M24x1 Tap Drill Chart

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

TAP DRILL (77% THREAD)

23 mm = 0.9055 in = 23.00 mm

Drills for M24x1 (50–85% thread)

DRILL	INCH	MM	% THREAD	
23 mm	0.9055	23.00	77%	Recommended

Clearance hole (bolt passes through)

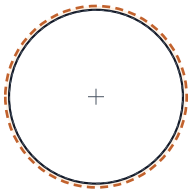
FIT	DRILL	INCH	MM
Close	25 mm	0.9843	25.00
Normal	26 mm	1.0236	26.00
Loose	28 mm	1.1024	28.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	0.9449	24.00
Pitch diameter (basic)	0.9193	23.35
Minor diameter, internal (basic)	0.9023	22.92
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 (23.00 mm):







Scan for the interactive version:

whatsizeis.com/tap-drill/m24x1/

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/