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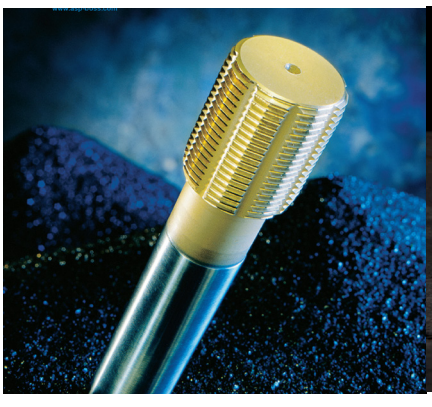
TAPS for NUT

Contents

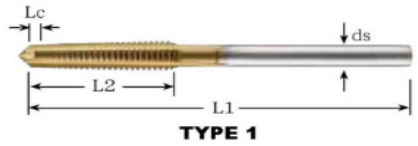


TiN Nut Taps

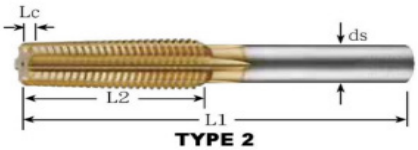
For Carbon Steel

Metric Size

1. Nut taps are used to tap nuts. They are individually designed to fit nut's characteristic and tapping machine, and to enhance the precision of nuts, longer service life of nut taps can also save the costs.
2. Best recommendation of nut's material: Carbon steel code by S8C(1008), S10C(1010), S25C, S35C, S45C.



TYPE 1



TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
M3x0.5	4	1	58	26	13	2.3
	5					
	6					
	7					
	8					
M4x0.7	5	1	58	26	18.2	3.0
	6					
	7					
	8					
	9					
M5x0.8	5	1	62	26	20.8	3.8
	6					
	7					
	8					
	9					
M6x1.0	5	1	67	26	26	4.5
	6					
	7					
	8					
	9					
M7x1.0	6	1	70	26	26	5.6
	7					
	8					
M8x1.25	6	2	77	26	32.5	6.05
	7					
	8					
	9					
	10					
M8x1.0	6	2	77	26	26	6.4
	7					
	8					
	9					
	10					
M10x1.5	6	2	89	26	39	8.0
	7					
	8					
	9					
	10					

Size	GH	Type	L_1	Thread	L_2	ds
M10x1.25	6	2	89	26	32.5	8.1
	7					
	8					
	9					
	10					
M10x1.0	6	2	89	26	26	8.4
	7					
	8					
M12x1.75	6	2	102	26	45.5	9.5
	7					
	8					
	9					
	10					
M12x1.5	6	2	102	26	39	9.8
	7					
	8					
	9					
	10					
M12x1.25	6	2	102	26	32.5	10.0
	7					
	8					
	9					
	10					
M14x2.0	6	2	114	26	52	11.2
	7					
	8					
	9					
	10					
M14x1.5	6	2	114	26	39	11.2
	7					
	8					
	9					
	10					
M16x2.0	6	2	127	26	52	13.1
	7					
	8					
	9					
	10					

TiN Nut Taps

For Carbon Steel

Metric Size

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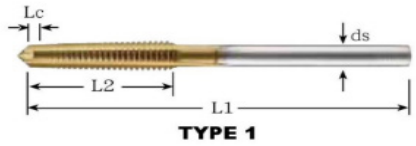
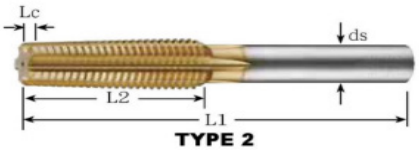


TYPE 1



TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
M16x1.5	6 7 8	2	127	26	39	13.1
M18x2.5	7 8 9 10 11	2	133	26	65	14.5
M18x2.0	8 9 10	2	133	26	52	15
M18x1.5	7 8 9 10 11	2	133	26	39	15
M20x2.5	8 9 10 11 12	2	133	26	65	16.5
M20x2.0	8 9 10	2	133	26	65	16.5
M20x1.5	8 9 10 11 12	2	133	26	39	16.5
M22x2.5	8 9 10 11 12	2	146	26	65	17.5
M22x2.0	8 9 10	2	146	26	52	19

