M27x2 Tap Drill Chart

Metric fine (ISO) · 2 mm pitch · ISO 261 / ISO 68-1

TAP DRILL (77% THREAD)

25 mm = 0.9843 in = 25.00 mm

Drills for M27x2 (50–85% thread)

DRILL	INCH	MM	% THREAD	
25.5 mm	1.0039	25.50	58%	
25 mm	0.9843	25.00	77%	Recommended

Clearance hole (bolt passes through)

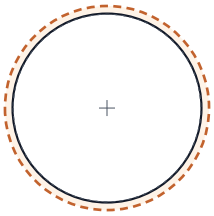
FIT	DRILL	INCH	MM
Close	28 mm	1.1024	28.00
Normal	30 mm	1.1811	30.00
Loose	32 mm	1.2598	32.00

Thread dimensions (basic)

DIMENSION	INCH	MM
Major diameter (basic)	1.0630	27.00
Pitch diameter (basic)	1.0118	25.70
Minor diameter, internal (basic)	0.9778	24.83
Pitch	0.0787	2.00

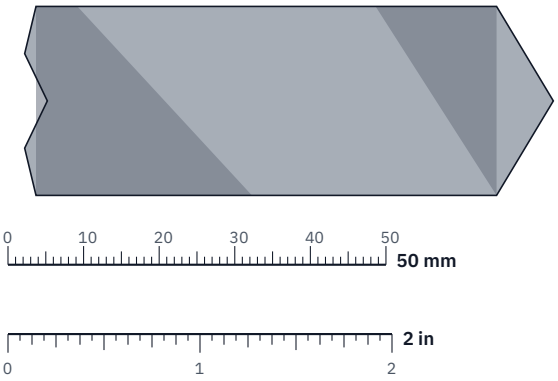
Actual size

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 (25.00 mm):



Scan for the interactive version:

whatsizeis.com/tap-drill/m27x2/

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/