

Tapping hole size dias for thread cutting tools

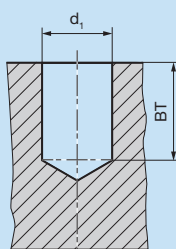
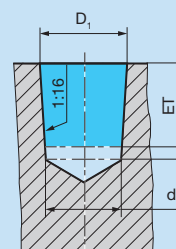
Std. ISO metric threads DIN 13					Std. ISO metric fine threads DIN 13					UNC threads ASME B1.1				
nom.- Ø	pitch P	tapping hole size Ø DIN 336 mm	core diameter of int. thread 6H*		nom.-x Ø	pitch P	tapping hole size Ø DIN 336 mm	core diameter of int. thread 6H*		nom.- Ø	threads	tapping hole size Ø DIN 336 mm	core diameter of int. thread 2B	
	mm		min. mm	max. mm		mm		min. mm	max. mm		per inch		min. mm	max. mm
M 1	0.25	0.75	0.729	0.785	M 2.5 x 0.35		2.15	2.121	2.221	M 22 x 1.50		20.50	20.376	20.676
M 1.1	0.25	0.85	0.829	0.885	M 3.0 x 0.35		2.65	2.621	2.721	M 22 x 2.00		20.00	19.835	20.210
M 1.2	0.25	0.95	0.929	0.985	M 3.5 x 0.35		3.15	3.121	3.221	M 24 x 1.00		23.00	22.917	23.153
M 1.4	0.30	1.10	1.075	1.142	M 4.0 x 0.50		3.50	3.459	3.599	M 24 x 1.50		22.50	22.376	22.676
M 1.6	0.35	1.25	1.221	1.321	M 4.5 x 0.50		4.00	3.959	4.099	M 24 x 2.00		22.00	21.835	22.210
M 1.8	0.35	1.45	1.421	1.521	M 5.0 x 0.50		4.50	4.459	4.599	M 25 x 1.00		24.00	23.917	24.153
M 2	0.40	1.60	1.567	1.679	M 5.5 x 0.50		5.00	4.959	5.099	M 25 x 1.50		23.50	23.376	23.676
M 2.2	0.45	1.75	1.713	1.838	M 6.0 x 0.75		5.20	5.188	5.378	M 25 x 2.00		23.00	22.835	23.210
M 2.5	0.45	2.05	2.013	2.138	M 7.0 x 0.75		6.20	6.188	6.378	M 27 x 1.00		26.00	25.917	26.153
M 3	0.50	2.50	2.459	2.599	M 8.0 x 0.50		7.50	7.459	7.599	M 27 x 1.50		25.50	25.376	25.676
M 3.5	0.60	2.90	2.850	3.010	M 8.0 x 0.75		7.20	7.188	7.378	M 27 x 2.00		25.00	24.835	25.210
M 4	0.70	3.30	3.242	3.422	M 8.0 x 1.00		7.00	6.917	7.153	M 28 x 1.00		27.00	26.917	27.153
M 4.5	0.75	3.70	3.688	3.878	M 9.0 x 0.75		8.20	8.188	8.378	M 28 x 1.50		26.50	26.376	26.676
M 5	0.80	4.20	4.134	4.334	M 9.0 x 1.00		8.00	7.917	8.153	M 28 x 2.00		26.00	25.835	26.210
M 6	1.00	5.00	4.917	5.153	M 10 x 0.75		9.20	9.188	9.378	M 30 x 1.00		29.00	28.917	29.153
M 7	1.00	6.00	5.917	6.153	M 10 x 1.00		9.00	8.917	9.153	M 30 x 1.50		28.50	28.376	28.676
M 8	1.25	6.80	6.647	6.912	M 10 x 1.25		8.80	8.647	8.912	M 30 x 2.00		28.00	27.835	28.210
M 9	1.25	7.80	7.647	7.912	M 11 x 0.75		10.20	10.188	10.378	M 30 x 3.00		27.00	26.752	27.252
M 10	1.50	8.50	8.376	8.676	M 11 x 1.00		10.00	9.917	10.153	M 32 x 1.50		30.50	30.376	30.676
M 11	1.50	9.50	9.376	9.676	M 12 x 1.00		11.00	10.917	11.153	M 32 x 2.00		30.00	29.835	30.210
M 12	1.75	10.20	10.106	10.441	M 12 x 1.25		10.80	10.647	10.912	M 33 x 1.50		31.50	31.376	31.676
M 14	2.00	12.00	11.835	12.210	M 12 x 1.50		10.50	10.376	10.676	M 33 x 2.00		31.00	30.835	31.210
M 16	2.00	14.00	13.835	14.210	M 14 x 1.00		13.00	12.917	13.153	M 33 x 3.00		30.00	29.752	30.252
M 18	2.50	15.50	15.294	15.744	M 14 x 1.25		12.80	12.647	12.912	M 35 x 1.50		33.50	33.376	33.676
M 20	2.50	17.50	17.294	17.744	M 14 x 1.50		12.50	12.376	12.676	M 36 x 1.50		34.50	34.376	34.676
M 22	2.50	19.50	19.294	19.744	M 15 x 1.00		14.00	13.917	14.153					
M 24	3.00	21.00	20.752	21.252	M 15 x 1.50		13.50	13.376	13.676					
M 27	3.00	24.00	23.752	24.252	M 16 x 1.00		15.00	14.917	15.153					
M 30	3.50	26.50	26.211	26.771	M 16 x 1.25		14.80	14.647	14.912					
M 33	3.50	29.50	29.211	29.771	M 16 x 1.50		14.50	14.376	14.676					
M 36	4.00	32.00	31.670	32.270	M 17 x 1.00		16.00	15.917	16.153					
M 39	4.00	35.00	34.670	35.270	M 17 x 1.50		15.50	15.376	15.676					
M 42	4.50	37.50	37.129	37.799	M 18 x 1.00		17.00	16.917	17.153					
M 45	4.50	40.50	40.129	40.799	M 18 x 1.50		16.50	16.376	16.676					
M 48	5.00	43.00	42.587	43.297	M 20 x 1.00		19.00	18.917	19.153					
M 52	5.00	47.00	46.587	47.297	M 20 x 1.50		18.50	18.376	18.676					
M 56	5.50	50.50	50.046	50.796	M 20 x 2.00		18.00	17.835	18.210					
					M 22 x 1.00		21.00	20.917	21.153					

