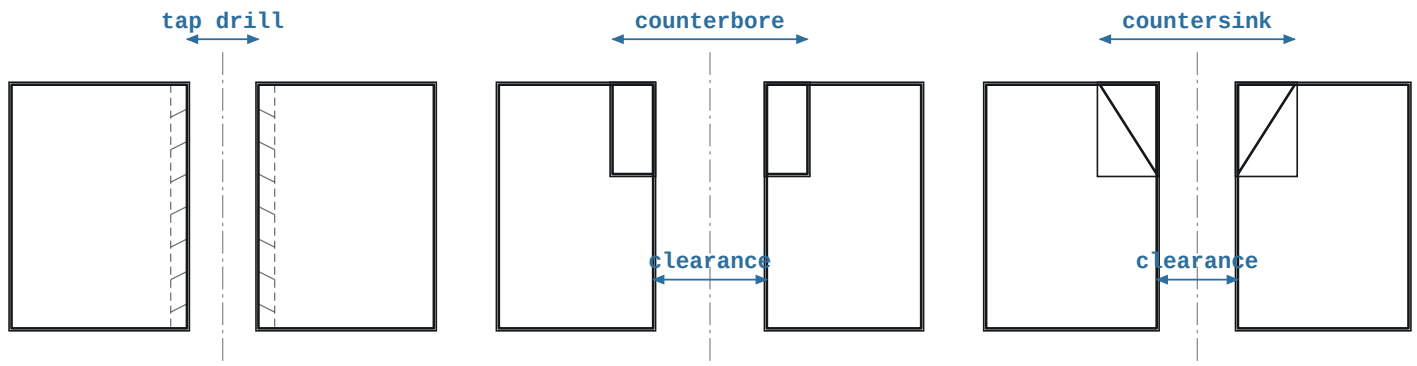
SHOP CHARTS

DRILL PRESS CHEAT SHEET

Most-used metric sizes, coarse thread. Tap, clearance and counterbore in mm.

LAVIGNE LABS



TAPPED HOLE
drill → tap · thread bites past the drill

CLEARANCE + C'BORE
socket head sits flush or below

COUNTERSINK
90° · flat head sits flush

SIZE	SERIES	PITCH	TAP DRILL 75%	HARD MAT. 65%	CLEAR CLOSE	CLEAR NORMAL	CLEAR LOOSE	SHCS C'BORE	C'BORE DEPTH	C
M2	coarse	0.4	**ø1.6**	ø1.65	ø2.2	ø2.4	ø2.6	ø4.4	2	
M2.5	coarse	0.45	**ø2.05**	ø2.1	ø2.7	ø2.9	ø3.1	ø5.4	2.5	
M3	coarse	0.5	**ø2.5**	ø2.6	ø3.2	ø3.4	ø3.6	ø6.5	3	ø6
M4	coarse	0.7	**ø3.3**	ø3.4	ø4.3	ø4.5	ø4.8	ø8.25	4	ø8
M5	coarse	0.8	**ø4.2**	ø4.3	ø5.3	ø5.5	ø5.8	ø9.75	5	ø1
M6	coarse	1	**ø5.0**	ø5.2	ø6.4	ø6.6	ø7.0	ø11.2	6	ø13
M8	coarse	1.25	**ø6.8**	ø6.9	ø8.4	ø9.0	ø10.0	ø14.5	8	ø17
M10	coarse	1.5	**ø8.5**	ø8.7	ø10.5	ø11.0	ø12.0	ø17.5	10	ø2
M12	coarse	1.75	**ø10.2**	ø10.5	ø13.0	ø13.5	ø14.5	ø19.5	12	ø26