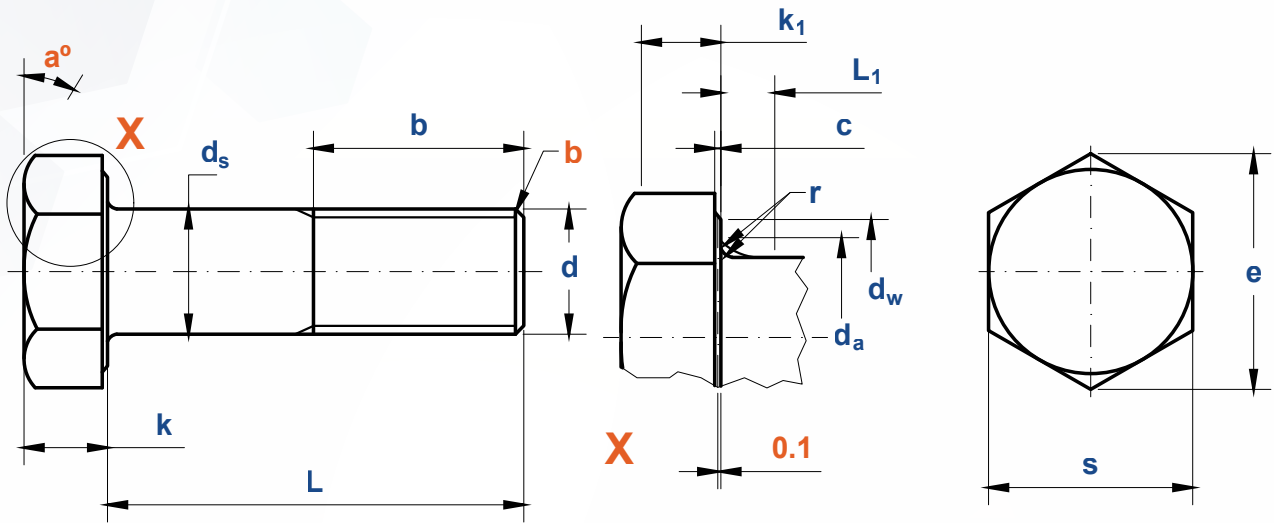
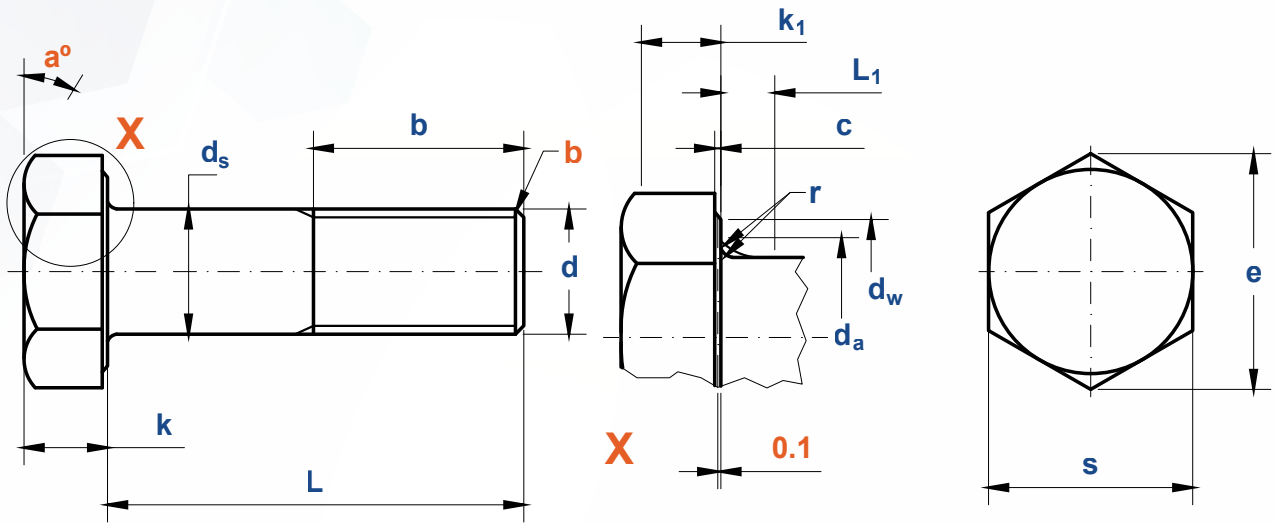




