# M18x1.5 Tap Drill Chart

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

TAP DRILL (77% THREAD)

**16.5 mm** = 0.6496 in = 16.50 mm

## Drills for M18x1.5 (50–85% thread)

| DRILL | INCH | MM | % THREAD | |
|---|---|---|---|---|
| 17 mm | 0.6693 | 17.00 | 51% | |
| 16.5 mm | 0.6496 | 16.50 | 77% | Recommended |

## Clearance hole (bolt passes through)

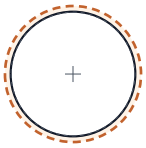
| FIT | DRILL | INCH | MM |
|---|---|---|---|
| Close | 19 mm | 0.7480 | 19.00 |
| Normal | 20 mm | 0.7874 | 20.00 |
| Loose | 21 mm | 0.8268 | 21.00 |

## Thread dimensions (basic)

| DIMENSION | INCH | MM |
|---|---|---|
| Major diameter (basic) | 0.7087 | 18.00 |
| Pitch diameter (basic) | 0.6703 | 17.03 |
| Minor diameter, internal (basic) | 0.6447 | 16.38 |
| Pitch | 0.0591 | 1.50 |

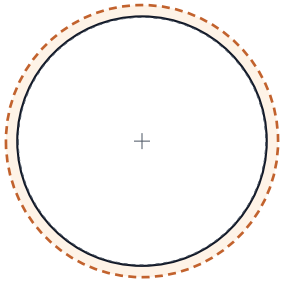
## Actual size

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 2x:**



**Tap drill, actual size (16.50 mm):**









Scan for the interactive version:

**whatsizeis.com/tap-drill/m18x1-5/**

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/