Metric tap drill chart

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Metric coarse

THREAD	PITCH (MM)	TAP DRILL (MM)	TAP DRILL (IN)	CLEARANCE HOLE (MM)
M1.6	0.35	1.25	0.0492	1.8
M2	0.4	1.6	0.0630	2.4
M2.5	0.45	2.05	0.0807	2.9
M3	0.5	2.5	0.0984	3.4
M3.5	0.6	2.9	0.1142	3.9
M4	0.7	3.3	0.1299	4.5
M5	0.8	4.2	0.1654	5.5
M6	1.0	5.0	0.1969	6.6
M8	1.25	6.8	0.2677	9.0
M10	1.5	8.5	0.3346	11.0
M12	1.75	10.2	0.4016	13.5
M14	2.0	12.0	0.4724	15.5
M16	2.0	14.0	0.5512	17.5
M18	2.5	15.5	0.6102	20.0
M20	2.5	17.5	0.6890	22.0
M22	2.5	19.5	0.7677	24.0
M24	3.0	21.0	0.8268	26.0
M27	3.0	24.0	0.9449	30.0
M30	3.5	26.5	1.0433	33.0
M33	3.5	29.5	1.1614	36.0
M36	4.0	32.0	1.2598	39.0

Metric fine

THREAD	PITCH (MM)	TAP DRILL (MM)	TAP DRILL (IN)	CLEARANCE HOLE (MM)
M8 x 1.0	1.0	7.0	0.2756	9.0
M10 x 1.25	1.25	8.8	0.3465	11.0
M10 x 1.0	1.0	9.0	0.3543	11.0
M12 x 1.5	1.5	10.5	0.4134	13.5
M12 x 1.25	1.25	10.8	0.4252	13.5
M14 x 1.5	1.5	12.5	0.4921	15.5
M16 x 1.5	1.5	14.5	0.5709	17.5
M18 x 1.5	1.5	16.5	0.6496	20.0
M20 x 1.5	1.5	18.5	0.7283	22.0
M22 x 1.5	1.5	20.5	0.8071	24.0
M24 x 2.0	2.0	22.0	0.8661	26.0
M27 x 2.0	2.0	25.0	0.9843	30.0
M30 x 2.0	2.0	28.0	1.1024	33.0
M36 x 3.0	3.0	33.0	1.2992	39.0

Tap drill for a cut tap = major diameter minus pitch (ISO 2306), about 75% thread. Clearance hole: ISO 273, medium series.
M8, M12, M10 x 1.25, M12 x 1.25: the standard stocked drill is shown; the exact ISO 2306 value is 6.75 mm, 10.25 mm, 8.75 mm, 10.75 mm.