* M 1,1 TO M 1,4 core diameter of int. thread 5H

MJ-threads DIN ISO 5855					UNJC-threads ISO 3161					UNJF-threads ISO 3161				
nom.- Ø	x pitch P	tapping hole size Ø	core diameter of int. thread 5H*		nom.- Ø	threads	tapping hole size Ø	core diameter of int. thread 3B		nom.- Ø	threads	tapping hole size Ø	core diameter of int. thread 3B	
	mm	mm	min. mm	max. mm		per inch	mm	min. mm	max. mm		per inch	mm	min. mm	max. mm
MJ 3	x 0.50	2.60	2.513	2.653	Nr. 6	- 32	2.85	2.733	2.939	Nr. 6	- 40	3.00	2.888	3.053
MJ 4	x 0.70	3.40	3.318	3.498	Nr. 8	- 32	3.55	3.393	3.599	Nr. 8	- 36	3.60	3.480	3.663
MJ 5	x 0.80	4.30	4.221	4.421	Nr. 10	- 24	4.00	3.795	4.064	Nr. 10	- 32	4.20	4.054	4.255
MJ 6	x 0.50	5.55	5.513	5.625	Nr. 12	- 24	4.60	4.455	4.704	Nr. 12	- 28	4.75	4.602	4.816
MJ 6	x 0.75	5.35	5.269	5.419	1/4	- 20	5.30	5.113	5.387	1/4	- 28	5.60	5.466	5.662
MJ 6	x 1.00	5.10	5.026	5.216	5/16	- 18	6.75	6.563	6.833	5/16	- 24	7.00	6.906	7.109
MJ 8	x 0.50	7.55	7.513	7.625	3/8	- 16	8.20	7.978	8.255	3/8	- 24	8.60	8.494	8.679
MJ 8	x 0.75	7.35	7.269	7.419	7/16	- 14	9.60	9.346	9.639	7/16	- 20	10.00	9.876	10.084
MJ 8	x 1.00	7.10	7.026	7.216	1/2	- 13	11.00	10.798	11.095	1/2	- 20	11.60	11.463	11.661
MJ 8	x 1.25	6.90	6.782	6.994	9/16	- 12	12.40	12.228	12.482	9/16	- 18	13.00	12.913	13.122
MJ 10	x 1.00	9.10	9.026	9.216	5/8	- 11	13.80	13.627	13.904	5/8	- 18	14.60	14.501	14.702
MJ 10	x 1.25	8.90	8.782	8.994										
MJ 10	x 1.50	8.60	8.539	8.775										
MJ 12	x 1.75	10.40	10.295	10.560										
MJ 16	x 2.00	14.20	14.051	14.351										

