

Recommended Drill Sizes for Inch XTF Forming Taps							
Nominal Size & Pitch mm	Theoretical Drill Size		Drill Approx. 65% Thread	Decimal Equivalent Inches	Tap Suggested for Class of Thread		
	Max. Approx. 55% Thread	Min. Approx. 75% Thread			2B	3B	B
0-80 NF	0.0553	0.0537	54	0.0550	H3	H2	H2
1-64NC	0.0671	0.0652	51	0.0670	-	H2	H2
1-72 NF	0.0678	0.0661	51	0.0670	H3	H2	H2
2-56 NC	0.0793	0.0771	5/64	0.0781	H3	H2	H2
2-64 NF	0.0801	0.0782	47	0.0785	H3	H3	H3
3-48 NC	0.0912	0.0886	43	0.0890	H3	H2	H2
3-56 NF	0.0923	0.0901	2.3mm	0.0905	H3	H2	H2
4-40 NC	0.1026	0.0995	38	0.1015	H5	H3	H3
4-48 NF	0.1042	0.1016	2.6mm	0.1024	H5	H3	H3
5-40 NC	0.1156	0.1125	2.9mm	0.1142	H5	H3	H3
6-32 NC	0.1263	0.1224	1/8	0.1250	H5	H3	H3
6-40 NF	0.1268	0.1255	3.25mm	0.1280	H5	H3	H3
8-32 NC	0.1523	0.1484	25	0.1495	H5	H3	H3
8-36 NF	0.1536	0.1501	24	0.1520	H5	H3	H3
10-24 NC	0.1744	0.1692	11/64	0.1719	H6	H4	H4
10-32 NF	0.1783	0.1744	16	0.1770	H6	H4	H4
12-24 NC	0.2004	0.1952	8	0.1990	H6	H4	H4
1/4-20 NC	0.2312	0.2250	1	0.2280	H6	H4	H4
1/4-28 NF	0.2366	0.2322	15/16	0.2344	H5	H4	H4
5/16-18 NC	0.2917	0.2847	L	0.2900	H7	H5	H5
5/16-24 NF	0.2969	0.2917	M	0.2950	H7	H5	H5
3/8-16 NC	0.3516	0.3438	S	0.3480	H7	H5	H5
3/8-24 NF	0.3594	0.3542	T	0.3580	H7	H5	H5
1/2-13 NC	0.4712	0.4615	15/32	0.4682	H8	H5	H5

Recommended Drill Sizes and "D" Limits for Metric XTF Forming Taps						
Nominal Size & Pitch mm	Recommended "D" Limit Class 6H Threads	Theoretical Drill Size		Rec. Drill Sizes		
		Max. Approx. 55% Thread	Min. Approx. 75% Thread	Drill Approx. 65% Thread	Decimal Equivalent Inches	
M1.6x0.35	D5	0.0578	0.0561	1.45mm	0.0571	
M2x0.4	D5	0.0728	0.0709	1.8mm	0.0709	
M2.5x0.45	D5	0.0918	0.0896	2.3mm	0.0905	
M3x0.5	D5	0.1107	0.1083	7/64	0.1094	
M3.5x0.6	D6	0.1289	0.1260	3.2mm	0.1260	
M4x0.7	D6	0.1471	0.1437	3.7mm	0.1457	
M5x0.8	D7	0.1850	0.1811	No.14	0.1820	
M6x1	D8	0.2215	0.2165	7/32	0.2188	
M8x1.25	D9	0.2965	0.2904	7.4mm	0.2913	
M10x1.5	D10	0.3716	0.3642	"U"	0.3680	
M12x1.75	D11	0.4460	0.4380	11.2mm	0.4409	