

TOLERANCES FOR TAP DIMENSIONS



Element	Nominal Diameter Range in inches		Direction	Tolerance inches
	Over	To (inc.)		
Length Overall - L	.0520	1.0100	Plus or Minus	.031
	1.0100	4.0100	Plus or Minus	.063
Length of Thread - l	.0520	.2230	Plus or Minus	.047
	.2230	.5100	Plus or Minus	.063
	.5100	1.5100	Plus or Minus	.094
	1.5100	4.0100	Plus or Minus	.125
Length of square - l2	.0520	1.0100	Plus or Minus	.031
	1.0100	4.0100	Plus or Minus	.063
Diameter of shank - d1	.0520	.2230	Minus	.0015
	.2230	.6350	Minus	.0015
	.6350	1.0100	Minus	.0020
	1.0100	1.5100	Minus	.0020
	1.5100	2.0100	Minus	.0030
	2.0100	4.0100	Minus	.0030
Size of square - a	.0520	.5100	Minus	.004
	.5100	1.0100	Minus	.006
	1.0100	2.0100	Minus	.008
	2.0100	4.0100	Minus	.010

TOLERANCES FOR SCREW THREADS

It is generally recognized that, in mass production, it is impossible to reproduce in exact detail the theoretically perfect product as laid out on the drawing board. The allowed slight variation between the theoretically perfect product and each unit of the actual product is called the TOLERANCE.

Allowance

An intentional difference in correlated dimensions of mating parts. It is the minimum clearance or maximum interference between such parts.

Angle of Thread

The angle included between the flanks of the thread measured in an axial plane.

Half Angle of Thread

The angle included between a flank of the thread and the normal (90°) to the axis, measured in an axial plane.

Lead of Thread

The distance a screw thread advances axially in one turn. On a single-thread screw the lead and pitch are identical. On a double thread the lead is 2X pitch, on a triple thread the lead is 3X pitch, etc.

Major Diameter

The largest diameter of a straight screw thread.

Minor Diameter

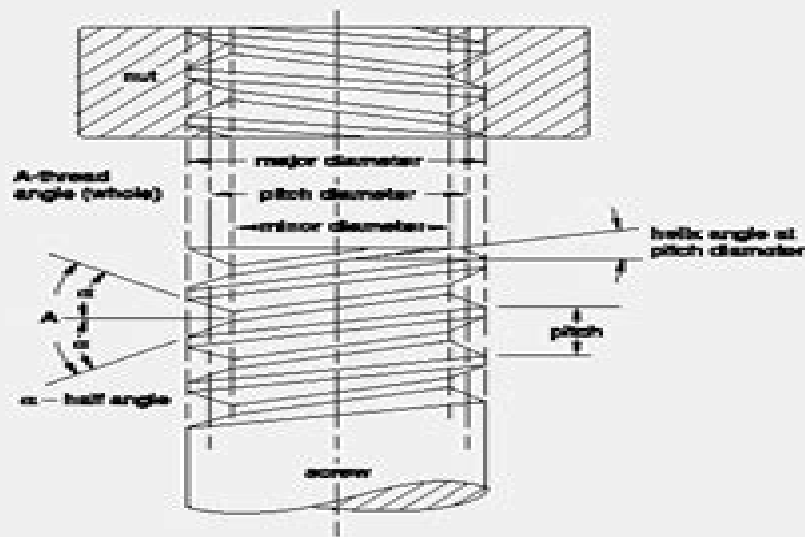
The smallest diameter of a straight screw thread.

Pitch

The distance from a point on a screw thread to a corresponding point on the next thread measured parallel to the axis.

The pitch in inches = $\frac{1}{\text{no. of threads per inch}}$

Screw Thread Tolerances



Greenfield Screw Thread Manual

Roman Wölfel



Greenfield Screw Thread Manual:

Moody's Manual of Railroads and Corporation Securities ,1920 NASA Technical Memorandum ,1976

Moodys Manual of Railroads and Corporation Securities. Government, State and Municipal Supplement ,1921

Exploring the Manual Arts John Frank Friesse,1926 *Machine Design* ,1974 Moody's Manual of Industrial and Miscellaneous Securities ,1922 Manual Arts in the Junior High School, St. Cloud Public Schools John Frank Friesse,1925

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