a. $a^\circ = 15^\circ \sim 30^\circ$

b. Point shall be chamfered or for threads $\leq M4$ may be as-rolled

Thread Size d		M1.6	M2	M2.5	M3	(M3.5)	M4	M5	M6	(M7)	M8	M10	M12	(M14)	M16	(M18)	
P	Pitch	0.35	0.4	0.45	0.5	0.6	0.7	0.8	1	1	1.25	1.5	1.75	2	2	2.5	
b	L≤125	9	10	11	12	13	14	16	18	20	22	26	30	34	38	42	
	125<L≤200	15	16	17	18	19	20	22	24	26	28	32	36	40	44	48	
	L>200	28	29	30	31	32	33	35	37	39	41	45	49	53	/	/	
c	max	0.25	0.25	0.25	0.4	0.4	0.4	0.5	0.5	0.6	0.6	0.6	0.6	0.6	0.8	0.8	
	min	0.1	0.1	0.1	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.2	0.2	
d _a	max	2	2.6	3.1	3.6	4.1	4.7	5.7	6.8	7.8	9.2	11.2	13.7	15.7	17.7	20.2	
d _s	max=nominal size		1.6	2	2.5	3	3.5	4	5	6	7	8	10	12	14	16	18
	Grade A	min	1.46	1.86	2.36	2.86	3.32	3.82	4.82	5.82	6.78	7.78	9.78	11.73	13.73	15.73	17.73
	Grade B	min	1.35	1.75	2.25	2.75	3.2	3.7	4.7	5.7	6.64	7.64	9.64	11.57	13.57	15.57	17.57
d _w	Grade A	min	2.54	3.34	4.34	4.84	5.34	6.2	7.2	8.88	9.63	11.63	14.63	16.63	19.64	22.49	25.34
	Grade B	min	2.42	3.22	4.22	4.72	5.22	6.06	7.06	8.74	9.47	11.47	14.47	16.47	19.15	22	24.85
e	Grade A	min	3.41	4.32	5.45	6.01	6.58	7.66	8.79	11.05	12.12	14.38	17.77	20.03	23.36	26.75	30.14
	Grade B	min	3.28	4.18	5.31	5.88	6.44	7.5	8.63	10.89	11.94	14.2	17.59	19.85	22.78	26.17	29.56
L ₁	max	0.6	0.8	1	1	1	1.2	1.2	1.4	1.4	2	2	3	3	3	3	
k	Nominal Size		1.1	1.4	1.7	2	2.4	2.8	3.5	4	4.8	5.3	6.4	7.5	8.8	10	11.5
	Grade A	max	1.225	1.525	1.825	2.125	2.525	2.925	3.65	4.15	4.95	5.45	6.58	7.68	8.98	10.18	11.715
		min	0.975	1.275	1.575	1.875	2.275	2.675	3.35	3.85	4.65	5.15	6.22	7.32	8.62	9.82	11.285
	Grade B	max	1.3	1.6	1.9	2.2	2.6	3	3.74	4.24	5.04	5.54	6.69	7.79	9.09	10.29	11.85
		min	0.9	1.2	1.5	1.8	2.2	2.6	3.26	3.76	4.56	5.06	6.11	7.21	8.51	9.71	11.15
k ₁	Grade A	min	0.68	0.89	1.1	1.31	1.59	1.87	2.35	2.7	3.26	3.61	4.35	5.12	6.03	6.87	7.9
	Grade B	min	0.63	0.84	1.05	1.26	1.54	1.82	2.28	2.63	3.19	3.54	4.28	5.05	5.96	6.8	7.81
r	min	0.1	0.1	0.1	0.1	0.1	0.2	0.2	0.25	0.25	0.4	0.4	0.6	0.6	0.6	0.6	
s	max=nominal size		3.2	4	5	5.5	6	7	8	10	11	13	16	18	21	24	27
	Grade A	min	3.02	3.82	4.82	5.32	5.82	6.78	7.78	9.78	10.73	12.73	15.73	17.73	20.67	23.67	26.67
	Grade B	min	2.9	3.7	4.7	5.2	5.7	6.64	7.64	9.64	10.57	12.57	15.57	17.57	20.16	23.16	26.16