Size	GH	Type	L_1	Thread	L_2	ds
M24x3.0	8 9 10 11 12	2	165	26	78	18.5
M24x2.0	8 9 10 11 12	2	165	26	52	20
M24x1.5	8 9 10 11 12	2	165	26	39	21.5

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

TiN Nut Taps

For Carbon Steel

US Thread

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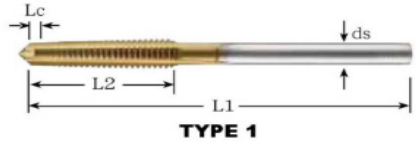
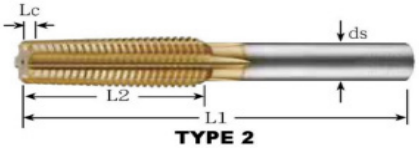


TYPE 1



TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
4-40UNC	5	1	58	26	16.5	2.0
	6					
5-40UNC	5	1	58	26	16.5	2.2
	6					
5-44UNF	5	1	58	26	15	2.2
	6					
6-32UNC	5	1	60	26	20.6	2.4
	6					
6-40UNF	5	1	60	26	16.5	2.6
	6					
8-32UNC	5	1	60	26	20.6	3.2
	6					
8-36UNF	5	1	60	26	18.3	3.2
	6					
10-24UNC	5	1	69	26	27.5	3.4
	6					
10-32UNF	5	1	69	26	20.6	3.7
	6					
12-24UNC	5	1	69	26	27.5	4.0
	6					
12-28UNF	5	1	69	26	23.6	4.2
	6					
1/4-20UNC	5	1	72	26	33	4.6
	6					
	7					
	8					
1/4-28UNF	5	1	72	26	23.6	5.0
	6					
	7					
	8					
5/16-18UNC	5	2	77	26	36.7	6.0
	6					
	7					
	8					
5/16-24UNF	5	2	77	26	27.5	6.3
	6					
	7					
	8					

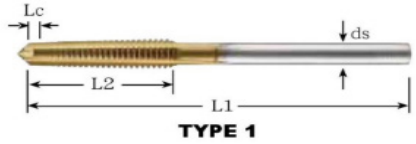
Size	GH	Type	L_1	Thread	L_2	ds
3/8-16UNC	6	2	89	26	41.3	7.3
	7					
	8					
	9					
3/8-24UNF	6	2	89	26	27.5	8.0
	7					
	8					
	9					
7/16-14UNC	6	2	102	26	47.2	8.6
	7					
	8					
	9					
7/16-20UNF	6	2	102	26	33	9.3
	7					
	8					
	9					
1/2-13UNC	7	2	102	26	50.8	10.0
	8					
	9					
1/2-20UNF	6	2	102	26	33	10.9
	7					
	8					
9/16-18UNF	8	2	114	26	36.7	11.4
	9					
5/8-11UNC	9	2	127	26	60	12.8
	10					
5/8-18UNF	8	2	127	26	36.7	13.1
	9					
3/4-10UNC	9	2	133	26	66	15
	10					
3/4-16UNF	8	2	133	26	41.3	15
	9					
7/8-9UNC	9	2	146	26	73.4	17
	10					
7/8-14UNF	8	2	146	26	47.2	18
	9					
1-12UNF	9	2	165	26	55	21
	10					

TiN Nut Taps

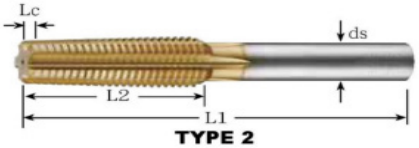
For Carbon Steel

BSW Thread (Brithish Whitworth)

1. Nut taps are used to tap nuts. They are individually designed to fit nut's characteristic and tapping machine, and to enhance the precision of nuts, longer service life of nut taps can also save the costs.
2. Best recommendation of nut's material: Carbon steel code by S8C(1008), S10C(1010), S25C, S35C, S45C.



