M22 Tap Drill Chart

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

TAP DRILL (77% THREAD)

19.5 mm = 0.7677 in = 19.50 mm

Drills for M22 (50–85% thread)

DRILL	INCH	MM	% THREAD	
20 mm	0.7874	20.00	62%	
19.5 mm	0.7677	19.50	77%	Recommended

Clearance hole (bolt passes through)

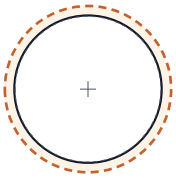
FIT	DRILL	INCH	MM
Close	23 mm	0.9055	23.00
Normal	24 mm	0.9449	24.00
Loose	26 mm	1.0236	26.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.8661	22.00
Pitch diameter (basic)	0.8022	20.38
Minor diameter, internal (basic)	0.7596	19.29
Pitch	0.0984	2.50

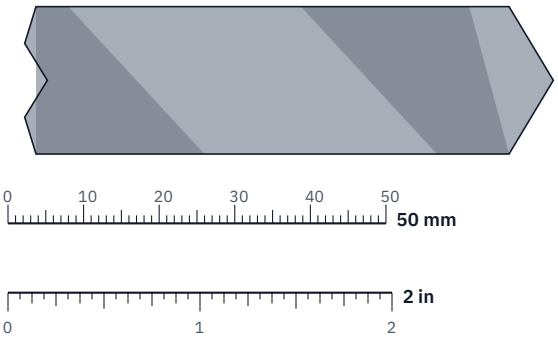
Actual size

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.

Tap drill, actual size (19.50 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m22/

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/