.75 mm

Drills for M1 (50–85% thread)

DRILL	INCH	MM	% THREAD	
0.8 mm	0.0315	0.80	62%	
0.75 mm	0.0295	0.75	77%	Recommended

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	1.1 mm	0.0433	1.10
Normal	1.2 mm	0.0472	1.20
Loose	1.3 mm	0.0512	1.30

Thread dimensions (basic)

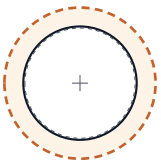
DIMENSION	INCH	MM
Major diameter (basic)	0.0394	1.00
Pitch diameter (basic)	0.0330	0.84
Minor diameter, internal (basic)	0.0287	0.73
Pitch	0.0098	0.25

Actual size

Print at 100% scale ("Actual size", not "Fit to page"). Check with the rulers below.

Dashed copper circle: thread major diameter; solid: tap drill hole; dotted: basic minor diameter.

Enlarged 20x:



Tap drill, actual size (0.75 mm):





Scan for the interactive version:

whatsizeis.com/tap-drill/m1/

Values from the ASME B1.1, ISO 261/68-1 and ASME B1.20.1 thread formulas; drill sizes per ASME B94.11M; clearance holes per ISO 273. Method: whatsizeis.com/how-we-calculate/