Unified thread UNC / UNJC / UNF / UNJF

UNC, tolerance 2B

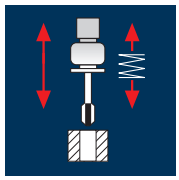
N° EH1687 / EH1688	11	HSS PM/F		Rm 850-1100		299
N° EH1690 / EH1691 x-tap	11	HSS PM/F		Rm 850-1100		303
N° ET1620 / ET1621	In	HSS PM/F		Inox Stainless		307
N° ET1690 / ET1691 x-tap	In	HSS PM/F		Inox Stainless		311
N° EI1602	Al	HSS PM/F		Al Aluminium Alloy	Cu Copper	315
N° EI1652	Al	HSS PM/F		Al Aluminium Alloy	Cu Copper	317

UNJC, tolerance 3B

N° E1699	Ni	HSS PM/F		Ni Nickel Alloy		319

UN

Application



Material

UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²												
2	-56	2.184	0.454	20	2915	1323	16	2330	1058	12	1750	795
3	-48	2.515	0.529	20	2530	1338	16	2025	1071	12	1520	804
4	-40	2.845	0.635	20	2240	1422	16	1790	1137	12	1345	854
5	-40	3.175	0.635	20	2005	1273	16	1605	1019	12	1205	765
6	-32	3.505	0.794	20	1815	1441	16	1455	1155	12	1090	865
8	-32	4.166	0.794	20	1530	1215	16	1225	973	12	915	727
10	-24	4.826	1.058	20	1320	1397	16	1055	1116	12	790	836
12	-24	5.486	1.058	20	1160	1227	16	930	984	12	695	735
1/4	-20	6.350	1.270	20	1005	1276	16	800	1016	12	600	762
Steel 500 - 850 N/mm²												
5/16	-18	7.938	1.411	20	800	1129	16	640	903	12	480	677
3/8	-16	9.525	1.588	20	670	1064	16	535	850	12	400	635
Steel 850 - 1100 N/mm²												
2	-56	2.184	0.454	16	2330	1058	12	1750	795	10	1455	661
3	-48	2.515	0.529	16	2025	1071	12	1520	804	10	1265	669
4	-40	2.845	0.635	16	1790	1137	12	1345	854	10	1120	711
5	-40	3.175	0.635	16	1605	1019	12	1205	765	10	1005	638
6	-32	3.505	0.794	16	1455	1155	12	1090	865	10	910	723
8	-32	4.166	0.794	16	1225	973	12	915	727	10	765	607
10	-24	4.826	1.058	16	1055	1116	12	790	836	10	660	698
12	-24	5.486	1.058	16	930	984	12	695	735	10	580	614
1/4	-20	6.350	1.270	16	800	1016	12	600	762	10	500	635
Steel 850 - 1100 N/mm²												
5/16	-18	7.938	1.411	16	640	903	12	480	677	10	400	564
3/8	-16	9.525	1.588	16	535	850	12	400	635	10	335	532

Material

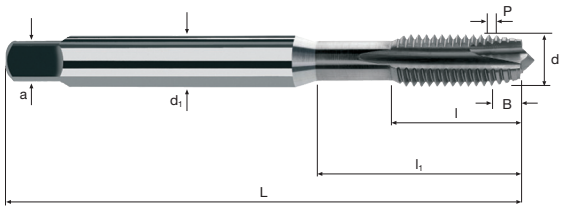
UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 1100 - 1300 N/mm²									
2	-56	2.184	0.454	5	730	331	3	435	197
3	-48	2.515	0.529	5	635	336	3	380	201
4	-40	2.845	0.635	5	560	356	3	335	213
5	-40	3.175	0.635	5	500	318	3	300	191
6	-32	3.505	0.794	5	455	361	3	270	214
8	-32	4.166	0.794	5	380	302	3	230	183
10	-24	4.826	1.058	5	330	349	3	200	212
12	-24	5.486	1.058	5	290	307	3	175	185
1/4	-20	6.350	1.270	5	250	318	3	150	191
Steel 1100 - 1300 N/mm²									
5/16	-18	7.938	1.411	5	200	282	3	120	169
3/8	-16	9.525	1.588	5	165	262	3	100	159

UNC | 2B

60° | HSS PM/F

DIN 371

X · P Form B



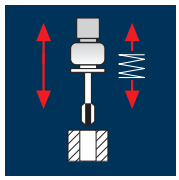
Rm < 850	Rm 850-1100	Rm 1100-1300

Example: **Order-N°.** Article-N°. **EH1687** ø-Code **.701**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1687
.701	Nr. 2	-56	2.184	45	9	–	2.8	2.1	3	1.85	●
.702	Nr. 3	-48	2.515	50	9	–	2.8	2.1	3	2.10	●
.703	Nr. 4	-40	2.845	56	12	18.0	3.5	2.7	3	2.35	●
.704	Nr. 5	-40	3.175	56	12	18.0	3.5	2.7	3	2.65	●
.705	Nr. 6	-32	3.505	56	12	20.0	4.0	3.0	3	2.85	●
.706	Nr. 8	-32	4.166	63	13	21.0	4.5	3.4	3	3.50	●
.707	Nr. 10	-24	4.826	70	15	25.0	6.0	4.9	3	3.90	●
.708	Nr. 12	-24	5.486	80	17	30.0	6.0	4.9	3	4.50	●
.709	1/4	-20	6.350	80	17	30.0	7.0	5.5	3	5.10	●
.710	5/16	-18	7.938	90	20	35.0	8.0	6.2	3	6.60	●
.711	3/8	-16	9.525	100	22	39.0	10.0	8.0	3	8.00	●

