

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
	.0520	.2230	Minus	.0015
	.2230	.6350	Minus	.0015
Diameter of shank - d1	.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

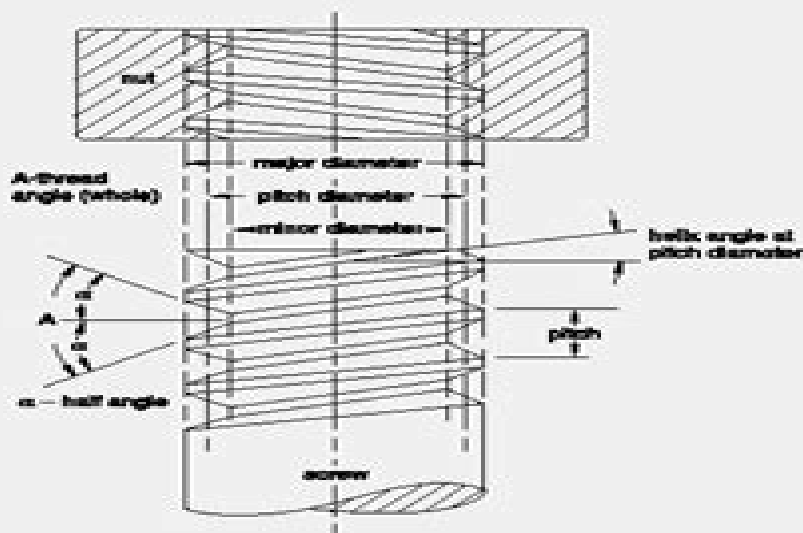
The smallest diameter of a straight screw thread.

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

L Darling-Hammond



Greenfield Screw Thread Manual:

Moody's Manual of Railroads and Corporation Securities ,1920 NASA Technical Memorandum ,1976 Moody's Manual of Railroads and Corporation Securities. Government, State and Municipal Supplement ,1921 **Exploring the Manual Arts** John Frank Frieze,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 Frieze,1925

Information on the Metric System and Related Fields Ernst Lange,Valerie Antoine,1974 Automotive Engineering ,1973-07 American Machinist ,1878 *Catalog of Copyright Entries. Third Series* Library of Congress. Copyright Office,1977 Production Engineering & Management ,1973 **Detroit Engineer** ,1975 **Information on the Metric System and Related Fields** Ernst Lange,1976 **Compressed Air** ,1976 **Poor's Manual of the Railroads of the United States** ,1897 The Economics of Manual Training Louis Rouillion,1905 Ward's Auto World ,1973 Scientific American Reference Book Albert Allis Hopkins,1920 **American Metric Journal** ,1975

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Table of Contents Greenfield Screw Thread Manual

1. Understanding the eBook Greenfield Screw Thread Manual
 - The Rise of Digital Reading Greenfield Screw Thread Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Greenfield Screw Thread Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Greenfield Screw Thread Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Greenfield Screw Thread Manual
 - Personalized Recommendations
 - Greenfield Screw Thread Manual User Reviews and Ratings
 - Greenfield Screw Thread Manual and Bestseller Lists

5. Accessing Greenfield Screw Thread Manual Free and Paid eBooks
 - Greenfield Screw Thread Manual Public Domain eBooks
 - Greenfield Screw Thread Manual eBook Subscription Services
 - Greenfield Screw Thread Manual Budget-Friendly Options
6. Navigating Greenfield Screw Thread Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Greenfield Screw Thread Manual Compatibility with Devices
 - Greenfield Screw Thread Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Greenfield Screw Thread Manual
 - Highlighting and Note-Taking Greenfield Screw Thread Manual
 - Interactive Elements Greenfield Screw Thread Manual
8. Staying Engaged with Greenfield Screw Thread Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Greenfield Screw Thread Manual
9. Balancing eBooks and Physical Books Greenfield Screw Thread Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Greenfield Screw Thread Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Greenfield Screw Thread Manual
 - Setting Reading Goals Greenfield Screw Thread Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Greenfield Screw Thread Manual
 - Fact-Checking eBook Content of Greenfield Screw Thread Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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