M27x1.5 Tap Drill Chart

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

TAP DRILL (77% THREAD)

25.5 mm = 1.0039 in = 25.50 mm

Drills for M27x1.5 (50–85% thread)

DRILL	INCH	MM	% THREAD	
26 mm	1.0236	26.00	51%	
25.5 mm	1.0039	25.50	77%	Recommended

Clearance hole (bolt passes through)

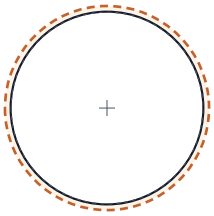
FIT	DRILL	INCH	MM
Close	28 mm	1.1024	28.00
Normal	30 mm	1.1811	30.00
Loose	32 mm	1.2598	32.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.0630	27.00
Pitch diameter (basic)	1.0246	26.03
Minor diameter, internal (basic)	0.9991	25.38
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.





Scan for the interactive version:

whatsizeis.com/tap-drill/m27x1-5/

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/