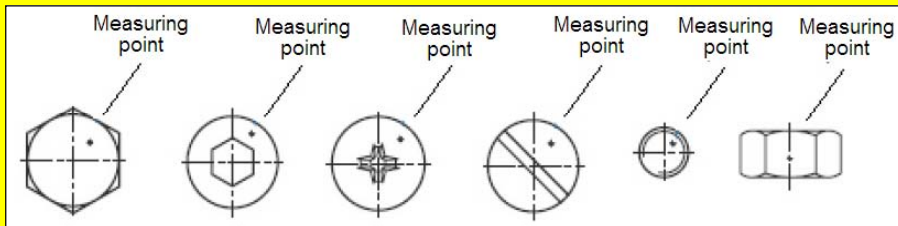


Pitch p		Internal thread		External thread															
		Tol. position G		Tolerance position g						Tolerance position f						Tolerance position e			
		Fundamental deviation	Coating thickness max. µm	Fundamental deviation	Nom. coating thickness max.			Fundamental deviation	Nom. coating thickness max.			Fundamental deviation	Nom. coating thickness max.			Fundamental deviation	Nom. coating thickness max.		
Overall length 2)	Nominal length l ≤ 3)				Overall length 2)	Nominal length l ≤ 3)			Overall length 2)	Nominal length l ≤ 3)									
		µm	µm	µm	µm	5d	10d	15d	µm	µm	µm	µm	µm	µm	µm	µm	µm	µm	µm
0,2	mm	17	3	-17	3	3	3	3											
0,25	1; 1,2	18	3	-18	3	3	3	3											
0,3	1,4	18	3	-18	3	3	3	3											
0,35	1,6 (1,8)	19	3	-19	3	3	3	3	-34	8	8	5	5						
0,4	2	19	3	-19	3	3	3	3	-34	8	8	5	5						
0,45	2,5 (2,2)	20	5	-20	5	5	3	3	-35	8	8	5	5						
0,5	3	20	5	-20	5	5	3	3	-36	8	8	5	5	-50	12	12	10	8	
0,6	3,5	21	5	-21	5	5	3	3	-36	8	8	5	5	-53	12	12	10	8	
0,7	4	22	5	-22	5	5	3	3	-38	8	8	5	5	-56	12	12	10	8	
0,75	4,5	22	5	-22	5	5	3	3	-38	8	8	5	5	-56	12	12	10	8	
0,8	5	24	5	-24	5	5	3	3	-38	8	8	5	5	-60	15	15	12	10	
1	6 (7)	26	5	-26	5	5	3	3	-40	10	10	8	5	-60	15	15	12	10	
1,25	8	28	5	-28	5	5	5	3	-42	10	10	8	5	-63	15	15	12	10	
1,5	10	32	8	-32	8	8	5	5	-45	10	10	8	5	-67	15	15	12	10	
1,75	12	34	8	-34	8	8	5	5	-48	12	12	8	8	-71	15	15	12	10	
2	16 (14)	38	8	-38	8	8	5	5	-52	12	12	10	8	-71	15	15	12	10	
2,5	20 (18; 22)	42	10	-42	10	10	8	5	-58	12	12	10	8	-80	20	20	15	10	
3	24 (27)	48	12	-48	12	12	8	8	-63	15	15	12	10	-85	20	20	15	12	
3,5	30 (33)	53	12	-53	12	12	10	8	-70	15	15	12	10	-90	20	20	15	12	
4	36 (39)	60	15	-60	15	15	12	10	-75	15	15	15	12	-95	20	20	15	15	
4,5	42 (45)	63	15	-63	15	15	12	10	-80	20	20	15	12	-100	25	25	20	15	
5	48 (52)	71	15	-71	15	15	12	10	-85	20	20	15	12	-106	25	25	20	15	
5,5	56 (60)	75	15	-75	15	15	15	12	-90	20	20	15	15	-112	25	25	20	15	
6	64	80	20	-80	20	20	15	12	-95	20	20	15	15	-118	25	25	20	15	

Measuring points for plating



The thread tolerance zone of 6 H allows for very little plating. Experience has shown that 5 µm on the measuring point generally does not impair gauging.

- note: 1) For reference only, the determining characteristic is the thread pitch.
- note: 2) Thickness, if minimum thickness at measuring point is agreed upon. (This is the method normally selected, if nothing else has been agreed upon, at the time of order.)
- note: 3) Thickness, if the average patch thickness has been agreed upon.

If no particular plating thickness is specified, the minimum plating thickness is applied which is also considered the commercial plating thickness. Because of the inconsistent plating thicknesses on thin and long screws (M4 and smaller), screws may not gauge properly.

Possible Alternatives: Use of a chemical nickel plating or stainless steel screws A2 or A4.

Screw threads are mainly produced in the g tolerance zone, prior to plating. Tolerance zone e and f are not common and require minimum production runs and longer lead times. Alternative: Screws made of stainless steel A2.

Use µm (micrometer) for plating thickness, surface roughness and other very small measurements.

Conversion tips: inch / metric:

To get micro inches divide by 0.0254

Example: 4 µm / 0.0254 = 157.480 µin* (rounded 160 µin*)

To get inches divide by 25,400

Example: 4 µm / 25,400 = 0.000118 in (rounded 0.00012 in)

*) µin = micro inch = 0.001 inch 1 µm (micrometer) = 0.000001 meter

Factor 0.0254 applies when 1 micro inch (µin) is listed like this: 1 µin

Example: 120 µin = 120 x 0.0254 = 3.048 micrometers (µm)

Conversions

Factor 25,400 applies when 1 micro inch (µin) is listed like this: .000001 in

Example: .00012 in = .00012 x 25,400 = 3.048 micrometers (µm)