For larger dimensions see article no. EH1688, page 301

Application



Material

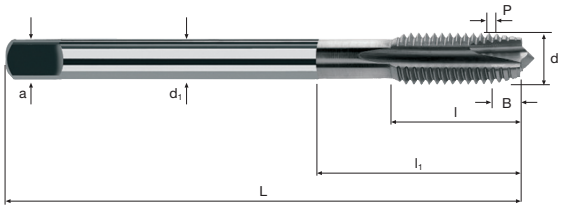
UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²												
7/16	-14	11.113	1.814	20	575	1043	16	460	834	12	345	626
1/2	-13	12.700	1.954	20	500	977	16	400	782	12	300	586
9/16	-12	14.288	2.117	20	445	942	16	355	752	12	265	561
5/8	-11	15.875	2.309	20	400	924	16	320	739	12	240	554
3/4	-10	19.050	2.540	20	335	851	16	265	673	12	200	508
7/8	-9	22.225	2.822	20	285	804	16	230	649	12	170	480
1"	-8	25.400	3.175	20	250	794	16	200	635	12	150	476
Steel 850 - 1100 N/mm²												
7/16	-14	11.113	1.814	16	460	834	12	345	626	10	285	517
1/2	-13	12.700	1.954	16	400	782	12	300	586	10	250	489
9/16	-12	14.288	2.117	16	355	752	12	265	561	10	225	476
5/8	-11	15.875	2.309	16	320	739	12	240	554	10	200	462
3/4	-10	19.050	2.540	16	265	673	12	200	508	10	165	419
7/8	-9	22.225	2.822	16	230	649	12	170	480	10	145	409
1"	-8	25.400	3.175	16	200	635	12	150	476	10	125	397
Steel 1100 - 1300 N/mm²												
7/16	-14	11.113	1.814	5	145	263	3	85	154			
1/2	-13	12.700	1.954	5	125	244	3	75	147			
9/16	-12	14.288	2.117	5	110	233	3	65	138			
5/8	-11	15.875	2.309	5	100	231	3	60	139			
3/4	-10	19.050	2.540	5	85	216	3	50	127			
7/8	-9	22.225	2.822	5	70	198	3	45	127			
1"	-8	25.400	3.175	5	65	206	3	40	127			

UNC | 2B

60° | HSS PM/F

≈DIN 376

X · P Form B

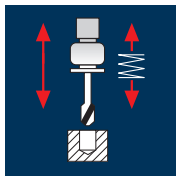


Rm < 850	Rm 850-1100	Rm 1100-1300

Example: **Order-N°.** Article-N°. **EH1688** ø-Code **.712**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1688
.712	7/16	-14	11.113	100	22	39	8	6.2	3	9.40	●
.713	1/2	-13	12.700	110	24	40	9	7.0	3	10.80	●
.714	9/16	-12	14.288	110	26	40	11	9.0	3	12.20	●
.715	5/8	-11	15.875	110	27	40	12	9.0	3	13.50	●
.716	3/4	-10	19.050	125	30	45	14	11.0	4	16.50	●
.717	7/8	-9	22.225	140	32	50	18	14.5	4	19.50	●
.718	1”	-8	25.400	160	34	50	18	14.5	5	22.30	●

UN

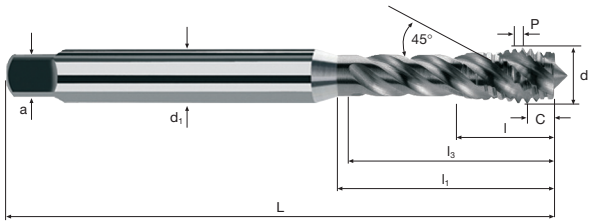
Application	Material	UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
	Steel 500 - 850 N/mm²	2	-56	2.184	0.454	25	3645	1655	22	3205	1455	18	2625	1192
		3	-48	2.515	0.529	25	3165	1674	22	2785	1473	18	2280	1206
		4	-40	2.845	0.635	25	2795	1775	22	2460	1562	18	2015	1280
		5	-40	3.175	0.635	25	2505	1591	22	2205	1400	18	1805	1146
		6	-32	3.505	0.794	25	2270	1802	22	2000	1588	18	1635	1298
		8	-32	4.166	0.794	25	1910	1517	22	1680	1334	18	1375	1092
		10	-24	4.826	1.058	25	1650	1746	22	1450	1534	18	1185	1254
		12	-24	5.486	1.058	25	1450	1534	22	1275	1349	18	1045	1106
		1/4	-20	6.350	1.270	25	1255	1594	22	1105	1403	18	900	1143
	Steel 500 - 850 N/mm²	5/16	-18	7.938	1.411	25	1000	1411	22	880	1242	18	720	1016
		3/8	-16	9.525	1.588	25	835	1326	22	735	1167	18	600	953
	Steel 850 - 1100 N/mm²	2	-56	2.184	0.454	16	2330	1058	13	1895	860	8	1165	529
		3	-48	2.515	0.529	16	2025	1071	13	1645	870	8	1015	537
		4	-40	2.845	0.635	16	1790	1137	13	1455	924	8	895	568
		5	-40	3.175	0.635	16	1605	1019	13	1305	829	8	800	508
		6	-32	3.505	0.794	16	1455	1155	13	1180	937	8	725	576
		8	-32	4.166	0.794	16	1225	973	13	995	790	8	610	484
		10	-24	4.826	1.058	16	1055	1116	13	855	905	8	530	561
		12	-24	5.486	1.058	16	930	984	13	755	799	8	465	492
		1/4	-20	6.350	1.270	16	800	1016	13	650	826	8	400	508
	Steel 850 - 1100 N/mm²	5/16	-18	7.938	1.411	16	640	903	13	520	734	8	320	452
		3/8	-16	9.525	1.588	16	535	850	13	435	691	8	265	421

UNC | 2B

60° | HSS PM/F

DIN 371

X · P | Form C



Rm < 850	Rm 850-1100

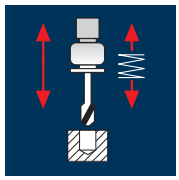
Example: **Order-N°.** Article-N°. **EH1690** ø-Code **.701**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1690
.701	Nr. 2	-56	2.184	45	9	–	12.5	2.8	2.1	3	1.85	●
.702	Nr. 3	-48	2.515	50	9	–	13.0	2.8	2.1	3	2.10	●
.703	Nr. 4	-40	2.845	56	5	–	16.0	3.5	2.7	3	2.35	●
.704	Nr. 5	-40	3.175	56	5	–	16.0	3.5	2.7	3	2.65	●
.705	Nr. 6	-32	3.505	56	6	–	18.0	4.0	3.0	3	2.85	●
.706	Nr. 8	-32	4.166	63	7	–	19.0	4.5	3.4	3	3.50	●
.707	Nr. 10	-24	4.826	70	8	–	23.0	6.0	4.9	3	3.90	●
.708	Nr. 12	-24	5.486	80	10	–	28.0	6.0	4.9	3	4.50	●
.709	1/4	-20	6.350	80	10	30.0	28.0	7.0	5.5	3	5.10	●
.710	5/16	-18	7.938	90	13	35.0	33.0	8.0	6.2	3	6.60	●
.711	3/8	-16	9.525	100	15	39.0	37.0	10.0	8.0	3	8.00	●

