M10 Tap Drill Chart

Metric coarse (ISO) · 1.5 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

8.5 mm = 0.3346 in = 8.50 mm

Drills for M10 (50–85% thread)

DRILL	INCH	MM	% THREAD	
9 mm	0.3543	9.00	51%	
8.9 mm	0.3504	8.90	56%	
8.8 mm	0.3465	8.80	62%	
8.7 mm	0.3425	8.70	67%	
8.6 mm	0.3386	8.60	72%	
8.5 mm	0.3346	8.50	77%	Recommended
8.4 mm	0.3307	8.40	82%	

Clearance hole (bolt passes through)

FIT	DRILL	INCH	MM
Close	10.5 mm	0.4134	10.50
Normal	11 mm	0.4331	11.00
Loose	12 mm	0.4724	12.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.3937	10.00
Pitch diameter (basic)	0.3553	9.03
Minor diameter, internal (basic)	0.3298	8.38
Pitch	0.0591	1.50

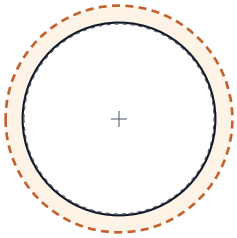
Actual size

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 3x:



Tap drill, actual size (8.50 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/m10/

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/