

General

The thread dimensions and profile accuracy are crucial for determining:

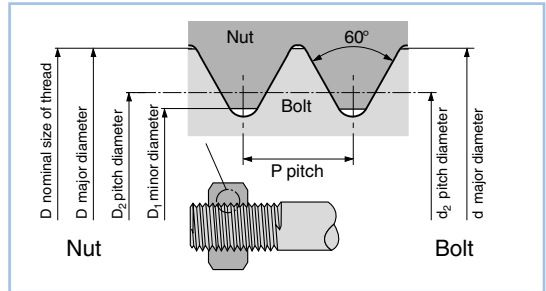
- whether a coating can still be applied to the screw thread
- whether the parts to be joined can be screwed together on assembly without difficulty or the need for reworking
- whether the thread can transmit the forces for which the components were dimensioned.

Tolerances are very small in screw manufacturing. Terms and fitting systems are difficult to understand. To assist, the following illustrations explain dimensions and tolerances.

Basic concept and nominal dimensions

according to ISO 724

The dimension system for threads is based on the nominal dimensions for thread, pitch and minor diameter.



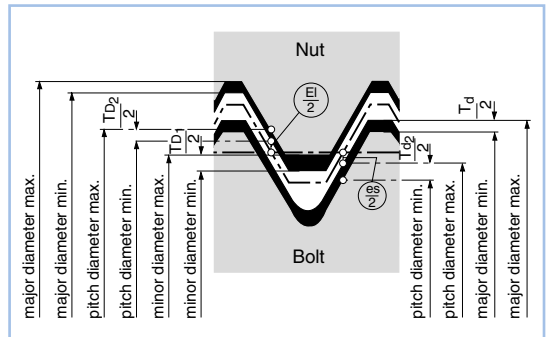
Clearance fit on metric ISO threads

according to ISO 965

Screw and nut threads have different tolerance zone positions: screw thread dimensions are situated at the nominal dimension and below, nut thread dimensions, at the nominal dimension and above.

This produces the necessary clearance and a defined range for permissible plating thicknesses: a plated screw thread must never exceed the nominal dimensions, while a plated nut thread must never fall below them.

▶ **Maximum coating thickness for metric ISO threads**
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Tolerance fields for commercial screws and nuts

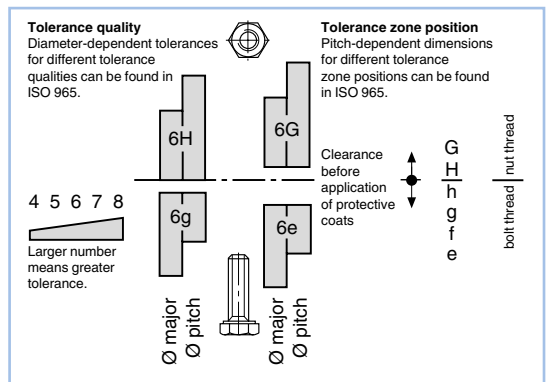
according to ISO 965

The ISO 965 thread standard recommends tolerance fields which give the desired clearance. For threads \geq M1,4, the following tolerance fields are standard:

Nut	Bolt	finish
6H*	6g	bright /suitable for standard electroplatings
6H	6h	after coating
6G	6e/6f	bright /suitable for thicker electroplatings
6H	6h	after coating

- | | |
|----------------------|--|
| Testing screw thread | bright: with 6g-ring gauges
coated: with 6h-ring gauges |
| Testing nut thread | bright or coated:
with thread plug gauge 6H* |

* according to 6H manufactured nuts just allow a surface protection, if during thread cutting the tolerance field ist not used up to the zero line.



Limits for metric (standard) coarse threads

according to ISO 965

Screws, tolerance 6g (*6h)