For larger dimensions see article no. EH1691, page 305

UN

Application



Material

UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²												
7/16	-14	11.113	1.814	25	715	1297	22	630	1143	18	515	934
1/2	-13	12.700	1.954	25	625	1221	22	550	1075	18	450	879
9/16	-12	14.288	2.117	25	555	1175	22	490	1037	18	400	847
5/8	-11	15.875	2.309	25	500	1155	22	440	1016	18	360	831
3/4	-10	19.050	2.540	25	420	1067	22	370	940	18	300	762
7/8	-9	22.225	2.822	25	360	1016	22	315	889	18	260	734
1"	-8	25.400	3.175	25	315	1000	22	275	873	18	225	714
Steel 850 - 1100 N/mm²												
7/16	-14	11.113	1.814	16	460	834	13	370	671	8	230	417
1/2	-13	12.700	1.954	16	400	782	13	325	635	8	200	391
9/16	-12	14.288	2.117	16	355	752	13	290	614	8	180	381
5/8	-11	15.875	2.309	16	320	739	13	260	600	8	160	369
3/4	-10	19.050	2.540	16	265	673	13	215	546	8	135	343
7/8	-9	22.225	2.822	16	230	649	13	185	522	8	115	325
1"	-8	25.400	3.175	16	200	635	13	165	524	8	100	318

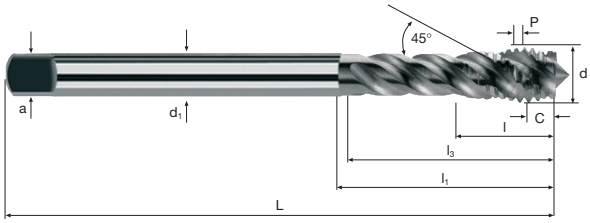
Taps x-tap

UNC | 2B

60° | HSS PM/F

≈DIN 376

X · P Form C



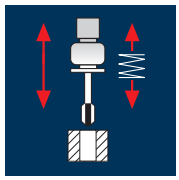
Rm < 850 | **Rm** 850-1100

Example: **Order-N°.** Article-N°. **EH1691** ø-Code **.712**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1691
.712	7/16	-14	11.113	100	15	39	37	8	6.2	3	9.40	●
.713	1/2	-13	12.700	110	18	50	48	9	7.0	3	10.80	●
.714	9/16	-12	14.288	110	20	58	56	11	9.0	3	12.20	●
.715	5/8	-11	15.875	110	20	58	56	12	9.0	3	13.50	●
.716	3/4	-10	19.050	125	25	65	63	14	11.0	4	16.50	●
.717	7/8	-9	22.225	140	25	72	70	18	14.5	4	19.50	●
.718	1”	-8	25.400	160	30	72	70	18	14.5	5	22.30	●

UN

Application



Material	UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic	2	-56	2.184	0.454	10	1455	661	8	1165	529	6	875	397
	3	-48	2.515	0.529	10	1265	669	8	1015	537	6	760	402
	4	-40	2.845	0.635	10	1120	711	8	895	568	6	670	425
	5	-40	3.175	0.635	10	1005	638	8	800	508	6	600	381
	6	-32	3.505	0.794	10	910	723	8	725	576	6	545	433
	8	-32	4.166	0.794	10	765	607	8	610	484	6	460	365
	10	-24	4.826	1.058	10	660	698	8	530	561	6	395	418
	12	-24	5.486	1.058	10	580	614	8	465	492	6	350	370
	1/4	-20	6.350	1.270	10	500	635	8	400	508	6	300	381
Stainless steel ferritc/martensitic	5/16	-18	7.938	1.411	10	400	564	8	320	452	6	240	339
	3/8	-16	9.525	1.588	10	335	532	8	265	421	6	200	318
Stainless steel [Cr-Ni/1.4301]	2	-56	2.184	0.454	6	875	397	4	585	266	3	435	197
	3	-48	2.515	0.529	6	760	402	4	505	267	3	380	201
	4	-40	2.845	0.635	6	670	425	4	450	286	3	335	213
	5	-40	3.175	0.635	6	600	381	4	400	254	3	300	191
	6	-32	3.505	0.794	6	545	433	4	365	290	3	270	214
	8	-32	4.166	0.794	6	460	365	4	305	242	3	230	183
	10	-24	4.826	1.058	6	395	418	4	265	280	3	200	212
	12	-24	5.486	1.058	6	350	370	4	230	243	3	175	185
	1/4	-20	6.350	1.270	6	300	381	4	200	254	3	150	191
Stainless steel [Cr-Ni/1.4301]	5/16	-18	7.938	1.411	6	240	339	4	160	226	3	120	169
	3/8	-16	9.525	1.588	6	200	318	4	135	214	3	100	159

Material	UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel [Cr-Ni-Mo-…/1.4571]	2	-56	2.184	0.454	6	875	397	5	730	331	4	585	266
	3	-48	2.515	0.529	6	760	402	5	635	336	4	505	267
	4	-40	2.845	0.635	6	670	425	5	560	356	4	450	286
	5	-40	3.175	0.635	6	600	381	5	500	318	4	400	254
	6	-32	3.505	0.794	6	545	433	5	455	361	4	365	290
	8	-32	4.166	0.794	6	460	365	5	380	302	4	305	242
	10	-24	4.826	1.058	6	395	418	5	330	349	4	265	280
	12	-24	5.486	1.058	6	350	370	5	290	307	4	230	243
	1/4	-20	6.350	1.270	6	300	381	5	250	318	4	200	254
Stainless steel [Cr-Ni-Mo-…/1.4571]	5/16	-18	7.938	1.411	6	240	339	5	200	282	4	160	226
	3/8	-16	9.525	1.588	6	200	318	5	165	262	4	135	214
Heat resistant steel [17-4 PH]	2	-56	2.184	0.454	4	585	266	3	435	197	2	290	132
	3	-48	2.515	0.529	4	505	267	3	380	201	2	255	135
	4	-40	2.845	0.635	4	450	286	3	335	213	2	225	143
	5	-40	3.175	0.635	4	400	254	3	300	191	2	200	127
	6	-32	3.505	0.794	4	365	290	3	270	214	2	180	143
	8	-32	4.166	0.794	4	305	242	3	230	183	2	155	123
	10	-24	4.826	1.058	4	265	280	3	200	212	2	130	138
	12	-24	5.486	1.058	4	230	243	3	175	185	2	115	122
	1/4	-20	6.350	1.270	4	200	254	3	150	191	2	100	127
Heat resistant steel [17-4 PH]	5/16	-18	7.938	1.411	4	160	226	3	120	169	2	80	113
	3/8	-16	9.525	1.588	4	135	214	3	100	159	2	65	103