Tapping hole size dias for thread cutting tools

UNF-threads ASME B1.1				BSW-(Whitworth)- thread BS84				(Whitworth-) BSP threads (to DIN-ISO 228-1)				Steel armoured conduit threads to DIN 40430							
nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread 2B		nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread		nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread		nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread	
		DIN 336 mm	min. mm	max. mm			min. mm	max. mm	min. mm			max. mm	min. mm	max. mm			min. mm	max. mm	min. mm
Nr. 1 - 72		1.55	1.473	1.610	W 1/16	60	1.20	1.045	1.230	G 1/16	28	6.80	6.561	6.843	Pg 7	20	11.40	11.280	11.430
Nr. 2 - 64		1.85	1.755	1.910	W 3/32	48	1.80	1.704	1.912	G 1/8	28	8.80	8.566	8.848	Pg 9	18	14.00	13.860	14.010
Nr. 3 - 56		2.15	2.024	2.197	W 1/8	40	2.50	2.362	2.591	G 1/4	19	11.80	11.445	11.890	Pg 11	18	17.30	17.260	17.410
Nr. 4 - 48		2.40	2.271	2.459	W 5/32	32	3.20	2.952	3.214	G 3/8	19	15.25	14.950	15.395	Pg 13.5	18	19.00	19.060	19.210
Nr. 5 - 44		2.70	2.550	2.741	W 3/16	24	3.60	3.407	3.745	G 1/2	14	19.00	18.631	19.172	Pg 16	18	21.30	21.160	21.310
Nr. 6 - 40		2.95	2.819	3.023	W 7/32	24	4.50	4.201	4.539	G 5/8	14	21.00	20.587	21.128	Pg 21	16	26.90	26.780	27.030
Nr. 8 - 36		3.50	3.404	3.607	W 1/4	20	5.10	4.724	5.156	G 3/4	14	24.50	24.117	24.658	Pg 29	16	35.50	35.480	35.730
Nr. 10 - 32		4.10	3.962	4.166	W 5/16	18	6.50	6.130	6.590	G 7/8	14	28.25	27.877	28.418	Pg 36	16	45.50	45.480	45.730
Nr. 12 - 28		4.60	4.496	4.724	W 3/8	16	7.90	7.492	7.987	G 1	11	30.75	30.291	30.931	Pg 42	16	52.50	52.480	52.730
1/4 - 28		5.50	5.359	5.588	W 7/16	14	9.20	8.789	9.330	G 1 1/8	11	35.50	34.939	35.579	Pg 48	16	57.80	57.780	58.030
5/16 - 24		6.90	6.782	7.036	W 1/2	12	10.50	9.989	10.591	G 1 1/4	11	39.50	38.952	39.592					
3/8 - 24		8.50	8.382	8.636	W 9/16	12	12.00	11.577	12.179	G 1 1/2	11	45.25	44.845	45.485					
7/16 - 20		9.90	9.728	10.033	W 5/8	11	13.50	12.918	13.558	G 1 3/4	11	51.00	50.788	51.428					
1/2 - 20		11.50	11.328	11.608	W 3/4	10	16.25	15.797	16.483	G 2	11	57.00	56.656	57.296					
9/16 - 18		12.90	12.751	13.081	W 7/8	9	19.25	18.611	19.353										
5/8 - 18		14.50	14.351	14.681	W 1	8	22.00	21.334	22.147										
3/4 - 16		17.50	17.323	17.678	W 1 1/8	7	24.50	23.928	24.832										
7/8 - 14		20.40	20.269	20.650	W 1 1/4	7	27.75	27.103	28.007										
1 - 12		23.25	23.114	23.571	W 1 3/8	6	30.50	29.504	30.528										
1 1/8 - 12		26.50	26.289	26.746	W 1 1/2	6	33.50	32.679	33.703										
1 1/4 - 12		29.50	29.464	29.921	W 1 5/8	5	35.50	34.769	35.963										
1 3/8 - 12		32.75	32.639	33.096	W 1 3/4	5	39.00	37.944	39.138										
1 1/2 - 12		36.00	35.814	36.271	W 2	4.5	44.50	43.571	44.877										