Thread	Length of thread engagement		Major diameter		Pitch diameter		Thread root radius [mm]
			d [mm]		d ₂ [mm]		
	from	to	max.	min.	max.	min.	min.
M1*	0,6	1,7	1,000	0,933	0,838	0,785	0,031
M1,2*	0,6	1,7	1,200	1,133	1,038	0,985	0,031
M1,4*	0,7	2	1,400	1,325	1,205	1,149	0,038
M1,6	0,8	2,6	1,581	1,496	1,354	1,291	0,044
M1,8	0,8	2,6	1,781	1,696	1,554	1,491	0,044
M2	1	3	1,981	1,886	1,721	1,654	0,050
M2,5	1,3	3,8	2,480	2,380	2,188	2,117	0,056
M3	1,5	4,5	2,980	2,874	2,655	2,580	0,063
M3,5	1,7	5	3,479	3,354	3,089	3,004	0,075
M4	2	6	3,978	3,838	3,523	3,433	0,088
M5	2,5	7,5	4,976	4,826	4,456	4,361	0,100
M6	3	9	5,974	5,794	5,324	5,212	0,125
M7	3	9	6,974	6,794	6,324	6,212	0,125
M8	4	12	7,972	7,760	7,160	7,042	0,156
M10	5	15	9,968	9,732	8,994	8,862	0,188
M12	6	18	11,966	11,701	10,829	10,679	0,219
M14	8	24	13,962	13,682	12,663	12,503	0,250
M16	8	24	15,962	15,682	14,663	14,503	0,250
M18	10	30	17,958	17,623	16,334	16,164	0,313
M20	10	30	19,958	19,623	18,334	18,164	0,313
M22	10	30	21,958	21,623	20,334	20,164	0,313
M24	12	36	23,952	23,577	22,003	21,803	0,375
M27	12	36	26,952	26,577	25,003	24,803	0,375
M30	15	45	29,947	29,522	27,674	27,462	0,438
M33	15	45	32,947	32,522	30,674	30,462	0,438
M36	18	53	35,940	35,465	33,342	33,118	0,500
M39	18	53	38,940	38,465	36,342	36,118	0,500

Nuts, tolerance 6H (*5H)

Thread	Length of thread engagement		Pitch diameter		Minor diameter	
			D ₂ [mm]		D ₁ [mm]	
	from	to	max.	min.	max.	min.
M1*	0,6	1,7	0,894	0,838	0,785	0,729
M1,2*	0,6	1,7	1,094	1,038	0,985	0,929
M1,4*	0,7	2	1,265	1,205	1,142	1,075
M1,6	0,8	2,6	1,458	1,373	1,321	1,221
M1,8	0,8	2,6	1,658	1,573	1,521	1,421
M2	1	3	1,830	1,740	1,679	1,567
M2,5	1,3	3,8	2,303	2,208	2,138	2,013
M3	1,5	4,5	2,775	2,675	2,599	2,459
M3,5	1,7	5	3,222	3,110	3,010	2,850
M4	2	6	3,663	3,545	3,422	3,242
M5	2,5	7,5	4,605	4,480	4,334	4,134
M6	3	9	5,500	5,350	5,153	4,917
M7	3	9	6,500	6,350	6,153	5,917
M8	4	12	7,348	7,188	6,912	6,647
M10	5	15	9,206	9,026	8,676	8,376
M12	6	18	11,063	10,863	10,441	10,106
M14	8	24	12,913	12,701	12,210	11,835
M16	8	24	14,913	14,701	14,210	13,835
M18	10	30	16,600	16,376	15,744	15,294
M20	10	30	18,600	18,376	17,744	17,294
M22	10	30	20,600	20,376	19,744	19,294
M24	12	36	22,316	22,051	21,252	20,752
M27	12	36	25,316	25,051	24,252	23,752
M30	15	45	28,007	27,727	26,771	26,211
M33	15	45	31,007	30,727	29,771	29,211
M36	18	53	33,702	33,402	32,270	31,670
M39	18	53	36,702	36,402	35,270	34,670

Selection series for coarse threads

according to ISO 262

1st choice

Thread nominal diameter	M1,2	M1,6	M2	M2,5	M3	M4	M5	M6	M8	M10	M12	M16	M20	M24	M30	M36	M42	M48
Pitch P [mm]	0,25	0,35	0,4	0,45	0,5	0,7	0,8	1	1,25	1,5	1,75	2	2,5	3	3,5	4	4,5	5

2nd choice

Thread nominal diameter	M1,4	M1,8	M3,5	M7	M14	M18	M22	M27	M33	M39	M45
Pitch P [mm]	0,3	0,35	0,6	1	2	2,5	2,5	3	3,5	4	4,5

