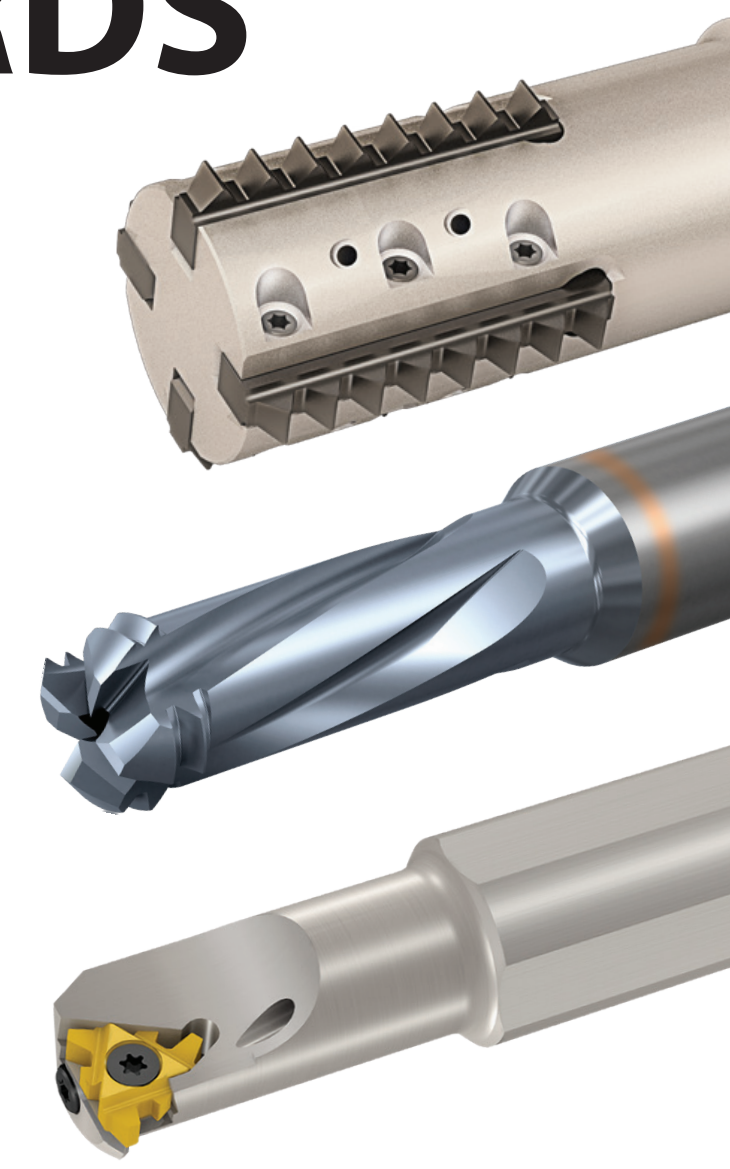
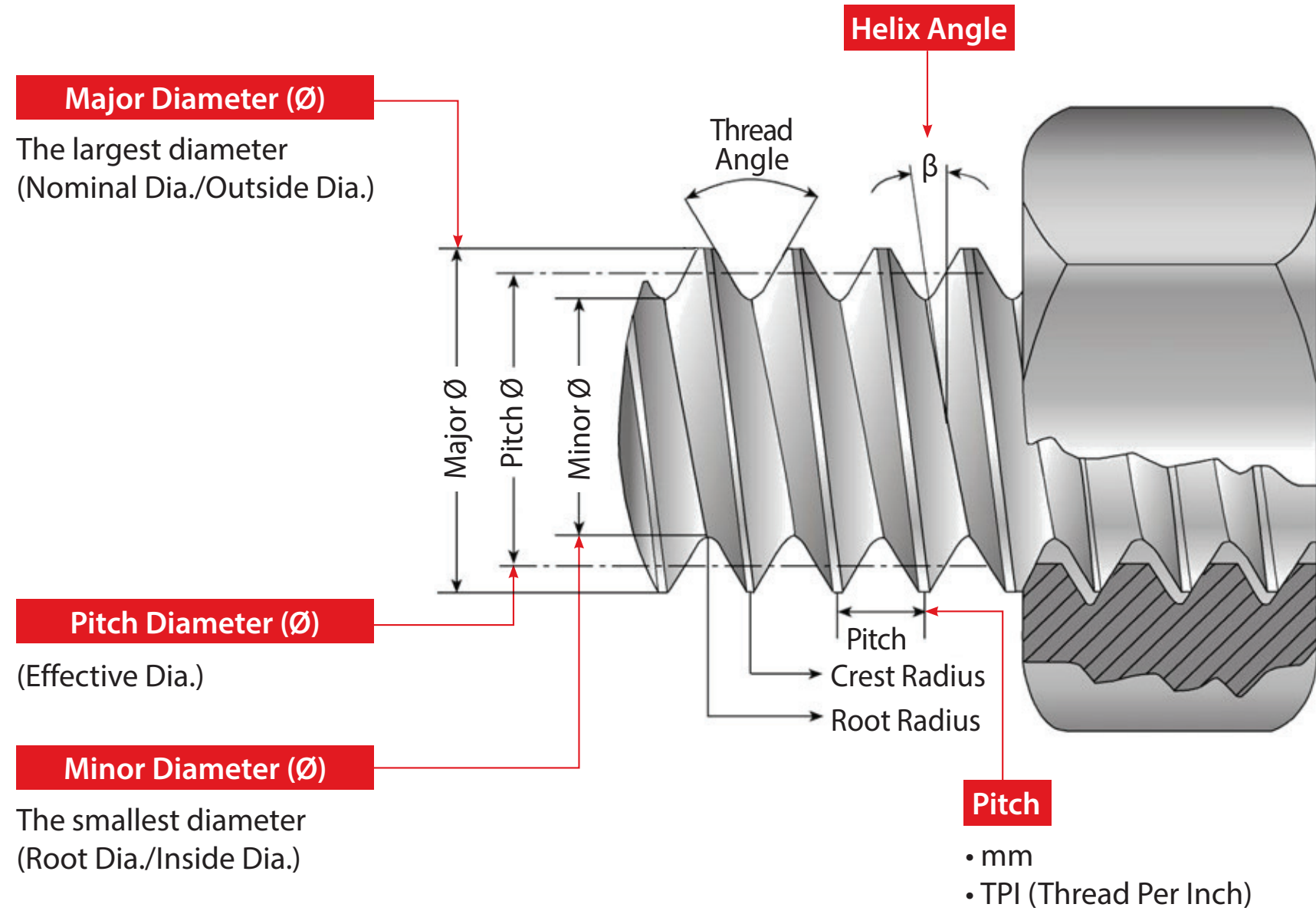
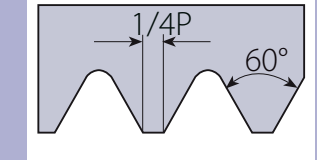