NPT ANSI B 2.1 American tapered pipe thread 1:16								
Version A (to avoid if possible)		Version B	nom.- Ø	threads per inch	tapp. hole Ø cyl. (A) d ₁	core diameter conical (B) D ₁	cutting depth ET mm	drill depth BT (min) mm
			1/16	- 27	6.15	6.39	9.29	10.7
			1/8	- 27	8.40	8.74	9.32	10.8
			1/4	- 18	11.10	11.36	13.52	15.6
			3/8	- 18	14.30	14.80	13.83	16.0
			1/2	- 14	17.90	18.32	18.07	20.8
			3/4	- 14	23.30	23.67	18.55	21.3
			1	- 11.5	29.00	29.69	22.29	25.6
			1 1/4	- 11.5	37.70	38.45	22.80	26.1
			1 1/2	- 11.5	43.70	44.52	22.80	26.1
			2	- 11.5	55.60	56.56	23.20	26.5
			2 1/2	- 8	66.30	67.62	31.75	36.3
			3	- 8	82.30	83.52	33.74	38.5

EG-threads Metr./Metr. fine (EG M 14 x 1,25) for wire thread inserts DIN 8140				
nom.- Ø	x pitch P	tapping hole size Ø	core diameter of int. thread	
	mm	mm	min. mm	max. mm
EG M 4	0.70	4.20	4.152	4.292
EG M 5	0.80	5.25	5.174	5.334
EG M 6	1.00	6.30	6.217	6.407
EG M 8	1.25	8.40	8.271	8.483
EG M10	1.50	10.50	10.324	10.560
EG M12	1.75	12.50	12.379	12.644
EG M14 x 1.25		14.40	14.271	14.483
EG M16	2.00	16.50	16.433	16.733

EG UNC (UNC-STI) threads for wire thread inserts ASME B18.29.1				
nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread	
		mm	min. mm	max. mm
EG Nr. 6	- 32	3.80	3.678	3.879
EG Nr. 8	- 32	4.40	4.338	4.524
EG Nr. 10	- 24	5.20	5.055	5.283
EG Nr. 12	- 24	5.80	5.715	5.944
EG 1/4	- 20	6.70	6.624	6.868
EG 5/16	- 18	8.40	8.242	8.489
EG 3/8	- 16	10.00	9.868	10.127
EG 7/16	- 14	11.60	11.506	11.783
EG 1/2	- 13	13.30	13.122	13.393
EG 9/16	- 12	14.90	14.747	15.032
EG 5/8	- 11	16.50	16.375	16.673

EG UNF (UNF-STI) threads for wire thread inserts ASME B18.29.1				
nom.- Ø	threads per inch	tapping hole size Ø	core diameter of int. thread	
		mm	min. mm	max. mm
EG Nr. 6	- 40	3.70	3.644	3.818
EG Nr. 8	- 36	4.40	4.321	4.498
EG Nr. 10	- 32	5.10	4.999	5.184
EG Nr. 12	- 28	5.70	5.682	5.809
EG 1/4	- 28	6.60	6.546	6.721
EG 5/16	- 24	8.25	8.166	8.352
EG 3/8	- 24	9.80	9.754	9.931
EG 7/16	- 20	11.50	11.389	11.585
EG 1/2	- 20	13.10	12.974	13.172
EG 9/16	- 18	14.70	14.592	14.798
EG 5/8	- 18	16.25	16.180	16.386

