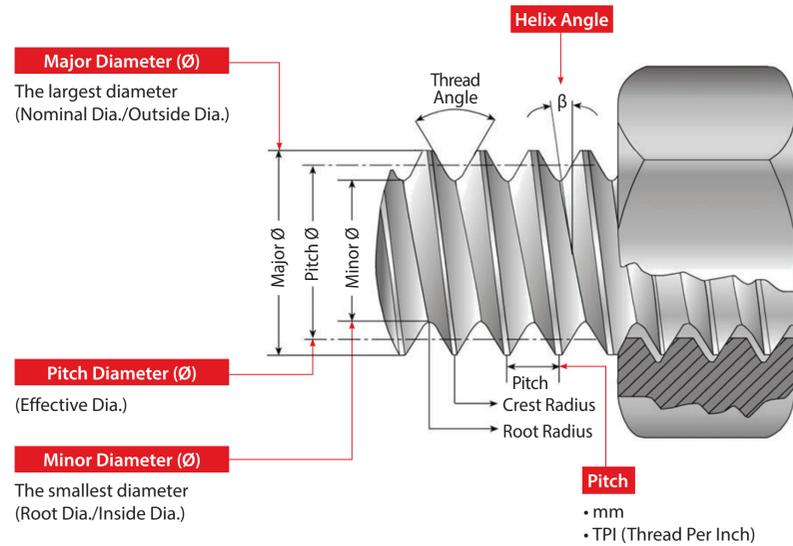


## THREADING STANDARDS



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	26.771	26.5
33x3.5	29.211	29.771	29.5
36x4	31.670	32.270	32
39x4	34.670	35.270	35
42x4.5	37.129	37.799	37.5
45x4.5	40.129	40.799	40.5
48x5	42.587	43.297	43
52x5	46.587	47.297	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

### Pg

DIN 40430  
Class: Standard

Thread	Minor Ø min	Minor Ø max	Drill Ø
Pg7-20	11.280	11.430	11.3
Pg9-18	13.860	14.010	13.9
Pg11-18	17.260	17.410	17.3
Pg13.5-18	19.060	19.210	19.1
Pg16-18	21.160	21.310	21.2
Pg21-16	26.780	27.030	26.9
Pg29-16	35.480	35.730	35.6
Pg36-16	45.480	45.730	45.6
Pg42-16	52.480	52.730	52.6
Pg48-16	57.780	58.030	57.9

### 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
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
¼-16	4.763	4.890	4.8
⅜-12	6.124	6.251	6.2
½-14	7.409	7.536	7.4
⅝-12	8.997	9.124	9
¾-10	10.160	10.287	10.2
⅞-8	12.700	12.857	12.7
1-6	14.816	15.027	14.9
1-5	17.991	18.202	18
1-5	20.320	20.574	20.4
1½-5	23.495	23.749	23.6
1½-5	26.670	26.924	26.7
1¾-4	28.575	28.893	28.7
1½-4	31.750	32.068	31.8
1¾-4	38.100	38.418	38.2
2-4	44.450	44.768	44.6
2¼-3	48.684	49.108	48.8
2½-3	55.034	55.458	55.2
2¾-3	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
⅝-8	13.970	14.130	14
¾-6	16.510	16.721	16.6
⅞-6	19.685	19.896	19.7
1-5	22.352	22.606	22.4
1½-5	25.527	25.781	25.6
1¾-5	28.702	28.956	28.8
1¾-4	31.115	31.433	31.3
1½-4	34.290	34.607	34.4
1¾-4	40.640	40.957	40.8
2-4	46.990	47.307	47.1
2¼-3	52.070	52.494	52.3
2½-3	58.420	58.844	58.6
2¾-3	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	11.672	11.5
16x8	13.142	13.672	13.5
18x8	15.142	15.672	15.5
20x8	17.142	17.672	17.5
22x8	19.142	19.672	19.5
24x8	21.142	21.672	21.5
26x8	23.142	23.672	23.5
28x8	25.142	25.672	25.5
30x8	27.142	27.672	27.5

### MJ ISO 5855 | Class: 4H/5H

Thread	Minor Ø min	Minor Ø max	Drill Ø
3x0.5	2.513	2.653	2.6
4x0.7	3.318	3.498	3.4
5x0.8	4.221	4.421	4.3
6x1	5.026	5.216	5.1
8x1	7.026	7.216	7.1
8x1.25	6.782	6.994	6.9
10x1.25	8.782	8.994	8.9
10x1.5	8.539	8.775	8.6

### UNJC MIL-S-8879C | Class: 3B

Thread	Minor Ø min	Minor Ø max	Drill Ø
No.6-32	2.733	2.939	2.8
No.10-24	3.795	4.064	3.9
¼-20	5.113	5.387	5.2
⅜-18	6.563	6.833	6.7
½-16	7.978	8.255	8.1
⅝-14	9.347	9.639	9.5
¾-12	10.798	11.095	10.9

### UNJF MIL-S-8879C | Class: 3B

Thread	Minor Ø min	Minor Ø max	Drill Ø
No.10-32	4.054	4.255	4.1
¼-28	5.466	5.662	5.5
⅜-24	6.906	7.109	7
½-20	9.875	10.084	10
⅝-18	12.913	13.122	13
¾-16	17.503	17.719	17.6
¾-14	20.46	20.706	20.6

### UNJEF MIL-S-8879C | Class: 3B

Thread	Minor Ø min	Minor Ø max	Drill Ø
No.12-32	4.714	4.9	4.8
⅜-28	10.229	10.378	10.3
½-24	13.256	13.414	13.3
¾-20	17.813	17.986	17.9
¾-18	25.613	25.804	25.7

### BSPT B.S.21:1985

Thread	Drill Ø	Thread Length
⅜-28	5.94	9.9
½-28	7.95	9.9
¾-18	10.7	10.2
½-18	14.2	10.4
½-14	17.5	13.6
¾-14	22.8	13.9
1-11.5	28.6	17.3
1½-11.5	37.3	18
1½-11.5	43.4	18.4
2-11.5	55.4	19.2
2½-8	65.8	28.9
3-8	81.6	30.5

### NPT USAS B2.1:1968

Thread	Drill Ø	Thread Length
⅜-27	5.98	6.63
½-27	8.32	6.7
¾-18	10.7	10.2
½-18	14.2	10.4
½-14	17.5	13.6
¾-14	22.8	13.9
1-11.5	28.6	17.3
1½-11.5	37.3	18
1½-11.5	43.4	18.4
2-11.5	55.4	19.2
2½-8	65.8	28.9