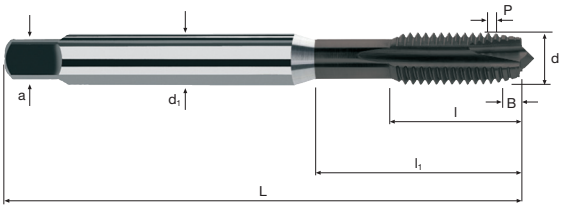
Taps

UNC | 2B

60° | HSS PM/F

≈DIN 371

X · P
Form B



Inox
Stainless

Example:
Order-N°. Article-N°. **ET1620** ø-Code **.701**

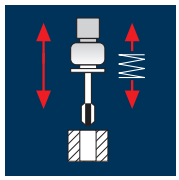
ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TRIBO ET1620
.701	Nr. 2	-56	2.184	45	9	–	2.8	2.1	2	1.90 *	●
.702	Nr. 3	-48	2.515	50	9	–	2.8	2.1	2	2.15 *	●
.703	Nr. 4	-40	2.845	56	12	18.0	3.5	2.7	3	2.40 *	●
.704	Nr. 5	-40	3.175	56	12	18.0	3.5	2.7	3	2.70 *	●
.705	Nr. 6	-32	3.505	56	12	20.0	4.0	3.0	3	2.90 *	●
.706	Nr. 8	-32	4.166	63	13	21.0	4.5	3.4	3	3.50	●
.707	Nr. 10	-24	4.826	70	15	25.0	6.0	4.9	3	4.00 *	●
.708	Nr. 12	-24	5.486	80	17	30.0	6.0	4.9	3	4.60 *	●
.709	1/4	-20	6.350	80	17	30.0	7.0	5.5	3	5.20	●
.710	5/16	-18	7.938	90	20	35.0	8.0	6.2	3	6.70	●
.711	3/8	-16	9.525	100	22	39.0	10.0	8.0	3	8.10	●

* The given dimension is out of norm

For larger dimensions see article no. ET1621, page 309

UN

Application



Material

UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic												
7/16	-14	11.113	1.814	10	285	517	8	230	417	6	170	308
1/2	-13	12.700	1.954	10	250	489	8	200	391	6	150	293
9/16	-12	14.288	2.117	10	225	476	8	180	381	6	135	286
5/8	-11	15.875	2.309	10	200	462	8	160	369	6	120	277
3/4	-10	19.050	2.540	10	165	419	8	135	343	6	100	254
7/8	-9	22.225	2.822	10	145	409	8	115	325	6	85	240
1"	-8	25.400	3.175	10	125	397	8	100	318	6	75	238
Stainless steel [Cr-Ni/1.4301]												
7/16	-14	11.113	1.814	6	170	308	4	115	209	3	85	154
1/2	-13	12.700	1.954	6	150	293	4	100	195	3	75	147
9/16	-12	14.288	2.117	6	135	286	4	90	191	3	65	138
5/8	-11	15.875	2.309	6	120	277	4	80	185	3	60	139
3/4	-10	19.050	2.540	6	100	254	4	65	165	3	50	127
7/8	-9	22.225	2.822	6	85	240	4	55	155	3	45	127
1"	-8	25.400	3.175	6	75	238	4	50	159	3	40	127
Stainless steel [Cr-Ni-Mo-.../1.4571]												
7/16	-14	11.113	1.814	6	170	308	5	145	263	4	115	209
1/2	-13	12.700	1.954	6	150	293	5	125	244	4	100	195
9/16	-12	14.288	2.117	6	135	286	5	110	233	4	90	191
5/8	-11	15.875	2.309	6	120	277	5	100	231	4	80	185
3/4	-10	19.050	2.540	6	100	254	5	85	216	4	65	165
7/8	-9	22.225	2.822	6	85	240	5	70	198	4	55	155
1"	-8	25.400	3.175	6	75	238	5	65	206	4	50	159
Heat resistant steel [17-4 PH]												
7/16	-14	11.113	1.814	4	115	209	3	85	154	2	55	100
1/2	-13	12.700	1.954	4	100	195	3	75	147	2	50	98
9/16	-12	14.288	2.117	4	90	191	3	65	138	2	45	95
5/8	-11	15.875	2.309	4	80	185	3	60	139	2	40	92
3/4	-10	19.050	2.540	4	65	165	3	50	127	2	35	89
7/8	-9	22.225	2.822	4	55	155	3	45	127	2	30	85
1"	-8	25.400	3.175	4	50	159	3	40	127	2	25	79

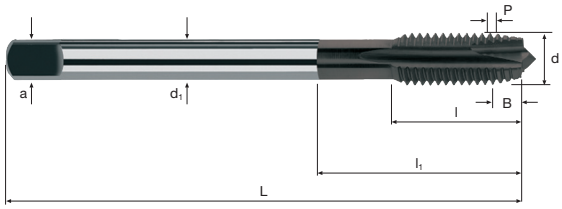
Taps

UNC | 2B

60° | HSS PM/F

≈DIN 376

X · P Form B



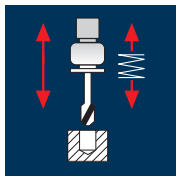
Inox Stainless

Example:
Order-N°. Article-N°. **ET1621** ø-Code **.712**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TRIBO ET1621
.712	7/16	-14	11.113	100	22	39	8	6.2	3	9.50	●
.713	1/2	-13	12.700	110	24	40	9	7.0	3	11.00	●
.714	9/16	-12	14.288	110	26	40	11	9.0	3	12.40	●
.715	5/8	-11	15.875	110	27	40	12	9.0	3	13.80	●
.716	3/4	-10	19.050	125	30	45	14	11.0	4	16.80	●
.717	7/8	-9	22.225	140	32	50	18	14.5	4	19.70	●
.718	1 “	-8	25.400	160	34	50	18	14.5	5	22.60	●

