M22x1 Tap Drill Chart

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

TAP DRILL (77% THREAD)

21 mm = 0.8268 in = 21.00 mm

Drills for M22x1 (50–85% thread)

DRILL	INCH	MM	% THREAD	
21 mm	0.8268	21.00	77%	Recommended

Clearance hole (bolt passes through)

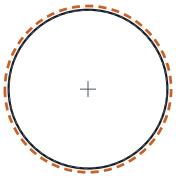
FIT	DRILL	INCH	MM
Close	23 mm	0.9055	23.00
Normal	24 mm	0.9449	24.00
Loose	26 mm	1.0236	26.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.8661	22.00
Pitch diameter (basic)	0.8406	21.35
Minor diameter, internal (basic)	0.8235	20.92
Pitch	0.0394	1.00

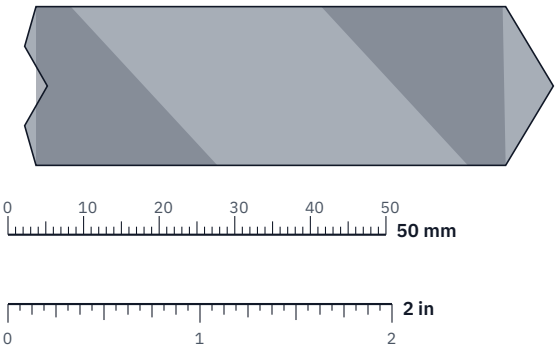
Actual size

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 (21.00 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m22x1/

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/