## THREADING STANDARDS



### ISO Metric DIN 13 | Class: 6H



#### M Coarse

Thread	Minor Ø min	Minor Ø max	Drill Ø
1x0.25	0.729	0.809	0.75
1.2x0.25	0.929	1.009	0.95
1.4x0.3	1.075	1.258	1.1
1.6x0.35	1.221	1.321	1.25
1.8x0.35	1.421	1.521	1.45
2x0.4	1.567	1.679	1.6
2.2x0.45	1.713	1.838	1.75
2.5x0.45	2.013	2.138	2.05
3x0.5	2.459	2.599	2.5
3.5x0.6	2.850	3.010	2.9
4x0.7	3.242	3.422	3.3
4.5x0.75	3.688	3.878	3.7
5x0.8	4.134	4.334	4.2
6x1	4.917	5.153	5
7x1	5.917	6.153	6
8x1.25	6.647	6.912	6.8
10x1.5	8.376	8.676	8.5
12x1.75	10.106	10.441	10.2
14x2	11.835	12.210	12
16x2	13.835	14.210	14
18x2.5	15.294	15.744	15.5
20x2.5	17.294	17.744	17.5
22x2.5	19.294	19.744	19.5
24x3	20.752	21.252	21
27x3	23.752	24.252	24
30x3.5	26.211	26.711	26.5
33x3.5	29.211	29.711	29.5
36x4	31.670	32.270	32
39x4	34.670	35.270	35
42x4.5	37.129	37.729	37.5
45x4.5	40.129	40.729	40.5
48x5	42.587	43.287	43
52x5	46.587	47.287	47
56x5.5	50.046	50.796	50.5
60x5.5	54.046	54.796	54.5
64x6	57.505	58.305	58
68x6	61.505	62.305	62

