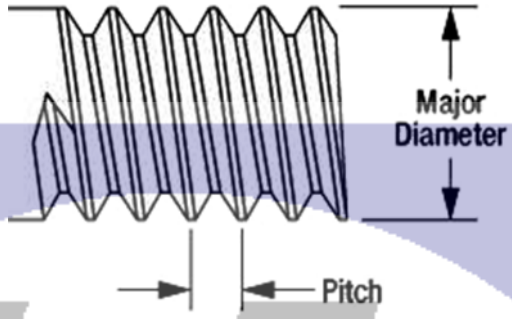
HAGUE FASTENERS LIMITED

HIGH INTEGRITY SPECIAL FASTENERS IN CRITICAL ALLOYS
Monmer Close, Willenhall, West Midlands, WV13 1JR, United Kingdom
Registered in England No: 3292586 VAT GB346974609

THREAD ROLLING BLANK DIAMETERS

Thread Rolling Diameter Should be adjusted depending on Material being processed. These charts must be used as a Guide only and all Pre-Machined Thread Rolled Blanks must be proven to Gauge prior to batch production & sign off.

Blank Diameter = MAX thread pitch diameter - .002 inches [or .051 MM]



METRIC FINE (2A - 60° Thread)					
	(P)	(D) Major Diameter		(d) Rolling Diameter	
SIZE	Pitch	MAX	MIN	MAX	MIN
M4	0.50	3.97	3.86	3.62	3.58
M4.5	0.50	4.47	4.36	4.12	4.08
M5	0.50	4.97	4.86	4.62	4.58
M6	0.75	5.97	5.85	5.45	5.41
M7	0.75	6.97	6.85	6.45	6.41
M8	1.00	7.97	7.83	7.29	7.24
M9	1.00	8.97	8.83	8.29	8.24
M10	1.25	9.96	9.81	9.12	9.07
M10	1.00	9.97	9.82	9.28	9.23
M12	1.25	11.97	11.76	11.12	11.07
M12	1.50	11.96	11.79	10.95	10.89
M14	1.50	13.96	13.79	12.95	12.89
M16	1.50	15.96	15.79	14.95	14.89
M18	2.00	17.95	17.65	16.62	16.54
M18	1.50	17.95	17.78	16.93	16.86
M20	2.00	19.95	19.65	18.62	18.54
M20	1.50	19.95	19.78	18.92	18.85
M22	1.50	21.95	21.78	20.92	20.85
M24	1.50	23.95	23.78	22.92	22.85
M26	1.50	25.95	25.78	24.93	24.85
M27	1.50	26.95	26.78	25.93	25.85
M28	1.50	27.95	27.78	26.93	26.85
M30	1.50	29.95	29.78	28.93	28.85

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METRIC COARSE (2A - 60° Thread)					
	(P)	(D) Major Diameter		(d) Rolling Diameter	
SIZE	Pitch	MAX	MIN	MAX	MIN
M2	0.40	1.98	1.89	1.72	1.69
M2.3	0.40	2.28	2.19	2.02	1.99
M2.5	0.45	2.48	2.38	2.18	2.15
M3	0.50	2.98	2.88	2.64	2.61
M3.5	0.60	3.47	3.36	3.06	3.03
M4	0.70	3.98	3.84	3.49	3.45
M4.5	0.75	4.47	4.34	3.96	3.92
M5	0.80	4.98	4.83	4.43	4.38
M6	1.00	5.97	5.82	5.30	5.25
M7	1.00	6.97	6.82	6.30	6.25
M8	1.25	7.96	7.79	7.12	7.07
M9	1.25	8.96	8.79	8.12	8.07
M10	1.50	9.96	9.77	8.97	8.91
M11	1.50	10.97	10.73	9.97	9.91
M12	1.75	11.95	11.76	10.79	10.73
M14	2.00	13.95	13.74	12.63	12.56
M16	2.00	15.95	15.74	14.63	14.56
M18	2.50	17.95	17.71	16.31	16.23
M20	2.50	19.95	19.71	18.31	18.23
M22	2.50	21.95	21.71	20.31	20.23
M24	3.00	23.94	23.68	21.98	21.90
M27	3.00	26.94	26.68	24.98	24.89
M30	3.50	29.94	29.66	27.66	27.56
M33	3.50	32.94	32.66	30.65	30.56