UN

Application



Material	UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic	2	-56	2.184	0.454	8	1165	529	6	875	397	5	730	331
	3	-48	2.515	0.529	8	1015	537	6	760	402	5	635	336
	4	-40	2.845	0.635	8	895	568	6	670	425	5	560	356
	5	-40	3.175	0.635	8	800	508	6	600	381	5	500	318
	6	-32	3.505	0.794	8	725	576	6	545	433	5	455	361
	8	-32	4.166	0.794	8	610	484	6	460	365	5	380	302
	10	-24	4.826	1.058	8	530	561	6	395	418	5	330	349
	12	-24	5.486	1.058	8	465	492	6	350	370	5	290	307
	1/4	-20	6.350	1.270	8	400	508	6	300	381	5	250	318
Stainless steel ferritc/martensitic	5/16	-18	7.938	1.411	8	320	452	6	240	339	5	200	282
	3/8	-16	9.525	1.588	8	265	421	6	200	318	5	165	262
Stainless steel [Cr-Ni/1.4301]	2	-56	2.184	0.454	4	585	266	3	435	197	2	290	132
	3	-48	2.515	0.529	4	505	267	3	380	201	2	255	135
	4	-40	2.845	0.635	4	450	286	3	335	213	2	225	143
	5	-40	3.175	0.635	4	400	254	3	300	191	2	200	127
	6	-32	3.505	0.794	4	365	290	3	270	214	2	180	143
	8	-32	4.166	0.794	4	305	242	3	230	183	2	155	123
	10	-24	4.826	1.058	4	265	280	3	200	212	2	130	138
	12	-24	5.486	1.058	4	230	243	3	175	185	2	115	122
	1/4	-20	6.350	1.270	4	200	254	3	150	191	2	100	127
Stainless steel [Cr-Ni/1.4301]	5/16	-18	7.938	1.411	4	160	226	3	120	169	2	80	113
	3/8	-16	9.525	1.588	4	135	214	3	100	159	2	65	103

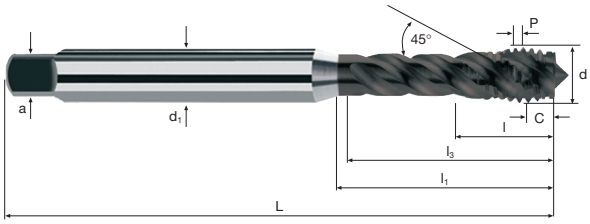
Material	UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel [Cr-Ni-Mo-…/1.4571]	2	-56	2.184	0.454	5	730	331	4	585	266	3	435	197
	3	-48	2.515	0.529	5	635	336	4	505	267	3	380	201
	4	-40	2.845	0.635	5	560	356	4	450	286	3	335	213
	5	-40	3.175	0.635	5	500	318	4	400	254	3	300	191
	6	-32	3.505	0.794	5	455	361	4	365	290	3	270	214
	8	-32	4.166	0.794	5	380	302	4	305	242	3	230	183
	10	-24	4.826	1.058	5	330	349	4	265	280	3	200	212
	12	-24	5.486	1.058	5	290	307	4	230	243	3	175	185
	1/4	-20	6.350	1.270	5	250	318	4	200	254	3	150	191
Stainless steel [Cr-Ni-Mo-…/1.4571]	5/16	-18	7.938	1.411	5	200	282	4	160	226	3	120	169
	3/8	-16	9.525	1.588	5	165	262	4	135	214	3	100	159
Heat resistant steel [17-4 PH]	2	-56	2.184	0.454	3	435	197	2	290	132			
	3	-48	2.515	0.529	3	380	201	2	255	135			
	4	-40	2.845	0.635	3	335	213	2	225	143			
	5	-40	3.175	0.635	3	300	191	2	200	127			
	6	-32	3.505	0.794	3	270	214	2	180	143			
	8	-32	4.166	0.794	3	230	183	2	155	123			
	10	-24	4.826	1.058	3	200	212	2	130	138			
	12	-24	5.486	1.058	3	175	185	2	115	122			
	1/4	-20	6.350	1.270	3	150	191	2	100	127			
Heat resistant steel [17-4 PH]	5/16	-18	7.938	1.411	3	120	169	2	80	113			
	3/8	-16	9.525	1.588	3	100	159	2	65	103			

UNC | 2B

60° | HSS PM/F

DIN 371

X · P Form C



Inox Stainless

Example: **Order-N°.** Article-N°. **ET1690** ø-Code **.701**

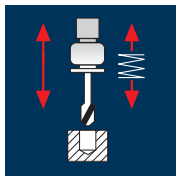
ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TRIBO ET1690
.701	Nr. 2	-56	2.184	45	9	–	12.5	2.8	2.1	3	1.90 *	●
.702	Nr. 3	-48	2.515	50	9	–	13.0	2.8	2.1	3	2.15 *	●
.703	Nr. 4	-40	2.845	56	5	–	16.0	3.5	2.7	3	2.40 *	●
.704	Nr. 5	-40	3.175	56	5	–	16.0	3.5	2.7	3	2.70 *	●
.705	Nr. 6	-32	3.505	56	6	–	18.0	4.0	3.0	3	2.90 *	●
.706	Nr. 8	-32	4.166	63	7	–	19.0	4.5	3.4	3	3.50	●
.707	Nr. 10	-24	4.826	70	8	–	23.0	6.0	4.9	3	4.00 *	●
.708	Nr. 12	-24	5.486	80	10	–	28.0	6.0	4.9	3	4.60 *	●
.709	1/4	-20	6.350	80	10	30.0	28.0	7.0	5.5	3	5.20	●
.710	5/16	-18	7.938	90	13	35.0	33.0	8.0	6.2	3	6.70	●
.711	3/8	-16	9.525	100	15	39.0	37.0	10.0	8.0	3	8.10	●

