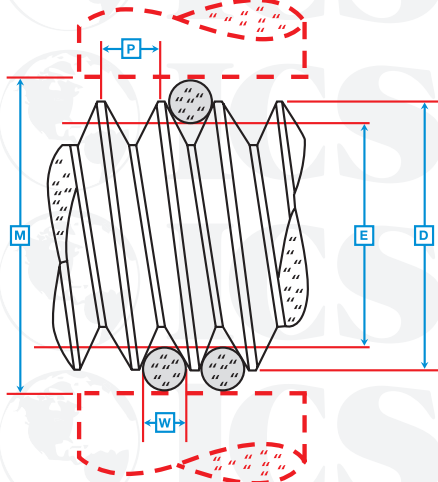


Three wire method of checking pitch diameter of screw threads



- M = Measurement over wires
- E = Pitch diameter of thread
- D = Basic major or outside diameter
- W = Wire Diameter
- $M = E + \text{Const.}$
- E =  $M - \text{Const.}$
- Const. = 3W 86603P (found in chart)

The maximum and minimum pitch diameter (E) for each class of thread can be found in machinery's hand book.



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## CONVERSION CHART FOR 60° METRIC THREADS

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	11360	04472
1.0	6096	024	3133	01233	9628	03790
1.25	7366	029	3154	01242	11273	04438
1.5	10160	040	7747	03050	17490	06886
1.75	10160	040	3958	01558	15324	06033
2.0	11430	045	3979	01567	16969	06681
2.5	13970	055	4021	01583	20259	07976
3.0	16002	063	2540	01000	22025	08671
3.5	20574	081	8678	03416	31411	12367
4.0	23368	092	9482	03733	35463	13962
4.5	27432	108	14096	05550	43325	17057
5.0	27432	108	6519	02566	38995	15352
5.5	30480	120	8085	03183	43808	17247
6.0	32258	127	5841	02300	41812	17643

ONE INCH EQUALS 25.400 MILLIMETERS  
.03937 INCH EQUALS ONE MILLIMETER

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

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

Measured pitch dia (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 INCH	WIRE SIZE	ADD	CONST	THREADS PER IN	WIRE SIZE	ADD	CONST
48	018	02243	03596	11 1/2	055	03321	09869
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