TYPE 1



TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
W3/16-24	5	1	69	26	27.5	3.2
	6					
	7					
	8					
W1/4-20	5	1	72	26	33	4.6
	6					
	7					
	8					
W5/16-18	5	2	77	26	36.7	6.0
	6					
	7					
	8					
W3/8-16	6	2	89	26	41.3	7.3
	7					
	8					
	9					
W7/16-14	6	2	102	26	47.2	8.6
	7					
	8					
	9					
W1/2-12	7	2	102	26	55	9.5
	8					
	9					
	10					

Size	GH	Type	L_1	Thread	L_2	ds
W9/16-12	8	2	114	26	55	10.5
	9					
	10					
W5/8-11	9	2	127	26	60	12
	10					
	11					
W3/4-10	9	2	133	26	66	15
	10					
	11					
W7/8-9	9	2	146	26	73.4	17
	10					
	11					
W1"-8	9	2	165	26	82.6	20
	10					
	11					

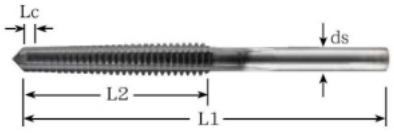
※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

TiCN Nut Taps

For Stainless Steel

Metric Thread

1. Nut taps are used to tap nuts. They are individually designed to fit nut's characteristic and tapping machine, and to enhance the precision of nuts, longer service life of nut taps can also save the costs.
2. Best recommendation of nut's material: Stainless steel 304, 316, 430



TYPE 1

TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
M3x0.5	4 5 6	1	58.7	30	15	2.3
M4x0.7	5 6 7	1	58.2	30	21	3.0
M5x0.8	5 6 7	1	62.8	30	24	3.8
M6x1.0	6 7 8	1	67.5	30	30	4.5
M7x1.0	6 7 8	1	70	30	30	5.6
M8x1.25	7 8 9	2	85	30	30	6.05
M8x1.0	6 7 8	2	77	30	30	6.4
M10x1.5	7 8 9	2	95	30	30	7.8
M10x1.25	6 7 8	2	89	30	30	8.1
M10x1.0	6 7	2	89	30	30	8.4
M12x1.75	7 8 9	2	102	30	30	9.5
M12x1.5	6 7 8	2	102	30	30	9.8
N12x1.25	6 7	2	102	30	30	10.1
M12x1.0	6 7	2	102	30	30	10.5

Size	GH	Type	L_1	Thread	L_2	ds
M14x2.0	7 8 9	2	114	30	60	11.2
M14x1.5	7 8 9	2	114	30	45	11.2
M16x2.0	7 8 9	2	127	30	60	13.1
M16x1.5	7 8 9	2	127	30	45	13.1
M18x2.5	9 10 11	2	133	30	75	14.0
M18x2.0	9 10 11	2	133	30	60	15.0
M20x2.5	9 10 11	2	133	30	75	15.5
M20x2.0	9 10 11	2	133	30	60	16.5
M20x1.5	8 9 10	2	133	30	45	16.5
M22x2.5	9 10 11	2	146	30	75	16.5
M22x2.0	9 10	2	146	30	60	19.0
M24x3.0	9 10 11	2	165	30	90	18.5
M24x2.0	9 10	2	165	30	60	20.0
M24x1.5	9 10	2	165	30	45	21.5

TiCN Nut Taps

For Stainless Steel

US Thread

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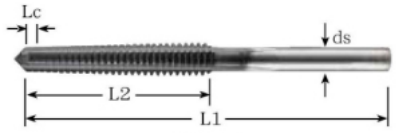

