

THREAD DESIGNATION	Minor Diameter for a Class 6H Thread				Recommendations for High Performance Drills for a Class 6H Thread Available from Stock							
	Maximum hole size for lowest % of thread		Minimum hole size for lowest % of thread		For <u>Lowest</u> % of Thread Engagement			For <u>Highest</u> % of Thread Engagement			For Thread Milling	
	mm	Decimal Equivalent	mm	Decimal Equivalent	Drill Size	Decimal Equivalent	Actual % of Thread Engagement	Drill Size	Decimal Equivalent	Actual % of Thread Engagement	Drill Size	Decimal Equivalent
M4 X 0.7	3,271	0.1288	3,091	0.1217	3.2	0.1260	88%	3.1	0.1220	99%	3.0	0.1181
M4 X 0.75	3,216	0.1266	3,026	0.1191	3.2	0.1260	82%	3.1	0.1220	92%	3.0	0.1181
M5 X 0.8	4,161	0.1638	3,961	0.1559	4.1	0.1614	87%	5/32	0.1563	99%	3.9	0.1535
M6 X 1	4,937	0.1944	4,701	0.1851	4.9	0.1929	85%	3/16	0.1875	95%	4.6	0.1811
M7 X 1	5,937	0.2337	5,701	0.2244	5.9	0.2323	85%	5.8	0.2283	92%	5.6	0.2205
M8 X 1	6,937	0.2731	6,701	0.2638	6.9	0.2717	85%	17/64	0.2656	96%	6.6	0.2598
M8 X 1.25	6,641	0.2615	6,376	0.2510	6.6	0.2598	86%	6.4	0.2520	99%	1/4	0.0098
M9 X 1.25	7,641	0.3008	7,376	0.2904	7.6	0.2992	86%	7.4	0.2913	99%	17.3	0.6811
M10 X 0.75	9,216	0.3628	9,026	0.3553	9.2	0.3622	82%	9.1	0.3583	92%	8.9	0.3504
M10 X 1.25	8,641	0.3402	8,376	0.3298	8.6	0.3386	86%	8.4	0.3307	99%	8.3	0.3268
M10 X 1.5	8,351	0.3288	8,051	0.3170	21/64	0.3281	85%	8.1	0.3189	98%	8.0	0.3150
M12 X 1	10,937	0.4306	10,701	0.4213	10.9	0.4291	85%	27/64	0.4219	99%	10.6	0.4173
M12 X 1.25	10,641	0.4189	10,376	0.4085	10.6	0.4173	86%	10.4	0.4094	99%	13/32	0.0160
M12 X 1.5	10,351	0.4075	10,051	0.3957	13/32	0.4063	86%	10.1	0.3976	98%	10.0	0.3937
M12 X 1.75	10,062	0.3961	9,727	0.3829	10.0	0.3937	88%	9.8	0.3858	97%	9.7	0.3819
M14 X 2	11,777	0.4637	11,402	0.4489	11.7	0.4606	89%	11.5	0.4528	96%	11.3	0.4449
M15 X 1	13,937	0.5487	13,701	0.5394	13.8	0.5433	92%	13.8	0.5433	92%	13.5	0.5315
M16 X 1.5	14,351	0.5650	14,051	0.5532	9/16	0.5625	88%	9/16	0.5625	88%	14.0	0.5512
M16 X 2	13,777	0.5424	13,402	0.5276	13.5	0.5315	96%	13.5	0.5315	96%	33/64	0.0203
M17 X 1	15,937	0.6274	15,701	0.6181	5/8	0.6250	87%	15.8	0.6220	92%	15.5	0.6102
M18 X 2.5	15,202	0.5985	14,752	0.5808	15.0	0.5906	92%	14.8	0.5827	99%	14.5	0.5709
M20 X 2.5	17,202	0.6773	16,752	0.6595	17.0	0.6693	92%	17.0	0.6693	92%	16.5	0.6496
M22 X 2.5	19,202	0.7560	18,752	0.7383	3/4	0.7500	91%	19.0	0.7480	92%	18.5	0.7283