

MARYLAND METRICS
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TECHNICAL INFORMATION and DATA

Coating thickness for parts with external threads

| Pitch | Nominal thread diameter ¹⁾ | General purpose tolerance for screw threads | | | | | | Special purpose tolerance for screw threads | | | | | | | | | Tolerance for hot dip galvanizing | |
|--------|---------------------------------------|---|--------------------------------------|-------------------------|----|--------|-----|---|--------------------------------------|-------------------------|---------------------------|-------------------------|-----------------------|--------------------------------------|-----------------------------|---------------------|--------------------------------------|----|
| | | Tolerance deviation g | | | | | | Tolerance deviation f | | | | | | Tolerance deviation e | | | Tolerance deviation ax | |
| | | Fundamental deviation | Coating thickness max. in the thread | | | | | Fundamental deviation | Coating thickness max. in the thread | | | | Fundamental deviation | Coating thickness max. in the thread | | | Coating thickness max. in the thread | |
| | | | 2) All nominal lengths | 3) Nominal length, l | | | | | 2) All Nominal lengths | 3) Nominal length, l | 2) All nominal lengths | 3) Nominal length, l | | | Fundamental deviation Ao | All nominal lengths | | |
| l ≤ 5d | | 5d < l ≤ 10d | | 10d < l ≤ 15d | | l ≤ 5d | | 5d < l ≤ 10d | | | | 10d < l ≤ 15d | | | | | | |
| mm | M | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm | μm |
| 0,25 | 1; 1,2 | -18 | 3 | 3 | 3 | 3 | | | | | | | | | | | | |
| 0,3 | 1,4 | -18 | 3 | 3 | 3 | 3 | | | | | | | | | | | | |
| 0,35 | 1,6 (1,8) | -19 | 3 | 3 | 3 | 3 | -34 | 8 | 8 | 5 | 5 | | | | | | | |
| 0,4 | 2 | -19 | 3 | 3 | 3 | 3 | -34 | 8 | 8 | 5 | 5 | | | | | | | |
| 0,45 | 2,5 (2,2) | -20 | 5 | 5 | 3 | 3 | -35 | 8 | 8 | 5 | 5 | | | | | | | |
| 0,5 | 3 | -20 | 5 | 5 | 3 | 3 | -36 | 8 | 8 | 5 | 5 | -50 | 12 | 12 | 10 | 8 | | |
| 0,6 | 3,5 | -21 | 5 | 5 | 3 | 3 | -36 | 8 | 8 | 5 | 5 | -53 | 12 | 12 | 10 | 8 | | |
| 0,7 | 4 | -22 | 5 | 5 | 3 | 3 | -38 | 8 | 8 | 5 | 5 | -56 | 12 | 12 | 10 | 8 | | |
| 0,75 | 4,5 | -22 | 5 | 5 | 3 | 3 | -38 | 8 | 8 | 5 | 5 | -56 | 12 | 12 | 10 | 8 | | |
| 0,8 | 5 | -24 | 5 | 5 | 3 | 3 | -38 | 8 | 8 | 5 | 5 | -60 | 15 | 15 | 12 | 10 | | |
| 1 | 6 (7) | -26 | 5 | 5 | 3 | 3 | -40 | 10 | 10 | 8 | 5 | -60 | 15 | 15 | 12 | 10 | -290 | 70 |
| 1,25 | 8 | -20 | 5 | 5 | 5 | 3 | -42 | 10 | 10 | 8 | 5 | -63 | 15 | 15 | 12 | 10 | -295 | 70 |
| 1,5 | 10 | -32 | 8 | 8 | 5 | 5 | -45 | 10 | 10 | 8 | 5 | -67 | 15 | 15 | 12 | 10 | -300 | 75 |
| 1,75 | 12 | -34 | 8 | 8 | 5 | 5 | -48 | 12 | 12 | 8 | 8 | -71 | 15 | 15 | 12 | 10 | -310 | 75 |
| 2 | 16 (14) | -38 | 8 | 8 | 5 | 5 | -52 | 12 | 12 | 10 | 8 | -71 | 15 | 15 | 12 | 10 | -315 | 75 |
| 2,5 | 20 (18; 22) | -42 | 10 | 10 | 8 | 5 | -58 | 12 | 12 | 10 | 8 | -80 | 20 | 20 | 15 | 12 | -315 | 80 |
| 3 | 24 (27) | -48 | 12 | 12 | 8 | 8 | -63 | 15 | 15 | 12 | 10 | -85 | 20 | 20 | 15 | 12 | -335 | 80 |
| 3,5 | 30 (33) | -53 | 12 | 12 | 10 | 8 | -70 | 15 | 15 | 12 | 10 | -90 | 20 | 20 | 15 | 15 | -345 | 85 |
| 4 | 36 (39) | -60 | 15 | 15 | 12 | 10 | -75 | 15 | 15 | 15 | 12 | -95 | 20 | 20 | 15 | 15 | -355 | 85 |
| 4,5 | 42 (45) | -63 | 15 | 15 | 12 | 10 | -80 | 20 | 20 | 15 | 12 | -100 | 25 | 25 | 20 | 15 | | |
| 5 | 48 (52) | -71 | 15 | 15 | 12 | 10 | -85 | 20 | 20 | 15 | 12 | -106 | 25 | 25 | 20 | 15 | | |
| 5,5 | 56 (60) | -75 | 15 | 15 | 15 | 12 | -90 | 20 | 20 | 15 | 15 | -112 | 25 | 25 | 20 | 15 | | |
| 6 | 64 | -80 | 20 | 20 | 15 | 12 | -95 | 20 | 20 | 15 | 15 | -118 | 25 | 25 | 20 | 15 | | |

¹⁾Information for coarse pitch threads is given for convenience only. The determining characteristic is the thread pitch.

²⁾Maximum values of nominal coating thickness if local thickness measurement is agreed.

³⁾Maximum values of nominal coating thickness if batch average thickness measurement is agreed.