



## CONVERSION CHART FOR 60° METRIC THREADS

ONE INCH EQUALS 25.400 MILLIMETERS

PITCH MM	WIRE SIZE		ADD		CONSTANT	
	MM	INCH	MM	INCH	MM	INCH
0.5	.4572	.018	.6138	.02417	.9386	.03695
0.6	.4572	.018	.4623	.01820	.8520	.03354
0.7	.4572	.018	.3107	.01223	.7654	.03013
0.75	.4572	.018	.2349	.00925	.7221	.02843
0.8	.6096	.024	.6164	.02427	1.1360	.04472
1.0	.6096	.024	.3133	.01233	.9628	.03790
1.25	.7366	.029	.3154	.01242	1.1273	.04438
1.5	1.0160	.040	.7747	.03050	1.7490	.06886
1.75	1.0160	.040	.3958	.01558	1.5324	.06033
2.0	1.1430	.045	.3979	.01567	1.6969	.06681
2.5	1.3970	.055	.4021	.01583	2.0259	.07976
3.0	1.6002	.063	.2540	.01000	2.2025	.08671
3.5	2.0574	.081	.8678	.03416	3.1411	.12367
4.0	2.3368	.092	.9482	.03733	3.5463	.13962
4.5	2.7432	.108	1.4096	.05550	4.3325	.17057
5.0	2.7432	.108	.6519	.02566	3.8995	.15352
5.5	3.0480	.120	.8085	.03183	4.3808	.17247
6.0	3.2258	.127	.5841	.02300	4.4812	.17643

.03937 INCH EQUALS ONE MILLIMETER

## THREAD CHART FOR ALL U.S.60° THREADS

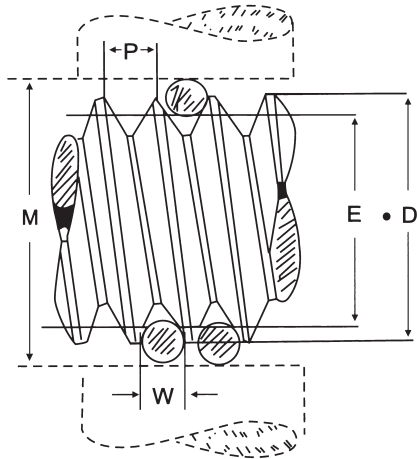
Select the proper wire size for either the number of threads per inch (US) or thread pitch (Metric).

Measured pitch diameter (E) equals measurement over wires (M) minus decimal in "CONST" column.

Note: Basic P.D. equals basic major diameter plus decimal in "ADD" column minus decimal in "CONST" column.

THREADS PER IN.	WIRE SIZE	ADD	CONST	THREADS PER IN.	WIRE SIZE	ADD	CONST
48	.018	.02243	.03596	11 1/2	.055	.03321	.08969
44	.018	.01956	.03432	11	.055	.02722	.08627
40	.018	.01611	.03235	10	.055	.01345	.07840
36	.018	.01190	.02994	9	.063	.02061	.09277
32	.024	.02464	.04494	8	.072	.02656	.10775
28	.024	.01787	.04107	7 1/2	.081	.04093	.12753
27	.024	.01587	.03993	7	.081	.02649	.11928
24	.029	.02385	.05092	6	.092	.02341	.13166
20	.029	.01122	.04370	5 1/2	.108	.04845	.16654
18	.032	.01180	.04789	5	.120	.05689	.18679
16	.040	.02528	.06587	4 1/2	.127	.04421	.18855
14	.040	.01175	.05814	4	.143	.05011	.21249
13	.045	.01842	.06838	3 1/2	.185	.12199	.30756
12	.055	.03870	.09283	3	.185	.04982	.26632

Three wire method of checking pitch diameter of screw threads.



M=Measurement over wires.

E=Pitch diameter of thread.

D=Basic major or outside diameter.

W=Wire diameter.

P=Thread pitch

$M = E + \text{Const}$

$E = M - \text{Const}$

Const. =  $3W - 86603p$  (found in chart)

The maximum and minimum pitch diameter(E)

for each class of thread found in machinery's hand book

The logo for HAAS, featuring the letters 'H', 'A', and 'S' in a stylized, bold, italicized font. The 'H' and 'S' are connected, and the 'A' is positioned between them.