Limits for metric fine threads

according to ISO 965

Screws with metric fine thread, tolerance 6g

Thread	Length of thread engagement		Major diameter		Pitch diameter		Thread root radius [mm]
	from	to	d [mm]		d ₂ [mm]		
			max.	min.	max.	min.	
M8x1	3	9	7,974	7,794	7,324	7,212	0,125
M10x1	3	9	9,974	9,794	9,324	9,212	0,156
M10x1,25	4	12	9,972	9,760	9,160	9,042	0,156
M12x1,25	4,5	13	11,972	11,760	11,160	11,028	0,156
M12x1,5	5,6	16	11,968	11,732	10,994	10,854	0,156
M14x1,5	5,6	16	13,968	13,732	12,994	12,854	0,188
M16x1,5	5,6	16	15,968	15,732	14,994	14,854	0,188
M18x1,5	5,6	16	17,968	17,762	16,994	16,854	0,188
M18x2	8	24	17,952	17,682	16,663	16,503	0,188
M20x1,5	5,6	16	19,968	19,732	18,994	18,854	0,188
M20x2	8	24	19,962	19,682	18,663	18,503	0,188
M22x1,5	5,6	16	21,968	21,732	20,994	20,854	0,188
M22x2	8	24	21,962	21,682	20,663	20,503	0,188
M24x2	8,5	25	23,962	23,682	22,663	22,493	0,250
M27x2	8,5	25	26,962	26,682	25,663	25,483	0,250
M30x2	8,5	25	29,962	29,682	28,663	28,493	0,250
M33x2	8,5	25	32,962	32,682	31,663	31,493	0,250
M36x3	12	36	35,952	35,577	34,003	33,803	0,375
M39x3	12	36	38,952	38,577	37,003	36,803	0,375

Nuts with metric fine thread, tolerance 6H

Thread	Length of thread engagement		Pitch diameter		Minor diameter	
	from	to	D ₂ [mm]		D ₁ [mm]	
			max.	min.	max.	min.
M8x1	3	9	7,500	7,350	7,153	6,917
M10x1	3	9	9,500	9,350	9,153	8,917
M10x1,25	4	12	9,348	9,188	8,912	8,647
M12x1,25	4,5	13	11,368	11,188	10,912	10,647
M12x1,5	5,6	16	11,216	11,026	10,676	10,376
M14x1,5	5,6	16	13,216	13,026	12,676	12,376
M16x1,5	5,6	16	15,216	15,026	14,676	14,376
M18x1,5	5,6	16	17,216	17,026	16,676	16,376
M18x2	8	24	16,913	16,701	16,210	15,835
M20x1,5	5,6	16	19,216	19,026	18,676	18,376
M20x2	8	24	18,913	18,701	18,210	17,835
M22x1,5	5,6	16	21,216	21,026	20,676	20,376
M22x2	8	24	20,913	20,701	20,210	19,835
M24x2	8,5	25	22,925	22,701	22,210	21,835
M27x2	8,5	25	25,925	25,701	25,210	24,834
M30x2	8,5	25	28,925	28,701	28,210	27,835
M33x2	8,5	25	31,925	31,701	31,210	30,835
M36x3	12	36	34,316	34,051	33,252	32,752
M39x3	12	36	37,316	37,051	36,252	35,752

Selection series for fine threads

according to ISO 262

1st choice

Nominal thread diameter	M8	M10	M12	M16	M20	M24	M30	M36
Pitch P [mm]	1	1,25	1,25	1,5	1,5	2	2	3
	–	1 ¹⁾	1,5 ¹⁾	–	2 ¹⁾	–	–	–

2nd choice

Nominal thread diameter	M14	M18	M22	M27	M33	M39
Pitch P [mm]	1,5	1,5	1,5	2	2	3
	–	2 ¹⁾	2 ¹⁾	–	–	–

¹⁾ Not contained in ISO 262:1973

Permissible tolerances for plastic fasteners

Dimension	for screw threads	for nut threads
major Ø	e8	2 x G7
minor Ø	2 x g8	H7
pitch Ø	2 x g8	2 x g8
pitch	±5%	±5%

- Dimensions of the head, screw length and thread approximately according to DIN. Acceptance according to VDI 2544.
- The tolerances must be observed 24 hours after fabrication, for all other tolerances, refer to ISO 4759, part 1, but with the factor 2.
- These technical recommendations are of a general nature. For more detailed specifications, please refer to VDI 2544.