M27 Tap Drill Chart

Metric coarse (ISO) · 3 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

24 mm = 0.9449 in = 24.00 mm

Drills for M27 (50–85% thread)

DRILL	INCH	MM	% THREAD	
25 mm	0.9843	25.00	51%	
24.5 mm	0.9646	24.50	64%	
24 mm	0.9449	24.00	77%	Recommended

Clearance hole (bolt passes through)

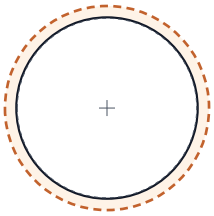
FIT	DRILL	INCH	MM
Close	28 mm	1.1024	28.00
Normal	30 mm	1.1811	30.00
Loose	32 mm	1.2598	32.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.0630	27.00
Pitch diameter (basic)	0.9863	25.05
Minor diameter, internal (basic)	0.9351	23.75
Pitch	0.1181	3.00

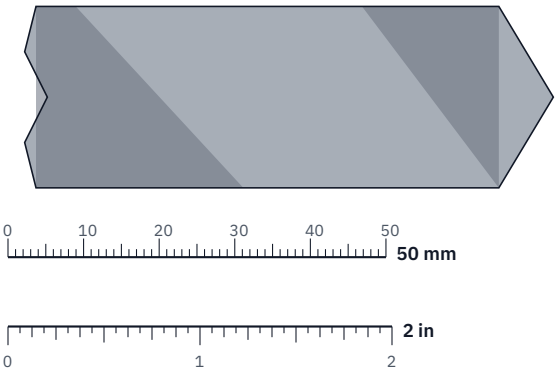
Actual size

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 (24.00 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m27/

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/