TYPE 1

TYPE 2

Size	GH	Type	L_1	Thread	L_2	ds
4-40UNC	4	1	58.8	30	19.1	2.0
	5					
4-48UNC	4	1	58.8	30	15.9	2.0
	5					
5-40UNC	4	1	58.6	30	19.1	2.2
	5					
5-44UNF	4	1	58.6	30	17.3	2.2
	5					
6-32UNC	5	1	60.5	30	23.8	2.4
	6					
6-40UNF	4	1	60.5	30	19.1	2.6
	5					
8-32UNC	5	1	60.2	30	23.8	3.1
	6					
8-36UNF	5	1	60.2	30	21.2	3.1
	6					
10-24UNC	5	1	69	30	31.7	3.4
	6					
10-32UNF	5	1	69	30	23.8	3.7
	6					
12-24UNC	5	1	69.5	30	31.7	4.0
	6					
12-28UNF	5	1	69.5	30	27.2	4.2
	6					
1/4-20UNC	5	1	72.4	30	38.1	4.5
	6					
	7					
1/4-28UNF	5	1	71.9	30	27.2	5.0
	6					
5/16-18UNC	6	2	80	30	42.3	6.0
	7					
	8					
5/16-24UNF	6	2	80	30	31.7	6.3
	7					
3/8-16UNC	6	2	89	30	47.6	7.3
	7					
	8					

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Size	GH	Type	L_1	Thread	L_2	ds
3/8-16UNF	6	2	89	30	31.7	8
	7					
7/16-14UNC	6	2	102	30	54.4	8.6
	7					
	8					
7/16-20UNF	6	2	102	30	38.1	9.3
	7					
1/2-13UNC	8	2	102	30	58.6	10
	9					
	10					
1/2-20UNF	7	2	102	30	38.1	10.9
	8					
9/16-12UNC	8	2	114	30	63.5	11
	9					
	10					
9/16-18UNF	8	2	114	30	42.3	11.4
	9					
	10					
5/8-11UNC	9	2	127	30	69.3	12.8
	10					
	11					
5/8-18UNF	8	2	127	30	42.3	13.1
	9					
	10					
3/4-10UNC	9	2	133	30	76.2	15
	10					
	11					
3/4-16UNF	8	2	133	30	47.6	15
	9					
7/8-9UNC	9	2	146	30	84.7	17
	10					
	11					
7/8-14UNF	8	2	146	30	54.4	18.5
	9					
1-8UNC	10	2	165	30	95.3	20
	11					
1-12UNF	9	2	165	30	63.5	21
	10					

TiCN Nut Taps

For Stainless Steel

BSW Thread (Brithish Whitworth)

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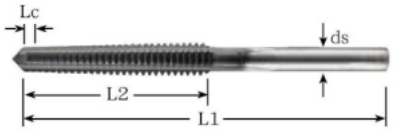


TYPE 1

Size	GH	Type	L_1	Thread	L_2	ds
W3/16-24	5	1	69	30	31.7	3.2
	6					
	7					
W1/4-20	5	1	72.4	30	38.1	4.5
	6					
	7					
W5/16-18	5	2	80	30	42.3	6.0
	6					
	7					
W3/8-16	6	2	89	30	47.6	7.3
	7					
	8					
W7/16-14	6	2	102	30	54.4	8.6
	7					
	8					
W1/2-12	7	2	102	30	63.5	9.5
	8					
	9					

TYPE 2

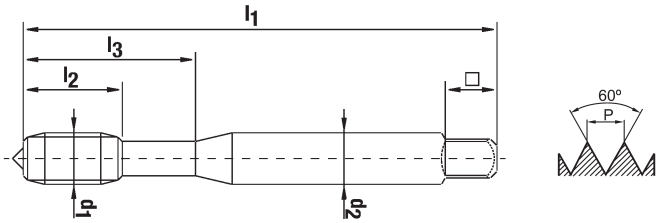
Size	GH	Type	L_1	Thread	L_2	ds
W9/16-12	6	2	114	30	63.5	10.5
	7					
	8					
W5/8-11	6	2	127	30	69.3	12
	10					
	11					
W3/4-10	6	2	133	30	76.2	15
	10					
	11					
W7/8-9	6	2	146	30	84.7	17
	10					
	11					
W1"-8	8	2	165	30	95.3	20
	11					
	12					