* The given dimension is out of norm

For larger dimensions see article no. ET1691, page 313

UN

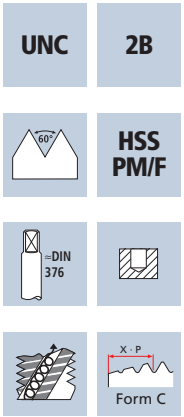
Application

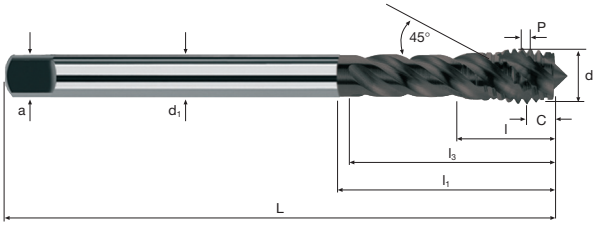


Material

UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic												
7/16	-14	11.113	1.814	8	230	417	6	170	308	5	145	263
1/2	-13	12.700	1.954	8	200	391	6	150	293	5	125	244
9/16	-12	14.288	2.117	8	180	381	6	135	286	5	110	233
5/8	-11	15.875	2.309	8	160	369	6	120	277	5	100	231
3/4	-10	19.050	2.540	8	135	343	6	100	254	5	85	216
7/8	-9	22.225	2.822	8	115	325	6	85	240	5	70	198
1"	-8	25.400	3.175	8	100	318	6	75	238	5	65	206
Stainless steel [Cr-Ni/1.4301]												
7/16	-14	11.113	1.814	4	115	209	3	85	154	2	55	100
1/2	-13	12.700	1.954	4	100	195	3	75	147	2	50	98
9/16	-12	14.288	2.117	4	90	191	3	65	138	2	45	95
5/8	-11	15.875	2.309	4	80	185	3	60	139	2	40	92
3/4	-10	19.050	2.540	4	65	165	3	50	127	2	35	89
7/8	-9	22.225	2.822	4	55	155	3	45	127	2	30	85
1"	-8	25.400	3.175	4	50	159	3	40	127	2	25	79
Stainless steel [Cr-Ni-Mo-…/1.4571]												
7/16	-14	11.113	1.814	5	145	263	4	115	209	3	85	154
1/2	-13	12.700	1.954	5	125	244	4	100	195	3	75	147
9/16	-12	14.288	2.117	5	110	233	4	90	191	3	65	138
5/8	-11	15.875	2.309	5	100	231	4	80	185	3	60	139
3/4	-10	19.050	2.540	5	85	216	4	65	165	3	50	127
7/8	-9	22.225	2.822	5	70	198	4	55	155	3	45	127
1"	-8	25.400	3.175	5	65	206	4	50	159	3	40	127
Heat resistant steel [17-4 PH]												
7/16	-14	11.113	1.814	3	85	154	2	55	100			
1/2	-13	12.700	1.954	3	75	147	2	50	98			
9/16	-12	14.288	2.117	3	65	138	2	45	95			
5/8	-11	15.875	2.309	3	60	139	2	40	92			
3/4	-10	19.050	2.540	3	50	127	2	35	89			
7/8	-9	22.225	2.822	3	45	127	2	30	85			
1"	-8	25.400	3.175	3	40	127	2	25	79			

Taps x-tap





Inox
Stainless

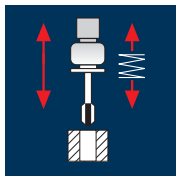
Example:
Order-N°. **ET1691** **.712**

Article-N°. ø-Code

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TRIBO ET1691
.712	7/16	-14	11.113	100	15	39	37	8	6.2	3	9.50	●
.713	1/2	-13	12.700	110	18	50	48	9	7.0	3	11.00	●
.714	9/16	-12	14.288	110	20	58	56	11	9.0	3	12.40	●
.715	5/8	-11	15.875	110	20	58	56	12	9.0	3	13.80	●
.716	3/4	-10	19.050	125	25	65	63	14	11.0	4	16.80	●
.717	7/8	-9	22.225	140	25	72	70	18	14.5	4	19.70	●
.718	1”	-8	25.400	160	30	72	70	18	14.5	5	22.60	●

UN

Application



Material	UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	2	-56	2.184	0.454	18	2625	1192	15	2185	992	13	1895	860
	3	-48	2.515	0.529	18	2280	1206	15	1900	1005	13	1645	870
	4	-40	2.845	0.635	18	2015	1280	15	1680	1067	13	1455	924
	5	-40	3.175	0.635	18	1805	1146	15	1505	956	13	1305	829
	6	-32	3.505	0.794	18	1635	1298	15	1360	1080	13	1180	937
	8	-32	4.166	0.794	18	1375	1092	15	1145	909	13	995	790
	10	-24	4.826	1.058	18	1185	1254	15	990	1047	13	855	905
	12	-24	5.486	1.058	18	1045	1106	15	870	920	13	755	799
	1/4	-20	6.350	1.270	18	900	1143	15	750	953	13	650	826
Unalloyed aluminium	5/16	-18	7.938	1.411	18	720	1016	15	600	847	13	520	734
	3/8	-16	9.525	1.588	18	600	953	15	500	794	13	435	691
Wrought aluminium alloys Si < 6% not hardened	2	-56	2.184	0.454	28	4080	1852	24	3500	1589	20	2915	1323
	3	-48	2.515	0.529	28	3545	1875	24	3040	1608	20	2530	1338
	4	-40	2.845	0.635	28	3135	1991	24	2685	1705	20	2240	1422
	5	-40	3.175	0.635	28	2805	1781	24	2405	1527	20	2005	1273
	6	-32	3.505	0.794	28	2545	2021	24	2180	1731	20	1815	1441
	8	-32	4.166	0.794	28	2140	1699	24	1835	1457	20	1530	1215
	10	-24	4.826	1.058	28	1845	1952	24	1585	1677	20	1320	1397
	12	-24	5.486	1.058	28	1625	1719	24	1395	1476	20	1160	1227
	1/4	-20	6.350	1.270	28	1405	1784	24	1205	1530	20	1005	1276
Wrought aluminium alloys Si < 6% not hardened	5/16	-18	7.938	1.411	28	1125	1587	24	960	1355	20	800	1129
	3/8	-16	9.525	1.588	28	935	1485	24	800	1270	20	670	1064

