

**TECHNICAL INFORMATION and DATA**

Coating thickness for parts with external threads

Pitch	Nominal thread diameter <sup>1)</sup>	General purpose tolerance for screw threads						Special purpose tolerance for screw threads									Tolerance for hot dip galvanizing	
		Tolerance deviation g						Tolerance deviation f						Tolerance deviation e			Tolerance deviation ax	
		Fundamental deviation	Coating thickness max. in the thread <sup>3)</sup>					Fundamental deviation	Coating thickness max. in the thread <sup>3)</sup>				Fundamental deviation	Coating thickness max. in the thread <sup>3)</sup>			Coating thickness max. in the thread <sup>2)</sup>	
			2) All nominal lengths	Nominal length, l					Ao	2) All Nominal lengths	Nominal length, l			Ao	2) All nominal lengths	Fundamental deviation Ao	All nominal lengths	
l ≤ 5d		5d < l ≤ 10d		10d < l ≤ 15d		l ≤ 5d		5d < l ≤ 10d			10d < l ≤ 15d		l ≤ 5d					5d < l ≤ 10d
mm	M	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm	μm
0,25	1; 1,2	-18	3	3	3	3												
0,3	1,4	-18	3	3	3	3												
0,35	1,6 (1,8)	-19	3	3	3	3	-34	8	8	5	5							
0,4	2	-19	3	3	3	3	-34	8	8	5	5							
0,45	2,5 (2,2)	-20	5	5	3	3	-35	8	8	5	5							
0,5	3	-20	5	5	3	3	-36	8	8	5	5	-50	12	12	10	8		
0,6	3,5	-21	5	5	3	3	-36	8	8	5	5	-53	12	12	10	8		
0,7	4	-22	5	5	3	3	-38	8	8	5	5	-56	12	12	10	8		
0,75	4,5	-22	5	5	3	3	-38	8	8	5	5	-56	12	12	10	8		
0,8	5	-24	5	5	3	3	-38	8	8	5	5	-60	15	15	12	10		
1	6 (7)	-26	5	5	3	3	-40	10	10	8	5	-60	15	15	12	10	-290	70
1,25	8	-20	5	5	5	3	-42	10	10	8	5	-63	15	15	12	10	-295	70
1,5	10	-32	8	8	5	5	-45	10	10	8	5	-67	15	15	12	10	-300	75
1,75	12	-34	8	8	5	5	-48	12	12	8	8	-71	15	15	12	10	-310	75
2	16 (14)	-38	8	8	5	5	-52	12	12	10	8	-71	15	15	12	10	-315	75
2,5	20 (18; 22)	-42	10	10	8	5	-58	12	12	10	8	-80	20	20	15	12	-315	80
3	24 (27)	-48	12	12	8	8	-63	15	15	12	10	-85	20	20	15	12	-335	80
3,5	30 (33)	-53	12	12	10	8	-70	15	15	12	10	-90	20	20	15	15	-345	85
4	36 (39)	-60	15	15	12	10	-75	15	15	15	12	-95	20	20	15	15	-355	85
4,5	42 (45)	-63	15	15	12	10	-80	20	20	15	12	-100	25	25	20	15		
5	48 (52)	-71	15	15	12	10	-85	20	20	15	12	-106	25	25	20	15		
5,5	56 (60)	-75	15	15	15	12	-90	20	20	15	15	-112	25	25	20	15		
6	64	-80	20	20	15	12	-95	20	20	15	15	-118	25	25	20	15		

<sup>1)</sup>Information for coarse pitch threads is given for convenience only. The determining characteristic is the thread pitch.

<sup>2)</sup>Maximum values of nominal coating thickness if local thickness measurement is agreed.

<sup>3)</sup>Maximum values of nominal coating thickness if batch average thickness measurement is agreed.