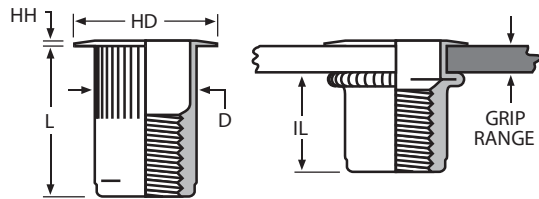


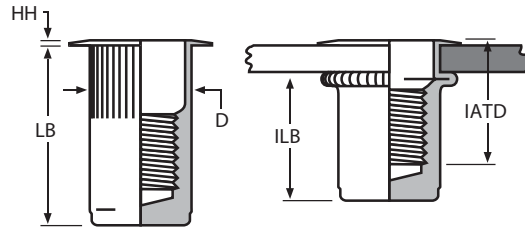
UNIFIED (INCH) AND METRIC THREAD SIZES



OPEN END TYPE



CLOSED END TYPE



Thread Specifications: Unified 2B/21 per ASME B1.1
Metric 6H/21 per ASME B1.13M

THREAD SIZE	THREAD CALL OUT	GRIP RANGE	GRIP CALL OUT	HOLE SIZE +.006 / -.000	HD ±.010 ±.025*	HH ±.003	L ±.015	D MAX.	IL MAX.	LB MAX.	ILB MAX.	IATD** MAX.
6-32 UNC	632	.020 - .080	80	17/64 (.2656)	.390	.030	.420	.265	.305	.755	.640	.610
6-32 UNC	632	.080 - .130	130	17/64 (.2656)	.390	.030	.470	.265	.305	.755	.580	.670
8-32 UNC	832	.020 - .080	80	17/64 (.2656)	.390	.030	.420	.265	.305	.755	.640	.610
8-32 UNC	832	.080 - .130	130	17/64 (.2656)	.390	.030	.470	.265	.305	.755	.580	.670
10-24 UNC	1024	.020 - .130	130	19/64 (.2969)	.415	.030	.475	.296	.315	1.005	.845	.730
10-24 UNC	1024	.130 - .225	225	19/64 (.2969)	.415	.030	.585	.296	.315	1.005	.735	.840
10-32 UNF	1032	.020 - .130	130	19/64 (.2969)	.415	.030	.475	.296	.315	1.005	.845	.730
10-32 UNF	1032	.130 - .225	225	19/64 (.2969)	.415	.030	.585	.296	.315	1.005	.735	.840
1/4-20 UNC	420	.027 - .165	165	25/64 (.3906)	.500	.030	.580	.390	.380	1.205	1.005	.895
1/4-20 UNC	420	.165 - .260	260	25/64 (.3906)	.500	.030	.680	.390	.380	1.205	.905	1.035
5/16-18 UNC	518	.027 - .150	150	17/32 (.5312)	.685*	.035	.690	.530	.470	1.405	1.175	.995
5/16-18 UNC	518	.150 - .312	312	17/32 (.5312)	.685*	.035	.805	.530	.425	1.405	1.025	1.120
3/8-16 UNC	616	.027 - .150	150	17/32 (.5312)	.685*	.035	.690	.530	.470	1.405	1.175	.995
3/8-16 UNC	616	.150 - .312	312	17/32 (.5312)	.685*	.035	.805	.530	.425	1.405	1.025	1.120
1/2-13 UNC	813	.063 - .200	200	11/16 (.6875)	.865*	.047	1.150	.685	.850	2.380	2.070	1.505
1/2-13 UNC	813	.200 - .350	350	11/16 (.6875)	.865*	.047	1.300	.685	.850	2.380	1.920	1.505
1/2-13 UNC	813	.350 - .500	500	11/16 (.6875)	.865*	.047	1.450	.685	.860	2.380	1.770	1.505