Recommended hole size dias for cold forming taps

Std. ISO metric threads DIN 13						Std. ISO metric fine threads DIN 13														
nom.- Ø	pitch P	tapp. hole size Ø	tapping hole size Ø		core-Ø of int. thread 7H*		nom.-x Ø	pitch P	tapp. hole size Ø	tapping hole size Ø		core-Ø of int. thread 7H*		nom.-x Ø	pitch P	tapp. hole size Ø	tapping hole size Ø		core-Ø of int. thread 7H*	
			min. mm	max. mm	min. mm	max. mm				min. mm	max. mm	min. mm	max. mm				min. mm	max. mm	min. mm	max. mm
M 1	0.25	0.75	0.729	0.785			M 2.5 x 0.35	2.35	2.35	2.38	2.121	2.221	M 20 x 1.50	19.30	19.26	19.38	18.376	19.751		
M 1.1	0.25	0.85	0.829	0.885			M 3 x 0.35	2.85	2.85	2.88	2.621	2.721	M 24 x 1.00	23.55	23.52	23.62	22.917	23.217		
M 1.2	0.25	0.95	0.929	0.985			M 4 x 0.35	3.85	3.85	3.88	3.621	3.721	M 24 x 1.50	23.30	23.26	23.38	22.376	22.751		
M 1.4	0.30	1.10	1.075	1.142			M 4 x 0.50	3.80	3.78	3.83	3.459	3.639	M 24 x 2.00	23.10	23.05	23.20	21.835	22.310		
M 1.6	0.35	1.25	1.221	1.321			M 5 x 0.50	4.80	4.78	4.83	4.459	4.639	M 27 x 1.50	26.30	26.26	26.38	25.376	25.751		
M 1.8	0.35	1.45	1.421	1.521			M 5.5 x 0.50	5.30	5.28	5.33	4.959	5.139	M 30 x 1.50	29.30	29.26	29.38	28.376	28.751		
M 2	0.40	1.85	1.84	1.88	1.567	1.679	M 6 x 0.75	5.65	5.62	5.70	5.188	5.424	M 33 x 1.50	32.30	32.26	32.38	31.376	31.751		
M 2.2	0.45	2.00	2.01	2.05	1.713	1.838	M 7 x 0.75	6.65	6.62	6.70	6.188	6.424	M 36 x 1.50	35.30	35.26	35.38	34.376	34.751		
M 2.5	0.45	2.30	2.28	2.32	2.013	2.138	M 8 x 0.75	7.65	7.62	7.70	7.188	7.424	M 39 x 1.50	38.30	38.26	38.38	37.376	37.751		
M 3	0.50	2.80	2.78	2.85	2.459	2.639	M 8 x 1.00	7.55	7.52	7.62	6.917	7.217	M 42 x 1.50	41.30	41.26	41.38	42.376	42.751		
M 3.5	0.60	3.25	3.23	3.30	2.850	3.050	M 9 x 0.75	8.65	8.62	8.70	8.188	8.424								
M 4	0.70	3.70	3.68	3.76	3.242	3.466	M 9 x 1.00	8.55	8.52	8.62	7.917	8.217								
M 4.5	0.75	4.20					M 10 x 0.75	9.65	9.62	9.70	9.188	9.424								
M 5	0.80	4.65	4.62	4.71	4.134	4.384	M 10 x 1.00	9.55	9.52	9.62	8.917	9.217								
M 6	1.00	5.55	5.52	5.62	4.917	5.217	M 10 x 1.25	9.40	9.36	9.47	8.647	8.982								
M 7	1.00	6.55	6.52	6.62	5.917	6.217	M 11 x 0.75	10.65	10.62	10.70	10.188	10.424								
M 8	1.25	7.40	7.36	7.47	6.647	6.982	M 11 x 1.00	10.55	10.52	10.62	9.917	10.217								
M 9	1.25	8.40	8.36	8.47	7.647	7.982	M 12 x 1.00	11.55	11.52	11.62	10.917	11.217								
M 10	1.50	9.30	9.26	9.38	8.376	8.751	M 12 x 1.25	11.40	11.36	11.47	10.647	10.982								
M 11	1.50	10.30	10.26	10.38	9.376	9.751	M 12 x 1.50	11.30	11.26	11.38	10.376	10.751								
M 12	1.75	11.20	11.15	11.29	10.106	10.531	M 14 x 1.00	13.55	13.52	13.62	12.917	13.217								
M 14	2.00	13.10	13.05	13.20	11.835	12.310	M 14 x 1.25	13.40	13.36	13.47	12.647	12.982								
M 16	2.00	15.10	15.05	15.20	13.835	14.310	M 14 x 1.50	13.30	13.26	13.38	12.376	12.751								
M 18	2.50	16.90	16.83	17.02	15.294	15.854	M 15 x 1.00	14.55	14.52	14.62	13.917	14.217								
M 20	2.50	18.90	18.83	19.02	17.294	17.854	M 15 x 1.50	14.30	14.26	14.38	13.376	13.751								
M 22	2.50	20.90	20.83	21.02	19.294	19.854	M 16 x 1.00	15.55	15.52	15.62	14.917	15.217								
M 24	3.00	22.70	22.62	22.80	20.752	21.382	M 16 x 1.50	15.30	15.26	15.38	14.376	14.751								
M 27	3.00	25.70	25.62	25.80	23.752	24.382	M 17 x 1.00	16.55	16.52	16.62	15.917	16.217								
M 30	3.50	28.50	28.40	28.60	26.211	26.921	M 17 x 1.50	16.30	16.26	16.38	15.376	15.751								
M 33	3.50	31.50	31.40	31.60	29.211	29.921	M 18 x 1.00	17.55	17.52	17.62	16.917	17.217								
M 36	4.00	34.30	34.17	34.40	31.670	32.420	M 18 x 1.50	17.30	17.26	17.38	16.376	16.751								
M 39	4.00	37.30	37.17	37.40	34.670	35.420	M 18 x 2.00	17.10	17.05	17.20	15.835	16.310								
M 42	4.50	40.10	39.95	40.20	37.129	37.979	M 20 x 1.00	19.55	19.52	19.62	18.917	19.217								

