

METRIC THREADFORMERS TOLERANCES & HOLE SIZES

| TAP SIZE | 6H | PROBABLE DRILL SIZE | TAP SIZE | 4H | PROBABLE DRILL SIZE |
|----------|-----|---------------------|----------|----|---------------------|
| M2X.4 | D5 | 1.85mm | M2X.4 | D3 | 1.8mm |
| M2.5X.45 | D6 | 2.35mm | M2.5X.45 | D3 | 2.3mm |
| M3X.5 | D6 | 2.80mm | M3X.5 | D3 | 2.75mm |
| M3.5X.6 | D7 | 3.25mm | M3.5X.6 | D4 | 3.2mm |
| M4X.7 | D7 | 3.70mm | M4X.7 | D4 | #27 |
| M5X.8 | D8 | 4.70mm | M5X.8 | D4 | 4.6mm |
| M6X1.0 | D9 | 5.5mm | M6X1.0 | D5 | 5.5mm |
| M8X1.25 | D10 | 7.40mm | M8X1.25 | D5 | 7.3mm |
| M10X1.5 | D11 | 9.25mm | M10X1.5 | D6 | 9.2mm |

To convert millimeters to inches, multiply by .03937

THREAD LIMITS

Table 337 – STANDARD METRIC TAPS – GROUND THREAD

| Nominal Size mm | Pitch mm | Major Diameter Inches | | | Standard Pitch Diameter Limits Inches | | | | | | | | | | | | | | |
|--------------------|-------------|--------------------------|--------|--------|--|------------|-------|------------|-------|------------|-------|------------|-------|------------|-------|------------|-------|------------|--------|
| | | Basic | Min. | Max. | Basic Pitch Dia. | D-3 Limits | | D-4 Limits | | D-5 Limits | | D-6 Limits | | D-7 Limits | | D-8 Limits | | D-9 Limits | |
| | | | | | | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. |
| 1.6 | 0.35 | .062992 | .0641 | .0651 | .054042 | .0550 | .0556 | | | | | | | | | | | | |
| 2 | 0.4 | .078740 | .0801 | .0811 | .068511 | .0695 | .0701 | | | | | | | | | | | | |
| 2.5 | 0.45 | .098425 | .0999 | .1009 | .086918 | .0879 | .0885 | | | | | | | | | | | | |
| 3 | 0.5 | .118110 | .1198 | .1208 | .105324 | .1063 | .1069 | | | | | | | | | | | | |
| 3.5 | 0.6 | .137795 | .1397 | .1407 | .122452 | | | .1237 | .1245 | | | | | | | | | | |
| 4 | 0.7 | .157480 | .1597 | .1613 | .139580 | | | .1408 | .1416 | | | | | | | | | | |
| 5 | 0.8 | .196850 | .1994 | .2010 | .176393 | | | .1776 | .1784 | | | | | | | | | | |
| 6 | 1 | .236220 | .2395 | .2411 | .210648 | | | | | .2122 | .2132 | | | | | | | | |
| 8 | 1.25 | .314960 | .3189 | .3214 | .282995 | | | | | .2843 | .2855 | | | | | | | | |
| 10 | 1.5 | .393700 | .3985 | .4010 | .355343 | | | | | | | .3572 | .3584 | | | | | | |
| 12 | 1.75 | .472440 | .4780 | .4805 | .427690 | | | | | | | .4295 | .4307 | | | | | | |
| 14 | 2 | .551180 | .5575 | .5600 | .500037 | | | | | | | | | .5020 | .5036 | | | | |
| 16 | 2 | .629920 | .6363 | .6388 | .578777 | | | | | | | | | .5807 | .5823 | | | | |
| 20 | 2.5 | .787400 | .7954 | .7979 | .723471 | | | | | | | | | .7254 | .7270 | | | | |
| 24 | 3 | .944880 | .9544 | .9583 | .868165 | | | | | | | | | | | .8706 | .8722 | | |
| 30 | 3.5 | 1.181100 | 1.1922 | 1.1961 | 1.091599 | | | | | | | | | | | | | 1.0942 | 1.0962 |
| 36 | 4 | 1.417320 | 1.4300 | 1.4339 | 1.315034 | | | | | | | | | | | | | 1.3176 | 1.3196 |