BST GROUP

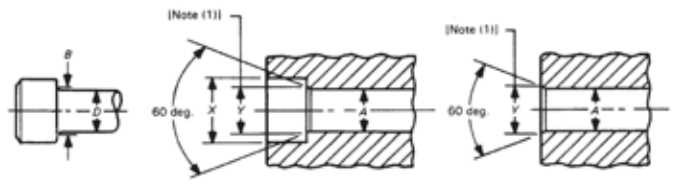
Maximise your productivity

CONVERSION CHART

TECHNICAL
THREAD TABLE

PITCH MM						THREADS PER INCH				
	SIZE		COARSE	FINE	EXTRA FINE	UNC	UN8	UNF	BSW	BSF
M1.6	-	#0	0.35	-	-	-	-	80	-	-
M2	-	#1	0.4	-	-	-	-	72	-	-
-	-	#2	-	-	-	56	-	64	-	-
M2.5	-	#3	0.45	-	-	48	-	56	-	-
-	-	#4	-	-	-	40	-	48	-	-
M3	1/8"	#5	0.5	-	-	40	-	44	40	-
M3.5	-	#6	0.6	-	-	32	-	40	-	-
M4	-	#8	0.7	-	-	32	-	36	-	-
M5	3/16"	#10	0.8	-	-	24	-	32	24	32
-	-	#12	-	-	-	24	-	28	-	-
M6	1/4"	-	1	-	-	20	-	28	20	26
M8	5/16"	-	1.25	1	-	18	-	24	18	22
M10	3/8"	-	1.5	1.25	1	16	-	24	16	20
-	7/16"	-	-	-	-	14	-	20	14	18
M12	1/2"	-	1.75	1.5	1.25	13	-	20	12	16
M14	9/16"	-	2	1.5	-	12	-	18	12	16
M16	5/8"	-	2	1.5	-	11	-	18	11	14
M18	-	-	2.5	1.5	-	-	-	-	-	-
M20	3/4"	-	2.5	1.5	-	10	-	16	10	12
M22	7/8"	-	2.5	1.5	-	9	-	14	9	11
M24	1"	-	3	2	-	8	8	12 (14)	8	10
M27	1 1/8"	-	3	2	-	7	8	12	7	9
M30	1 1/4"	-	3.5	2	-	7	8	12	7	9
M33	1 3/8"	-	3.5	2	-	6	8	12	6	8
M36	1 1/2"	-	4	3	-	6	8	12	6	8
M39	1 5/8"	-	4	3	-	-	8	-	5	8
M42	-	-	4.5	-	-	-	-	-	-	-
M45	1 3/4"	-	4.5	-	-	5	8	-	5	7
M48	1 7/8"	-	5	-	-	-	8	-	-	-
M52	2"	-	5	-	-	4.5	8	-	4.5	7
M56	2 1/4"	-	5.5	-	-	4.5	8	-	4	6
M60	-	-	5.5	-	-	-	-	-	-	-
M64	2 1/2"	-	6	-	-	4	8	-	4	6
M72	2 3/4"	-	6	-	-	4	8	-	3.5	6
M80	3"	-	6	-	-	4	8	-	3.5	5
-	3 1/4"	-	-	-	-	4	8	-	3.25	5
M90	3 1/2"	-	6	-	-	4	8	-	3.25	4.5
-	3 3/4"	-	-	-	-	4	8	-	3	4.5
M100	4"	-	6	-	-	4	8	-	3	4.5

DRILL AND COUNTERBORE SIZES FOR METRIC SOCKET HEAD CAP SCREWS



NOMINAL SIZE OR BASIC SCREW DIAMETER	A		X	Y
	NOMINAL DRILL SIZE		COUNTERBORE DIAMETER	COUNTERSINK DIAMETER
	CLOSE FIT	NORMAL FIT		
M1.6	1.80	1.95	3.50	2.0
M2	2.20	2.40	4.40	2.6
M2.5	2.70	3.00	5.40	3.1
M3	3.40	3.70	6.50	3.6
M4	4.40	4.80	8.25	4.7
M5	5.40	5.80	9.75	5.7
M6	6.40	6.80	11.25	6.8
M8	8.40	8.80	14.25	9.2
M10	10.50	10.80	17.25	11.2
M12	12.50	12.80	19.25	14.2
M14	14.50	14.75	22.25	16.2
M16	16.50	16.75	25.50	18.2
M20	20.50	20.75	31.50	22.4
M24	24.50	24.75	37.50	26.4
M30	30.75	31.75	47.50	33.4
M36	37.00	37.50	56.50	39.4
M42	43.00	44.00	66.00	45.6
M48	49.00	50.00	75.00	52.6