* M 2 to M 2,5 core-Ø of int. thread 6H

* M 2,5 x 0,35 to M 4 x 0,35 core-Ø of int. thread 6H

Tapping hole size diameter tolerance zone for thread forming (to DIN 13, section 50)

Due to the tensile strength it is not necessary to adhere to the tapping hole size diameter tolerance class 6H; tolerance class 7H satisfies the requirement that the flank coverage of external and internal threads should not fall below 0,32 x P. In addition, formed threads generally possess a higher tensile strength in comparison to cut threads thanks to an uninterrupted grain flow and subsequent work hardening.



Recommended hole size dias for cold forming taps

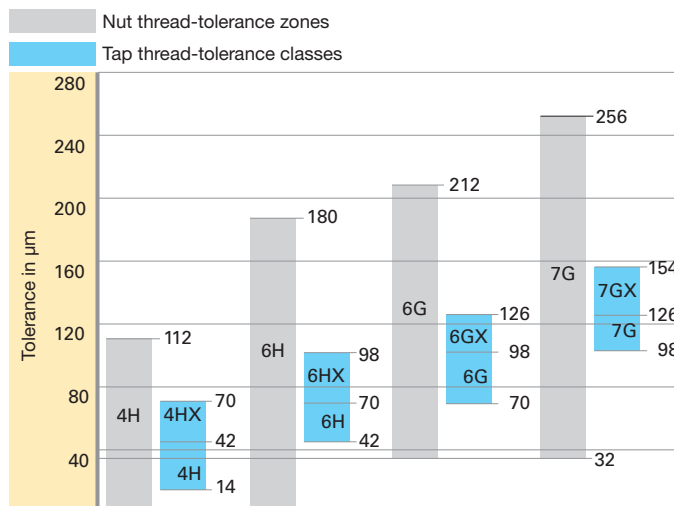
UNC threads ASME B1.1						UNF threads ASME B1.1						(Whitworth-) BSP threads DIN EN ISO 228-1								
nom.- threads Ø	per inch	tapp. hole size Ø mm	tapping hole size Ø		core-Ø of int. thread 2B		nom.- threads Ø	per inch	tapp. hole size Ø mm	tapping hole size Ø		core-Ø of int. thread 2B		nom.- threads inch	per inch	tapp. hole size Ø mm	tapping hole size Ø		core-Ø of int. thread	
			min. mm	max. mm	min. mm	max. mm				min. mm	max. mm	min. mm	max. mm				min. mm	max. mm		
Nr. 1 - 64		1.68	1.67	1.70	1.425	1.580	Nr. 1 - 72		1.70	1.69	1.72	1.473	1.610	G 1/16 28		7.30	7.28	7.35	6.561	6.843
Nr. 2 - 56		1.98	1.97	2.01	1.694	1.872	Nr. 2 - 64		2.00	1.99	2.03	1.755	1.910	G 1/8 28		9.30	9.28	9.35	8.566	8.848
Nr. 3 - 48		2.28	2.27	2.32	1.941	2.146	Nr. 3 - 56		2.30	2.29	2.34	2.024	2.197	G 1/4 19		12.50	12.48	12.55	11.445	11.890
Nr. 4 - 40		2.55	2.54	2.59	2.157	2.385	Nr. 4 - 48		2.60	2.59	2.63	2.271	2.459	G 3/8 19		16.00	15.98	16.05	14.950	15.395
Nr. 5 - 40		2.90	2.89	2.94	2.487	2.698	Nr. 5 - 44		2.90	2.89	2.93	2.550	2.741	G 1/2 14		20.00	19.98	20.12	18.631	19.172
Nr. 6 - 32		3.15	3.14	3.19	2.642	2.896	Nr. 6 - 40		3.20	3.19	3.24	2.819	3.023	G 5/8 14		22.00	21.98	22.12	20.587	21.128
Nr. 8 - 32		3.80	3.78	3.82	3.302	3.531	Nr. 8 - 36		3.85	3.83	3.88	3.404	3.607	G 3/4 14		25.50	25.48	25.62	24.117	24.658
Nr. 10 - 24		4.35	4.33	4.39	3.683	3.937	Nr. 10 - 32		4.45	4.43	4.49	3.962	4.166	G 7/8 14		29.25	29.23	29.37	27.877	28.418
Nr. 12 - 24		5.00	4.97	5.03	4.343	4.597	Nr. 12 - 28		5.10	5.07	5.13	4.496	4.724	G 1 11		32.00	31.98	32.15	30.291	30.931
