M18 Tap Drill Chart

Metric coarse (ISO) · 2.5 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

15.5 mm = 0.6102 in = 15.50 mm

Drills for M18 (50–85% thread)

DRILL	INCH	MM	% THREAD	
16 mm	0.6299	16.00	62%	
15.5 mm	0.6102	15.50	77%	Recommended

Clearance hole (bolt passes through)

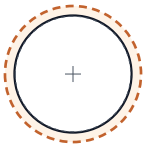
FIT	DRILL	INCH	MM
Close	19 mm	0.7480	19.00
Normal	20 mm	0.7874	20.00
Loose	21 mm	0.8268	21.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.7087	18.00
Pitch diameter (basic)	0.6447	16.38
Minor diameter, internal (basic)	0.6021	15.29
Pitch	0.0984	2.50

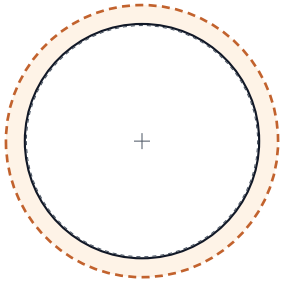
Actual size

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 2x:



Tap drill, actual size (15.50 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/m18/

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/