THREAD
CONVERSION CHART

INCH SERIES			METRIC			
SIZE	DIA. (IN)	TPI	SIZE	DIA. (IN)	PITCH (MM)	TPI (APPROX)
#0	0.06	80				
			M1.6	0.063	0.35	74
#1	0.07	64				
			M2	0.079	0.4	64
#2	0.09	56				
			M2.5	0.098	0.45	56
#3	0.10	48				
#4	0.11	40				
			M3	0.118	0.5	51
#5	0.13	40				
#6	0.14	32				
			M4	0.157	0.7	36
#8	0.16	32				
#10	0.19	24				
			M5	0.196	0.8	32
			M6	0.236	1.00	25
1/4	0.25	20				
5/16	0.31	18				
			M8	0.315	1.25	20
3/8	0.38	16				
			M10	0.393	1.5	17
7/16	0.44	14				
			M12	0.472	1.75	14.5
1/2	0.50	13				
			M14	0.551	2	12.5
5/8	0.63	11				
			M16	0.63	2	12.5
3/4	0.75	10				
			M20	0.787	2.5	10
7/8	0.88	9				
			M24	0.945	3	8.5
1	1.00	8				
			M27	1.063	3	8.5

TECHNICAL
UNIT CONVERSION TABLE

CONVERT FROM	CONVERT TO	MULTIPY BY
LENGTH & MASS UNITS		
INCH	MM	25.4
OUNCE (OZ)	GRAM (G)	28.34952
POUND	KILOGRAM (KG)	0.4535924
UK TON	TONNE (1000KG)	1.01605
PRESSURE & FORCE UNITS		
POUND FORCE/INCH² (PSI)	MEGA-PASCAL (MPA)	0.00689
KSI	MPA	6.89
KSI	PSI	1000
MEGA-PASCAL (MPA)	POUND FORCE/INCH² (PSI)	145
POUND FORCE/INCH² (PSI)	KG/MM²	0.000703
KG/MM²	POUND FORCE/INCH² (PSI)	1422.5
POUND/INCH² (PSI)	TON/INCH² (TSI)	0.000446
TON FORCE/INCH²(TSI)	POUND FORCE/INCH² (PSI)	2240
TON-FORCE (TONF)	POUND-FORCE (LBF)	2240
POUND-FORCE (LBF)	KILO-NEWTON (KN)	0.00445
KILO-NEWTON (KN)	POUND-FORCE (LBF)	224.8
TORQUE UNITS		
POUND FORCE FOOT (LBF.FT)	NEWTON-METRE (NM)	1.35582
NEWTON-METRE (NM)	POUND FORCE-FOOT (LBF.FT)	0.737562
POUND FORCE-INCH (LBF.IN)	NEWTON-METRE (NM)	0.113
NEWTON-METRE (NM)	POUND FORCE-INCH (LBF.IN)	8.851
AREA & VOLUME UNITS		
HECTARE	ACRES	2.471
SQUARE METRE (M²)	SQUARE FEET (FT²)	10.764
SQUARE FEET (FT²)	SQUARE METRE (M²)	0.092903
SQUARE INCH (IN²)	SQUARE MM (MM²)	645.16
LITRE	US GALLON	0.264172
POWER & HEAT UNITS		
HORSEPOWER	KILOWATT	0.746
CELSIUS (TC)	FAHRENHEIT (TF)	TF=1.8TC+32

INCH ROCKWELL - BRINELL - TENSILE CONVERSION

ROCKWELL "C" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. 1000PSI	ROCKWELL "C" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. 1000PSI	ROCKWELL "C" SCALE	ROCKWELL "B" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. 1000PSI
60	654	336	43	408	200	26		259	123
59	634	328	42	398	194	25		253	120
58	615	319	41	387	188	24		247	118
57	595	310	40	377	181	23		241	115
56	577	301	39	367	176	22	100	235	112
55	560	292	38	357	170	21	99	230	110
54	543	283	37	347	165	20	98	225	107
53	524	274	36	337	160	(19)		220	104
52	512	265	35	327	155	(18)	97	215	103
51	500	257	34	318	150	(17)		210	102
50	488	249	33	309	147	(16)	96	206	100
49	476	241	32	301	142	(15)		201	99
48	464	233	31	294	139	(14)	95	197	97
47	453	225	30	285	136	(13)	94	193	96
46	442	219	29	279	132	(12)	93	190	93
45	430	212	28	272	129	(11)		186	91
44	419	206	27	265	126	(10)	92	183	90

METRIC ROCKWELL - BRINELL - TENSILE CONVERSION

ROCKWELL "C" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. MPA	ROCKWELL "C" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. MPA	ROCKWELL "C" SCALE	ROCKWELL "B" SCALE	BRINELL HARDNESS NUMBER	TENSILE STRENGTH APPROX. MPA
60	654	2317	43	408	1379	26		259	848
59	634	2261	42	398	1338	25		253	827
58	615	2199	41	387	1296	24		247	814
57	595	2137	40	377	1248	23		241	793
56	577	2075	39	367	1213	22	100	235	772
55	560	2013	38	357	1172	21	99	230	758
54	543	1951	37	347	1138	20	98	225	738
53	524	1889	36	337	1103	(19)		220	717
52	512	1827	35	327	1069	(18)	97	215	710
51	500	1772	34	318	1034	(17)		210	703
50	488	1717	33	309	1014	(16)	96	206	690
49	476	1662	32	301	979	(15)		201	683
48	464	1606	31	294	958	(14)	95	197	669
47	453	1551	30	285	938	(13)	94	193	662
46	442	1510	29	279	910	(12)	93	190	641
45	430	1462	28	272	889	(11)		186	627
44	419	1420	27	265	869	(10)	92	183	621