

Thread Size d			M1.4	M1.6	M2	M2.5	M3	M4	M5	M6	M8	M10	M12	(M14)	M16	(M18)	M20	
P	Pitch	Coarse thread	0.30	0.35	0.40	0.45	0.50	0.70	0.80	1.00	1.25	1.50	1.75	2.00	2.00	2.50	2.50	
		Fine thread pitch-1	-	-	-	-	-	-	-	-	-	1.00	1.25	1.25	1.50	1.50	1.50	1.50
		Fine thread pitch-2	-	-	-	-	-	-	-	-	-	-	1.00	1.50	-	-	2.00	2.00
d <sub>k</sub>	plain head	max	2.60	3.00	3.80	4.50	5.50	7.00	8.50	10.00	13.00	16.00	18.00	21.00	24.00	27.00	30.00	
	knurled heads	max	2.74	3.14	3.98	4.68	5.68	7.22	8.72	10.22	13.27	16.27	18.27	21.33	24.33	27.33	30.33	
		min	2.46	2.86	3.62	4.32	5.32	6.78	8.28	9.78	12.73	15.73	17.73	20.67	23.67	26.67	29.67	
d <sub>a</sub>		max	1.80	2.00	2.60	3.10	3.60	4.70	5.70	6.80	9.20	11.20	13.70	15.70	17.70	20.20	22.40	
d <sub>s</sub>		max	1.40	1.60	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	14.00	16.00	18.00	20.00	
		min	1.26	1.46	1.86	2.36	2.86	3.82	4.82	5.82	7.78	9.78	11.73	13.73	15.73	17.73	19.67	
e		min	1.50	1.73	1.73	2.30	2.87	3.44	4.58	5.72	6.86	9.15	11.43	13.72	16.00	16.00	19.44	
k		max	1.40	1.60	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	14.00	16.00	18.00	20.00	
		min	1.26	1.46	1.86	2.36	2.86	3.82	4.82	5.70	7.64	9.64	11.57	13.57	15.57	17.57	19.48	
s		Nominal Size	1.30	1.50	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	14.00	14.00	17.00	
		min	1.320	1.520	1.520	2.020	2.520	3.020	4.020	5.020	6.020	8.025	10.025	12.032	14.032	14.032	17.050	
		max	1.360	1.560	1.560	2.060	2.580	3.080	4.095	5.140	6.140	8.175	10.175	12.212	14.212	14.212	17.230	
t		min	0.60	0.70	1.00	1.10	1.30	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00	
w		min	0.50	0.55	0.55	0.85	1.15	1.40	1.90	2.30	3.00	4.00	4.80	5.80	6.80	7.80	8.60	

①, For size ≤ M4, the point need not be chamfered.

②,  $e_{\min} = 1.14 * S_{\min}$

④, Nominal lengths above 300 mm shall be in 20 mm steps.

⑤,  $L-b \geq 3P$  (P: Coarse thread pitch)

⑥, Material:

a) Steel, Property class: ≤M39: 8.8, 10.9, 12.9 ; > M39: as agreed. Standard DIN ISO 898-1

b) Stainless steel, Property class: ≤M20: A2-70, A4-70 ; > M20≤M39: A2-50, A4-50 ; ≤M39: C3 ; > M39: as agreed. Standard ISO 3506, DIN 267-11

c) Non-ferrous metal by standard DIN 267-18

Thread Size d			(M22)	M24	(M27)	M30	(M33)	M36	M42	M48	M56	M64	M72	M80	M90	M100
P	Pitch	Coarse thread	2.50	3.00	3.00	3.50	3.50	4.00	4.50	5.00	5.50	6.00	6.00	6.00	6.00	6.00
		Fine thread pitch-1	1.50	2.00	2.00	2.00	2.00	3.00	3.00	3.00	4.00	4.00	4.00	4.00	4.00	4.00
		Fine thread pitch-2	2.00	-	-	-	-	-	-	-	-	-	-	-	-	-
d <sub>k</sub>	plain head	max	33.00	36.00	40.00	45.00	50.00	54.00	63.00	72.00	84.00	96.00	108.00	120.00	135.00	150.00
	knurled heads	max	33.39	36.39	40.39	45.39	50.39	54.46	63.46	72.46	84.54	96.54	108.54	120.54	135.63	150.63
		min	32.61	35.61	39.61	44.61	49.61	53.54	62.54	71.54	83.46	95.46	107.46	119.46	134.37	149.37
d <sub>a</sub>		max	24.40	26.40	30.40	33.40	36.40	39.40	45.50	52.60	63.00	71.00	79.00	87.00	97.00	107.00
d <sub>s</sub>		max	22.00	24.00	27.00	30.00	33.00	36.00	42.00	48.00	56.00	64.00	72.00	80.00	90.00	100.00
		min	21.67	23.67	26.67	29.67	32.61	35.61	41.61	47.61	55.54	63.54	71.54	79.54	89.46	99.46
e		min	19.44	21.73	21.73	25.15	27.43	30.85	36.57	41.13	46.83	52.53	62.81	74.21	85.61	97.04
k		max	22.00	24.00	27.00	30.00	33.00	36.00	42.00	48.00	56.00	64.00	72.00	80.00	90.00	100.00
		min	21.48	23.48	26.48	29.48	32.38	35.38	41.38	47.38	55.26	63.26	71.26	79.26	89.13	99.13
s		Nominal Size	17.00	19.00	19.00	22.00	24.00	27.00	32.00	36.00	41.00	46.00	55.00	65.00	75.00	85.00
		min	17.050	19.065	19.065	22.065	24.065	27.065	32.080	36.080	41.080	46.080	55.100	65.100	75.100	85.120
		max	17.230	19.275	19.275	22.275	24.275	27.275	32.330	36.330	41.330	46.330	55.400	65.400	75.400	85.470
t		min	11.00	12.00	13.50	15.50	18.00	19.00	24.00	28.00	34.00	38.00	43.00	48.00	54.00	60.00
w		min	9.40	10.40	11.90	13.10	13.50	15.30	16.30	17.50	19.00	22.00	25.00	27.00	32.00	34.00

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