THREAD SIZE	THREAD CALL OUT	GRIP RANGE	GRIP CALL OUT	HOLE SIZE +.015 / -.000	HD ±.025 ±.064*	HH ±.008	L ±.038	D MAX.	IL MAX.	LB MAX.	ILB MAX.	IATD** MAX.
M4 x 0,7 ISO	470	0,50 - 2,00	2,0	6,75	9,91	0,76	10,67	6,73	7,75	19,18	16,26	15,49
M4 x 0,7 ISO	470	2,00 - 3,30	3,3	6,75	9,91	0,76	11,94	6,73	7,75	19,18	14,73	17,02
M5 x 0,8 ISO	580	0,50 - 3,30	3,3	7,60	10,54	0,76	12,07	7,52	8,00	25,53	21,46	18,54
M5 x 0,8 ISO	580	3,30 - 5,70	5,7	7,60	10,54	0,76	14,86	7,52	8,00	25,53	18,67	21,34
M6 x 1,0 ISO	610	0,70 - 4,20	4,2	10,00	12,70	0,76	14,73	9,91	9,65	30,61	25,53	22,73
M6 x 1,0 ISO	610	4,20 - 6,60	6,6	10,00	12,70	0,76	17,27	9,91	9,65	30,61	22,99	26,29
M8 x 1,25 ISO	8125	0,70 - 3,80	3,8	13,50	17,40*	0,89	17,53	13,46	11,94	35,69	29,85	25,27
M8 x 1,25 ISO	8125	3,80 - 7,90	7,9	13,50	17,40*	0,89	20,45	13,46	10,80	35,69	26,04	28,45
M10 x 1,5 ISO	1015	0,70 - 3,80	3,8	13,50	17,40*	0,89	17,53	13,46	11,94	35,69	29,85	25,27
M10 x 1,5 ISO	1015	3,80 - 7,90	7,9	13,50	17,40*	0,89	20,45	13,46	10,80	35,69	26,04	28,45
M12 x 1,75 ISO	12175	1,60 - 5,10	5,1	17,45	21,97*	1,19	29,21	17,4	21,59	60,45	52,58	38,23
M12 x 1,75 ISO	12175	5,10 - 8,90	8,9	17,45	21,97*	1,19	33,02	17,4	21,59	60,45	48,77	38,23
M12 x 1,75 ISO	12175	8,90 - 12,7	12,7	17,45	21,97*	1,19	36,83	17,4	21,84	60,45	44,96	38,23

NOTE 1: Grip range can be affected by parent material density and actual hole size. AVK suggests trial installations to determine optimum grip.

NOTE 2: Additional UNF fine threads are available. Contact an AVK Sales Representative for details.

NOTE 3: Additional grip lengths are available. Contact an AVK Sales Representative for details. **Dimensions in minimum grip condition.

PART NUMBERING SYSTEM

SAMPLE NUMBER: ALS3T-420-165

AL	()	()	-()	-()	()																																
PRODUCT SERIES	MATERIAL	FINISH	THREAD CALL OUT	GRIP CALL OUT	TYPE																																
	<table><tr><th>CALL OUT</th><th>GRADE</th></tr><tr><td>S</td><td>Steel 1010/1008</td></tr><tr><td>A</td><td>Aluminum 5056</td></tr><tr><td>B</td><td>Brass 270/260</td></tr><tr><td>M</td><td>Monel 400</td></tr><tr><td>C</td><td>CRES 302</td></tr></table>	CALL OUT	GRADE	S	Steel 1010/1008	A	Aluminum 5056	B	Brass 270/260	M	Monel 400	C	CRES 302	<table><tr><th>CALL OUT</th><th>SPECIFICATION</th></tr><tr><td>3T</td><td>ZINC TRIVALENT PER ASTM-B-633, FE/ZN .0003 (8μ) WITH CLEAR PROTECTIVE COATING</td></tr><tr><td>4T</td><td>YELLOW ZINC TRIVALENT PER ASTM-B-633, FE/ZN .0003 (8μ) WITH CLEAR PROTECTIVE COATING</td></tr><tr><td>9T</td><td>TIN ZINC TRIVALENT PER ESP-P-004, .0003 (8μ) WITH CLEAR PROTECTIVE COATING</td></tr><tr><td colspan="2">Note: For Additional Plating See Chart on Page 46</td></tr></table>	CALL OUT	SPECIFICATION	3T	ZINC TRIVALENT PER ASTM-B-633, FE/ZN .0003 (8μ) WITH CLEAR PROTECTIVE COATING	4T	YELLOW ZINC TRIVALENT PER ASTM-B-633, FE/ZN .0003 (8μ) WITH CLEAR PROTECTIVE COATING	9T	TIN ZINC TRIVALENT PER ESP-P-004, .0003 (8μ) WITH CLEAR PROTECTIVE COATING	Note: For Additional Plating See Chart on Page 46				<table><tr><th>CALL OUT</th><th>TYPE</th></tr><tr><td>BLANK</td><td>Open End</td></tr><tr><td>B</td><td>Closed End</td></tr><tr><td>S</td><td>Sealed (See Pg.18)</td></tr><tr><td>W</td><td>Wedge Head</td></tr></table>	CALL OUT	TYPE	BLANK	Open End	B	Closed End	S	Sealed (See Pg.18)	W	Wedge Head
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For air tool selection see pages 30 and 31