Material	UNC		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Wrought aluminium alloys Si < 6% hardened	2	-56	2.184	0.454	16	2330	1058	14	2040	926	11	1605	729
	3	-48	2.515	0.529	16	2025	1071	14	1770	936	11	1390	735
	4	-40	2.845	0.635	16	1790	1137	14	1565	994	11	1230	781
	5	-40	3.175	0.635	16	1605	1019	14	1405	892	11	1105	702
	6	-32	3.505	0.794	16	1455	1155	14	1270	1008	11	1000	794
	8	-32	4.166	0.794	16	1225	973	14	1070	850	11	840	667
	10	-24	4.826	1.058	16	1055	1116	14	925	979	11	725	767
	12	-24	5.486	1.058	16	930	984	14	810	857	11	640	677
	1/4	-20	6.350	1.270	16	800	1016	14	700	889	11	550	699
Wrought aluminium alloys Si < 6% hardened	5/16	-18	7.938	1.411	16	640	903	14	560	790	11	440	621
	3/8	-16	9.525	1.588	16	535	850	14	470	746	11	370	588
Unalloyed copper	2	-56	2.184	0.454	17	2480	1126	14	2040	926	12	1750	795
	3	-48	2.515	0.529	17	2150	1137	14	1770	936	12	1520	804
	4	-40	2.845	0.635	17	1900	1207	14	1565	994	12	1345	854
	5	-40	3.175	0.635	17	1705	1083	14	1405	892	12	1205	765
	6	-32	3.505	0.794	17	1545	1227	14	1270	1008	12	1090	865
	8	-32	4.166	0.794	17	1300	1032	14	1070	850	12	915	727
	10	-24	4.826	1.058	17	1120	1185	14	925	979	12	790	836
	12	-24	5.486	1.058	17	985	1042	14	810	857	12	695	735
	1/4	-20	6.350	1.270	17	850	1080	14	700	889	12	600	762
Unalloyed copper	5/16	-18	7.938	1.411	17	680	959	14	560	790	12	480	677
	3/8	-16	9.525	1.588	17	570	905	14	470	746	12	400	635

Taps

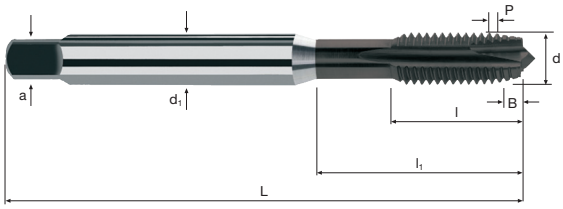
Al

UNC | 2B

60° | HSS PM/F

DIN 371

X · P Form B



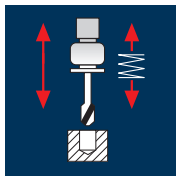
			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	

Example: **Order-N°.** Article-N°. **EI1602** ø-Code **.701**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			INTEGRAL EI1602
.701	Nr. 2	-56	2.184	45	9	–	2.8	2.1	2	1.85	●
.702	Nr. 3	-48	2.515	50	9	–	2.8	2.1	2	2.10	●
.703	Nr. 4	-40	2.845	56	12	18.0	3.5	2.7	2	2.35	●
.704	Nr. 5	-40	3.175	56	12	18.0	3.5	2.7	2	2.65	●
.705	Nr. 6	-32	3.505	56	12	20.0	4.0	3.0	2	2.85	●
.706	Nr. 8	-32	4.166	63	13	21.0	4.5	3.4	2	3.50	●
.707	Nr. 10	-24	4.826	70	15	25.0	6.0	4.9	2	3.90	●
.708	Nr. 12	-24	5.486	80	17	30.0	6.0	4.9	2	4.50	●
.709	1/4	-20	6.350	80	17	30.0	7.0	5.5	2	5.10	●
.710	5/16	-18	7.938	90	20	35.0	8.0	6.2	2	6.60	●
.711	3/8	-16	9.525	100	22	39.0	10.0	8.0	2	8.00	●

UN

Application



Material	UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium	2	-56	2.184	0.454	12	1750	795	10	1455	661	8	1165	529
	3	-48	2.515	0.529	12	1520	804	10	1265	669	8	1015	537
	4	-40	2.845	0.635	12	1345	854	10	1120	711	8	895	568
	5	-40	3.175	0.635	12	1205	765	10	1005	638	8	800	508
	6	-32	3.505	0.794	12	1090	865	10	910	723	8	725	576
	8	-32	4.166	0.794	12	915	727	10	765	607	8	610	484
	10	-24	4.826	1.058	12	790	836	10	660	698	8	530	561
	12	-24	5.486	1.058	12	695	735	10	580	614	8	465	492
	1/4	-20	6.350	1.270	12	600	762	10	500	635	8	400	508
Unalloyed aluminium	5/16	-18	7.938	1.411	12	480	677	10	400	564	8	320	452
	3/8	-16	9.525	1.588	12	400	635	10	335	532	8	265	421
Wrought aluminium alloys Si < 6% not hardened	2	-56	2.184	0.454	12	1750	795	10	1455	661	8	1165	529
	3	-48	2.515	0.529	12	1520	804	10	1265	669	8	1015	537
	4	-40	2.845	0.635	12	1345	854	10	1120	711	8	895	568
	5	-40	3.175	0.635	12	1205	765	10	1005	638	8	800	508
	6	-32	3.505	0.794	12	1090	865	10	910	723	8	725	576
	8	-32	4.166	0.794	12	915	727	10	765	607	8	610	484
	10	-24	4.826	1.058	12	790	836	10	660	698	8	530	561
	12	-24	5.486	1.058	12	695	735	10	580	614	8	465	492
	1/4	-20	6.350	1.270	12	600	762	10	500	635	8	400	508
Wrought aluminium alloys Si < 6% not hardened	5/16	-18	7.938	1.411	12	480	677	10	400	564	8	320	452
	3/8	-16	9.525	1.588	12	400	635	10	335	532	8	265	421

Material	UNC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Wrought aluminium alloys Si < 6% hardened	2	-56	2.184	0.454	10	1455	661	9	1310	595	8	1165	529
	3	-48	2.515	0.529	10	1265	669	9	1140	603	8	1015	537
	4	-40	2.845	0.635	10	1120	711	9	1005	638	8	895	568
	5	-40	3.175	0.635	10	1005	638	9	900	572	8	800	508
	6	-32	3.505	0.794	10	910	723	9	815	647	8	725	576
	8	-32	4.166	0.794	10	765	607	9	690	548	8	610	484
	10	-24	4.826	1.058	10	660	698	9	595	630	8	530	561
	12	-24	5.486	1.058	10	580	614	9	520	550	8	465	492
	1/4	-20	6.350	1.270	10	500	635	9	450	572	8	400	508
Wrought aluminium alloys Si < 6% hardened	5/16	-18	7.938	1.411	10	400	564	9	360	508	8	320	452
	3/8	-16	9.525	1.588	10	335	532	9	300	476	8	265	421
Unalloyed copper	2	-56	2.184	0.454	16	2330	1058	14	2040	926	13	1895	860
	3	-48	2.515	0.529	16	2025	1071	14	1770	936	13	1645	870
	4	-40	2.845	0.635	16	1790	1137	14	1565	994	13	1455	924
	5	-40	3.175	0.635	16	1605	1019	14	1405	892	13	1305	829
	6	-32	3.505	0.794	16	1455	1155	14	1270	1008	13	1180	937
	8	-32	4.166	0.794	16	1225	973	14	1070	850	13	995	790
	10	-24	4.826	1.058	16	1055	1116	14	925	979	13	855	905
	12	-24	5.486	1.058	16	930	984	14	810	857	13	755	799
	1/4	-20	6.350	1.270	16	800	1016	14	700	889	13	650	826
Unalloyed copper	5/16	-18	7.938	1.411	16	640	903	14	560	790	13	520	734
	3/8	-16	9.525	1.588	16	535	850	14	470	746	13	435	691