1/4 - 20		5.75	5.72	5.80	4.978	5.258	1/4 - 28		5.95	5.92	5.99	5.359	5.588	G 1 1/4 11		40.75	40.70	40.85	38.952	39.592
5/16 - 18		7.30	7.26	7.37	6.401	6.731	5/16 - 24		7.45	7.42	7.50	6.782	7.036							
3/8 - 16		8.80	8.77	8.88	7.798	8.153	3/8 - 24		9.05	9.02	9.10	8.838	8.636							
7/16 - 14		10.30	10.27	10.37	9.144	9.550	7/16 - 20		10.55	10.48	10.58	9.728	10.033							
1/2 - 13		11.80	11.77	11.88	10.592	11.024	1/2 - 20		12.10	12.08	12.18	11.328	11.608							
9/16 - 12		13.30	13.28	13.39	11.989	12.446	9/16 - 18		13.65	13.61	13.72	12.751	13.081							
5/8 - 11		14.80	14.78	14.90	13.386	13.868	5/8 - 18		15.25	15.21	15.32	14.351	14.681							
3/4 - 10		17.90	17.85	17.97	16.307	16.840	3/4 - 16		18.35	18.30	18.41	17.323	17.678							
7/8 - 9		21.00	20.95	21.10	19.177	19.761	7/8 - 14		21.40	21.35	21.49	20.269	20.650							
1 - 8		24.00	23.95	24.12	21.971	22.606	1 - 12		24.45	24.40	24.54	23.114	23.571							

Tolerance zones (nut thread)/Tolerance classes (tap thread)

Quality and position of tolerance determine the tolerance zone, which is identified by the appropriate figures and letters. The abbreviation for the tolerance class of tap corresponds to the tolerance zone of the internal thread for which the tap is used in most cases. Therefore, it is not identical with the

tolerance zone of the cut nut thread in every application. Taps with deviating tolerances according to DIN 802 part 1 will be given additional marking "X" (6 HX, 6 GX). We recommend the application of taps in accordance with the adjacent table:

Tolerance zone / tolerance class allocation



DIN EN 22857		Tolerance zone of internal thread to be cut				DIN 802 part 1 (withdrawn)	
Application class of tap	Designation*	Reference					Tolerance class of tap
Class 1	ISO 1		4H	5H			4H
Class 2	ISO 2				6H		6H
Class 3	ISO 3					6G	6G
-	-					7G	7G

* The tolerance of the 3 application classes is calculated in accordance to the following data dependent on one tolerance unit t the value of which corresponds to the value of the basic pitch diameter TD2 in tolerance class 5 of the nut thread (polished to a pitch of 0.2 mm):
t = t_{D2} Tolerance class 5 of nut thread