a. $a^\circ = 15^\circ \sim 30^\circ$

b. Point shall be chamfered or for threads $\leq M4$ may be as-rolled

Thread Size d		M20	(M22)	M24	(M27)	M30	(M33)	M36	(M39)	M42	(M45)	M48	(M52)	M56	(M60)	M64	
P	Pitch	2.5	2.5	3	3	3.5	3.5	4	4	4.5	4.5	5	5	5.5	5.5	6	
b	L≤125	46	50	54	60	66	72	/	/	/	/	/	/	/	/	/	
	125<L≤200	52	56	60	66	72	78	84	90	96	102	108	116	/	/	/	
	L>200	/	69	73	79	85	91	97	103	109	115	121	129	137	145	153	
c	max	0.8	0.8	0.8	0.8	0.8	0.8	0.8	1	1	1	1	1	1	1	1	
	min	0.2	0.2	0.2	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	
d _a	max	22.4	24.4	26.4	30.4	33.4	36.4	39.4	42.4	45.6	48.6	52.6	56.6	63	67	71	
d _s	max=nominal size		20	22	24	27	30	33	36	39	42	45	48	52	56	60	64
	Grade A	min	19.67	21.67	23.67	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	min	19.48	21.48	23.48	26.48	29.48	32.38	35.38	38.38	41.38	44.38	47.38	51.26	55.26	59.26	63.26
d _w	Grade A	min	28.19	31.71	33.61	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	min	27.7	31.35	33.25	38	42.75	46.55	51.11	55.86	59.95	64.7	69.45	74.2	78.66	83.41	88.16
e	Grade A	min	33.53	37.72	39.98	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	min	32.95	37.29	39.55	45.2	50.85	55.37	60.79	66.44	71.3	76.95	82.6	88.25	93.56	99.21	104.86
L ₁	max	4	4	4	6	6	6	6	6	8	8	10	10	12	12	13	
k	Nominal Size		12.5	14	15	17	18.7	21	22.5	25	26	28	30	33	35	38	40
	Grade A	max	12.715	14.215	15.215	/	/	/	/	/	/	/	/	/	/	/	/
		min	12.285	13.785	14.785	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	max	12.85	14.35	15.35	17.35	19.12	21.42	22.92	25.42	26.42	28.42	30.42	33.5	35.5	38.5	40.5
		min	12.15	13.65	14.65	16.65	18.28	20.58	22.08	24.58	25.58	27.58	29.58	32.5	34.5	37.5	39.5
k ₁	Grade A	min	8.6	9.65	10.35	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	min	8.51	9.56	10.26	11.66	12.8	14.41	15.46	17.21	17.91	19.31	20.71	22.75	24.15	26.25	27.65
r	min	0.8	0.8	0.8	1	1	1	1	1	1.2	1.2	1.6	1.6	2	2	2	2
s	max=nominal size		30	34	36	41	46	50	55	60	65	70	75	80	85	90	95
	Grade A	min	29.67	33.38	35.38	/	/	/	/	/	/	/	/	/	/	/	/
	Grade B	min	29.16	33	35	40	45	49	53.8	58.8	63.1	68.1	73.1	78.1	82.8	87.8	92.8