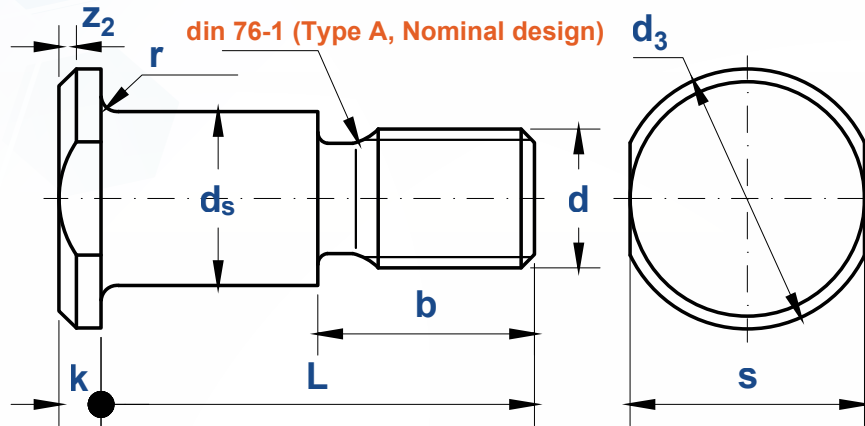




Size		8	10	12	14	16	18	20	22	24	27	30
ds	max	8	10	12	14	16	18	20	22	24	27	30
	min	7.91	9.91	11.89	13.89	15.89	17.89	19.87	21.87	23.87	26.87	29.87
b	min	11	14	17	20	20	20	25	25	29	29	36
d		M6	M8	M10	M12	M12	M12	M16	M16	M20	M20	M24
P	Pitch	1	1.25	1.5	1.75	1.75	1.75	2	2	2.5	2.5	3
d3	max=nominal size (h14)	14	18	20	22	25	28	30	33	36	40	44
	min	13.57	17.57	19.48	21.48	24.48	27.48	29.48	32.38	35.38	39.38	43.38
k	Nominal Size (js14)	3	4	4	4	4.5	5	5	5.5	6	6	8
	max	3.125	4.15	4.15	4.15	4.65	5.15	5.15	5.65	6.15	6.15	8.18
	min	2.875	3.85	3.85	3.85	4.35	4.85	4.85	5.35	5.85	5.85	7.82
r		0.6	0.6	0.6	0.6	0.6	1.0	1.0	1.0	1.0	1.0	1.0
s	max	11	13	17	19	22	24	27	30	32	36	36
	min	10.73	12.73	16.73	18.67	21.67	23.67	26.67	29.67	31.38	35.38	35.38
Z2	≈	1.0	1.0	1.6	1.6	1.6	1.6	2.0	2.0	2.0	2.0	2.0

Size		33	36	40	45	50	55	60	70	80	90	100
ds	max	33	36	40	45	50	55	60	70	80	90	100
	min	32.84	35.84	39.84	44.84	49.84	54.81	59.81	69.81	79.81	89.78	99.78
b	min	36	39	42	45	49	52	58	61	68	78	84
d		M24	M27	M30	M33	M36	M39	M42	M45	M52	M56	M64
P	Pitch	3	3	3.5	3.5	4	4	4.5	4.5	5	5.5	6
d3	max=nominal size (h14)	47	50	55	60	66	72	78	90	100	110	120
	min	46.38	49.38	54.26	59.26	65.26	71.26	77.26	89.13	99.13	109.13	119.13
k	Nominal Size (js14)	8	8	8	9	9	11	12	13	13	13	13
	max	8.18	8.18	8.18	9.18	9.18	11.215	12.215	13.215	13.215	13.215	13.215
	min	7.82	7.82	7.82	8.82	8.82	10.785	11.785	12.785	12.785	12.785	12.785
r		1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0
s	max	41	46	50	55	60	65	70	80	90	100	110
	min	40.38	45.38	49.38	54.26	59.26	64.26	69.26	79.26	89.13	99.13	109.13
Z2	≈	2.0	2.0	2.0	2.0	2.0	3.0	3.0	3.0	3.0	3.0	3.0

① Material: Free-cutting steel (St), hardness 125HV to 245HV ; other materials by agreement