Taps

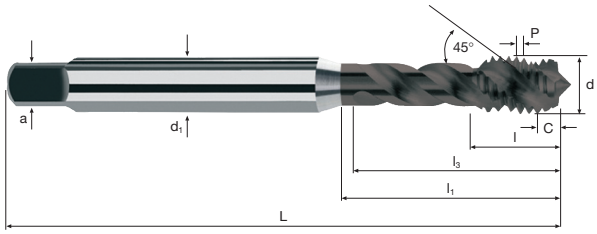
Al

UNC | 2B

60° | HSS PM/F

DIN 371

X · P Form C



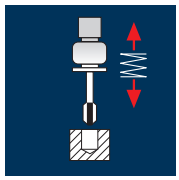
			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	

Example: **Order-N°.** Article-N°. **EI1652** ø-Code **.701**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			INTEGRAL EI1652
.701	Nr. 2	-56	2.184	45	9	–	12.5	2.8	2.1	3	1.85	●
.702	Nr. 3	-48	2.515	50	9	–	13.0	2.8	2.1	3	2.10	●
.703	Nr. 4	-40	2.845	56	5	18.0	16.0	3.5	2.7	3	2.35	●
.704	Nr. 5	-40	3.175	56	5	18.0	16.0	3.5	2.7	3	2.65	●
.705	Nr. 6	-32	3.505	56	6	20.0	18.0	4.0	3.0	3	2.85	●
.706	Nr. 8	-32	4.166	63	7	21.0	19.0	4.5	3.4	3	3.50	●
.707	Nr. 10	-24	4.826	70	8	25.0	23.0	6.0	4.9	3	3.90	●
.708	Nr. 12	-24	5.486	80	10	30.0	28.0	6.0	4.9	3	4.50	●
.709	1/4	-20	6.350	80	10	30.0	28.0	7.0	5.5	3	5.10	●
.710	5/16	-18	7.938	90	13	35.0	33.0	8.0	6.2	3	6.60	●
.711	3/8	-16	9.525	100	15	39.0	37.0	10.0	8.0	3	8.00	●

UN

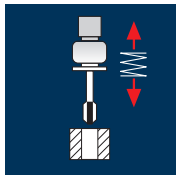
Application



Material

UNJC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
Nickel base alloys not hardened									
4	-40	2.845	0.635	2	225	143	1.5	170	108
6	-32	3.505	0.794	2	180	143	1.5	135	107
8	-32	4.166	0.794	2	155	123	1.5	115	91
10	-24	4.826	1.058	2	130	138	1.5	100	106
1/4	-20	4.350	1.270	2	145	184	1.5	110	140
5/16	-18	7.938	1.411	2	80	113	1.5	60	85
3/8	-16	9.525	1.588	2	65	103	1.5	50	79
Nickel base alloys hardened									
4	-40	2.845	0.635	1.5	170	108	1.5	170	108
6	-32	3.505	0.794	1.5	135	107	1.5	135	107
8	-32	4.166	0.794	1.5	115	91	1.5	115	91
10	-24	4.826	1.058	1.5	100	106	1.5	100	106
1/4	-20	4.350	1.270	1.5	110	140	1.5	110	140
5/16	-18	7.938	1.411	1.5	60	85	1.5	60	85
3/8	-16	9.525	1.588	1.5	50	79	1.5	50	79

Application



Material

UNJC		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
Nickel base alloys not hardened									
4	-40	2.845	0.635	2	225	143	1.5	170	108
6	-32	3.505	0.794	2	180	143	1.5	135	107
8	-32	4.166	0.794	2	155	123	1.5	115	91
10	-24	4.826	1.058	2	130	138	1.5	100	106
1/4	-20	4.350	1.270	2	145	184	1.5	110	140
5/16	-18	7.938	1.411	2	80	113	1.5	60	85
3/8	-16	9.525	1.588	2	65	103	1.5	50	79
Nickel base alloys hardened									
4	-40	2.845	0.635	1.5	170	108	1.5	170	108
6	-32	3.505	0.794	1.5	135	107	1.5	135	107
8	-32	4.166	0.794	1.5	115	91	1.5	115	91
10	-24	4.826	1.058	1.5	100	106	1.5	100	106
1/4	-20	4.350	1.270	1.5	110	140	1.5	110	140
5/16	-18	7.938	1.411	1.5	60	85	1.5	60	85
3/8	-16	9.525	1.588	1.5	50	79	1.5	50	79

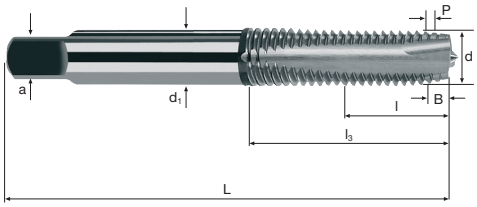
Taps

Ni

UNJC | 3B

60° | HSS PM/F

X · P | Form B



Nickel-Alloys

Example:
Order-N°. Article-N°. **E1699** ø-Code **.703**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			E1699	
.703	Nr. 4	-40	2.845	48	11	–	16	3.5	2.7	3	2.40 *	●	
.705	Nr. 6	-32	3.505	50	12	–	18	4.0	3.0	3	2.90	●	
.706	Nr. 8	-32	4.166	53	13	–	19	4.5	3.4	3	3.60 *	●	
.707	Nr. 10	-24	4.826	58	15	–	22	6.0	4.9	3	4.00	●	
.709	1/4	-20	6.350	66	17	–	28	7.0	5.5	3	5.40 *	●	
.710	5/16	-18	7.938	72	20	–	34	8.0	6.2	3	6.80	●	
.711	3/8	-16	9.525	80	22	–	37	10.0	8.0	3	8.20	●	

* The given dimension is out of norm

UN