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U.N.C (2A - 60° Thread)					
	(T)	(D) Major Diameter		(d) Rolling Diameter	
SIZE	Threads	MAX	MIN	MAX	MIN
NO:1	64	1.838	1.743	1.58	1.56
NO:2	56	2.169	2.066	1.87	1.85
NO:3	48	2.496	2.383	2.14	2.11
NO:4	40	2.824	2.695	2.40	2.37
NO:5	40	3.154	3.026	2.72	2.69
NO:6	32	3.484	3.333	2.94	2.91
NO:8	32	4.142	3.991	3.60	3.57
NO:10	24	4.800	4.618	4.09	4.05
NO:12	24	5.461	5.279	4.75	4.70
1/4	20	6.322	6.117	5.50	5.45
5/16	18	7.907	7.687	6.98	6.93
3/8	16	9.491	9.254	8.45	8.40
7/16	14	11.076	10.816	9.89	9.83
1/2	13	12.661	12.386	11.39	11.32
9/16	12	14.246	13.958	12.87	12.80
5/8	11	15.834	15.528	14.33	14.26
3/4	10	19.004	18.677	17.34	17.27
7/8	9	22.176	21.824	20.34	20.26
1	8	25.349	24.969	23.28	23.20
1-1/8	7	28.519	28.103	26.16	26.07

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U.N.F (2A - 60° Thread)					
	(T)	(D) Major Diameter		(d) Rolling Diameter	
SIZE	Threads	MAX	MIN	MAX	MIN
NO:2	64	2.169	2.073	1.91	1.89
NO:3	56	2.496	2.393	2.20	2.17
NO:4	48	2.827	2.713	2.47	2.44
NO:5	44	3.157	3.036	2.76	2.73
NO:6	40	3.484	3.356	3.05	3.02
NO:8	36	4.145	4.006	3.66	3.63
NO:10	32	4.803	4.651	4.26	4.23
NO:12	28	5.461	5.296	4.85	4.81
1/4	28	6.324	6.160	5.72	5.68
5/16	24	7.909	7.727	7.20	7.16
3/8	24	9.497	9.315	8.76	8.74
7/16	20	11.079	10.874	10.23	10.18
1/2	20	12.666	12.462	11.82	11.76
9/16	18	14.251	14.031	13.31	13.25
5/8	18	15.839	15.619	14.89	14.83
3/4	16	19.011	18.774	17.95	17.89
7/8	14	22.184	21.923	20.98	20.91
1	12	25.254	25.065	23.95	23.87
1-1/8	12	28.529	28.240	27.12	27.05

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B.S.W (2A - 55° Thread)					
	(P)	(D) Major Diameter		(d) Rolling Diameter	
SIZE	Pitch	MAX	MIN	MAX	MIN
1/8	40	3.145	3.030	2.72	2.70
5/32	32	3.945	3.795	3.40	3.38
3/16	24	4.732	4.592	4.03	4.00
1/4	20	6.320	6.165	5.48	5.45
5/16	18	7.905	7.737	6.97	6.94
3/8	16	9.490	9.312	8.44	8.40
7/16	14	11.074	10.883	9.88	9.84
1/2	12	12.662	12.456	11.27	11.22
9/16	12	14.247	14.039	12.86	12.81
5/8	11	15.832	15.614	14.33	14.27
3/4	10	19.004	18.770	17.34	17.28
7/8	9	22.225	21.798	20.34	20.28
1	8	25.400	25.130	23.29	23.23