#### M Fine

Thread	Minor Ø min	Minor Ø max	Drill Ø
2x0.25	1.729	1.809	1.75
2.2x0.25	1.929	2.009	1.95
2.3x0.25	2.029	2.109	2.05
2.5x0.35	2.121	2.221	2.15
2.6x0.35	2.221	2.321	2.25
3x0.35	2.621	2.721	2.65
3.5x0.35	3.121	3.221	3.15
4x0.35	3.621	3.721	3.65
4x0.5	3.459	3.599	3.5
4.5x0.5	3.959	4.099	4
5x0.5	4.459	4.599	4.5
6x0.5	5.459	5.599	5.5
6x0.75	5.188	5.378	5.2
7x0.75	6.188	6.378	6.2
8x0.5	7.459	7.599	7.5
8x0.75	7.188	7.378	7.2
8x1	6.917	7.153	7
9x1	7.917	8.153	8
10x0.75	9.188	9.378	9.2
10x1	8.917	9.153	9
10x1.25	8.647	8.912	8.8
11x1	9.917	10.153	10
12x1	10.917	11.153	11
12x1.25	10.647	10.912	10.8
12x1.5	10.376	10.676	10.5
14x1	12.917	13.153	13
14x1.25	12.647	12.912	12.8
14x1.5	12.376	12.676	12.5
15x1	13.917	14.153	14
15x1.5	13.376	13.676	13.5
16x1	14.917	15.153	15
16x1.5	14.376	14.676	14.5
18x1	16.917	17.153	17
18x1.5	16.376	16.676	16.5
18x2	15.835	16.210	16
20x1	18.917	19.153	19
20x1.5	18.376	18.676	18.5
20x2	17.835	18.210	18
22x1	20.917	21.153	21
22x1.5	20.376	20.676	20.5
22x2	19.835	20.210	20
24x1	22.917	23.153	23
24x1.5	22.376	22.676	22.5
24x2	21.835	22.210	22
36x3	32.752	33.252	33
39x3	35.752	36.252	36

### BSW

B.S.84:1956, DIN 259, ISO228/1:1982  
Class: Medium A

Thread	Minor Ø min	Minor Ø max	Drill Ø
1/16 - 60	1.045	1.23	1.15
1/8 - 48	1.704	1.912	1.85
1/8 - 40	2.362	2.591	2.5
3/16 - 32	2.952	3.214	3.1
3/16 - 24	3.407	3.745	3.7
1/4 - 20	4.201	4.539	4.4
1/4 - 20	4.724	5.156	5.1
5/16 - 18	6.130	6.590	6.5
5/16 - 14	7.492	7.987	7.9
7/16 - 14	8.789	9.330	9.2
1/2 - 12	9.989	10.591	10.4
1/2 - 12	11.577	12.179	12
3/4 - 11	12.918	13.559	13.4
3/4 - 10	15.797	16.483	16.3
7/8 - 9	18.611	19.353	19.2
1 - 8	21.334	22.147	22
1 1/8 - 7	23.928	24.832	24.6
1 1/4 - 7	27.103	28.007	27.7
1 1/2 - 6	29.504	30.528	30.2
1 1/2 - 6	32.679	33.703	33.4
1 3/4 - 5	34.769	35.963	35.5
1 3/4 - 5	37.944	39.138	38.7
1 7/8 - 4 1/2	40.396	41.702	41.3
2 - 4 1/2	43.571	44.877	44.5

### BSF

B.S.84:1956, DIN 259, ISO228/1:1982  
Class: Medium A

Thread	Minor Ø min	Minor Ø max	Drill Ø
3/16 - 32	3.746	4.005	3.9
7/32 - 28	4.395	4.677	4.6
1/4 - 26	5.099	5.396	5.3
5/32 - 24	5.893	6.190	6.1
5/16 - 22	6.459	6.817	6.7
3/8 - 20	7.899	8.331	8.2
7/16 - 18	9.305	9.765	9.6
7/16 - 16	10.667	11.162	11
1/2 - 16	12.254	12.749	12.6
1/2 - 14	13.552	14.093	13.9
5/8 - 14	15.139	15.68	15.5
3/4 - 12	16.339	16.941	16.7
7/8 - 12	17.927	18.529	18.3
1 - 8	19.268	19.908	19.7
1 - 10	22.147	22.833	22.6
1 1/8 - 9	24.961	25.703	25.5
1 1/4 - 9	28.136	28.878	28.7
1 1/2 - 8	30.859	31.672	31.5
1 1/2 - 8	34.034	34.847	34.6
1 3/4 - 8	37.209	38.022	37.8
1 3/4 - 7	39.803	40.707	40.5
2 - 7	46.153	47.057	46.8

### BSP (G)

B.S.2779:1956  
Class: Medium

Thread	Minor Ø min	Minor Ø max	Drill Ø
G1/16 - 28	6.561	6.843	6.7
G1/8 - 28	8.566	8.848	8.7
G1/4 - 19	11.445	11.890	11.7
G3/8 - 19	14.950	15.395	15.2
G1/2 - 14	18.631	19.172	19
G5/8 - 14	20.587	21.128	21
G3/4 - 14	24.117	24.658	24.5
G7/8 - 14	27.877	28.418	28.3
G1 - 11	30.291	30.931	30.8
G1 1/8 - 11	34.939	35.579	35.4
G1 1/4 - 11	38.952	39.592	39.4
G1 1/2 - 11	44.845	45.485	45.3
G1 3/4 - 11	50.788	51.428	51.2
G2 - 11	56.656	57.296	57
G2 1/4 - 11	62.752	63.392	63.2
G2 1/2 - 11	72.226	72.866	72.7
G2 3/4 - 11	78.576	79.216	79
G3 - 11	84.926	85.566	85.4

### Trapez

DIN 103  
Class: 7H

Thread	Minor Ø min	Minor Ø max	Drill Ø
8x1.5	6.5	6.69	6.6
9x1.5	7.5	7.69	7.6
9x2	7.0	7.236	7.1
10x1.5	8.5	8.69	8.6
10x2	8.0	8.236	8.1
11x2	9.0	9.236	9.1
11x3	8.0	8.315	8.2
12x2	10.0	10.236	10.1
12x3	9.0	9.315	9.2
14x2	12.0	12.236	12.1
14x3	11.0	11.315	11.2
16x2	14.0	14.236	14.1
16x4	12.0	12.375	12.2
18x2	16.0	16.236	16.1
18x4	14.0	14.375	14.2
20x2	18.0	18.236	18.1
20x4	16.0	16.375	16.2
22x3	19.0	19.315	19.2
22x5	17.0	17.450	17.3
24x3	21.0	21.315	21.2
24x5	19.0	19.450	19.3
26x3	23.0	23.315	23.2
26x5	21.0	21.450	21.3
28x3	25.0	25.315	25.2
28x5	23.0	23.450	23.3
30x3	27.0	27.315	27.2
30x6	24.0	24.500	24.3
32x3	29.0	29.315	29.2
32x6	26.0	26.500	26.3
34x3	31.0	31.315	31.2
34x6	28.0	28.500	28.3
36x3	33.0	33.315	33.2
36x6	30.0	30.500	30.3
38x7	31.0	31.560	31.4
40x7	33.0	33.560	33.4
42x7	35.0	35.560	35.4
44x7	37.0	37.560	37.4
46x8	38.0	38.630	38.5
48x8	40.0	40.630	40.5
50x8	42.0	42.630	42.5
52x8	44.0	44.630	44.5

### ACME

ANSI B1.5:1988  
Class: 3G

Thread	Minor Ø min	Minor Ø max	Drill Ø
1/4 - 16	4.763	4.890	4.8
3/8 - 12	6.124	6.251	6.2
3/8 - 12	7.409	7.536	7.4
1/2 - 12	8.997	9.124	9
1/2 - 10	10.160	10.287	10.2
5/8 - 8	12.700	12.857	12.7
3/4 - 6	14.816	15.027	14.9
7/8 - 6	17.991	18.202	18
1 - 5	20.320	20.574	20.4
1 1/8 - 5	23.495	23.749	23.6
1 1/4 - 5	26.670	26.924	26.7
1 3/4 - 4	28.755	28.893	28.7
1 1/2 - 4	31.750	32.068	31.8
1 3/4 - 4	38.100	38.418	38.2
2 - 4	44.450	44.768	44.6
2 1/4 - 3	48.684	49.108	48.8
2 1/2 - 3	55.034	55.458	55.2
2 3/4 - 3	61.384	61.808	61.6
3 - 2	63.500	64.135	63.8

### Stub ACME

ANSI B1.8:1988  
Class: 2G

Thread	Minor Ø min	Minor Ø max	Drill Ø
3/8 - 8	13.970	14.130	14
3/4 - 6	16.510	16.721	16.6
7/8 - 6	19.685	19.896	19.7
1 - 5	22.352	22.606	22.4
1 1/8 - 5	25.527	25.781	25.6
1 1/4 - 5	28.702	28.956	28.8
1 3/4 - 4	31.115	31.433	31.3
1 1/2 - 4	34.290	34.607	34.4
1 3/4 - 4	40.640	40.957	40.8
2 - 4	46.990	47.307	47.1
2 1/4 - 3	52.070	52.494	52.3
2 1/2 - 3	58.420	58.844	58.6
2 3/4 - 3	64.770	65.194	65

### Round

DIN 405  
Class: 7H

Thread	Minor Ø min	Minor Ø max	Drill Ø
8x10	5.714	6.164	6
9x10	6.714	7.164	7
10x10	7.714	8.164	8
11x10	8.714	9.164	9
12x10	9.714	10.164	10
14x8	11.142</		