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Spiral Point Taps

TIN Coating

Metric Size



Size		L_1	L_2	L_3	d_2	□
M2x0.4	OH2	41	8.8	13.8	3.0	2.5
	OH3					
M2.5x0.45	OH2	45	10	17.8	3.0	2.5
	OH3					
M2.6x0.45	OH2	45	10	17.8	3.0	2.5
	OH3					
M3x0.5	OH2	47	8.2	19.2	4.0	3.2
	OH3					
M3.5x0.6	OH2	48	8.4	19.4	4.0	3.2
	OH3					
M4x0.7	OH2	54	9.6	22.6	5.0	4.0
	OH3					
	OH4					
M5x0.8	OH3	62	12	27	5.5	4.5
	OH4					
	OH5					
	OH6					
M6x1.0	OH3	62	12	30	6.0	4.5
	OH4					
	OH5					
	OH6					
	OH7					
	OH8					
M6x0.75	OH3	62	12	30	6	4.5
M8x1.25	OH3	70	15	32	6.2	5.0
	OH4					
	OH5					
	OH6					
	OH7					
	OH8					
M8x1.0	OH3	70	15	32	6.2	5.0
	OH4					
M10x1.5	OH4	75	18	40	7.0	5.5
	OH5					
	OH6					
	OH7					
M10x1.0	OH3	75	18	40	7	5.5
	OH4					

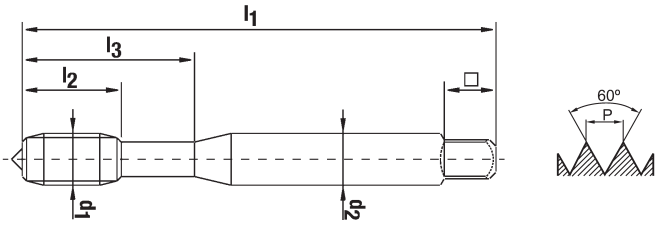
Size		L_1	L_2	L_3	d_2	□
M10x1.25	OH3	75	18	40	7	5.5
	OH4					
M12x1.75	OH5	82	21	42	8.5	6.5
	OH6					
	OH7					
M12x1.5	OH4	82	18	42	8.5	6.5
	OH5					
M12x1.25	OH4	82	18	42	8.5	6.5
	OH5					
M12x1.0	OH4	82	18	42	8.5	6.5
M14x2.0	OH5	88	24	49	10.5	8.0
	OH6					
M14x1.5	OH4	88	18	49	10.5	8.0
	OH5					
M16x2.0	OH5	95	24	48	12.5	10.0
	OH6					
M16x1.5	OH4	95	18	48	12.5	10.0
	OH5					
M18x2.5	OH5	100	25	54	14.0	11.0
	OH6					
M18x1.5	OH4	100	20	54	14	11.0
	OH5					
M20x2.5	OH5	105	25	50	15	12.0
	OH6					
M20x1.5	OH4	105	24	50	15	12.0
	OH5					
M22x2.5	OH5	115	25	55	17.0	13.0
	OH6					
M22x1.5	OH4	115	24	55	17	13.0
	OH5					
M24x3.0	OH5	120	30	60	19.0	15.0
	OH6					
M24x1.5	OH4	120	24	60	19	15.0
	OH5					
M27x3.0	OH5	130	30	67.5	20	15.0
M27x1.5	OH4	130	24	67.5	20	15.0

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Spiral Point Taps

TIN Coating

US Thread ANSI B1.1



Size		L_1	L_2	L_3	d_2	□
4-40 UNC	OH2	45	8.2	19.2	3.0	2.5
6-32 UNC	OH2	49	8.4	19.4	4.0	3.2
8-32 UNC	OH2	54	9.6	22.6	5.0	4.0
10-24 UNC	OH2	62	12.0	27.0	5.5	4.5
12-24 UNC	OH2	62	12.0	30.0	5.5	4.5
1/4-20 UNC	OH3	62	12.0	30.0	6.0	4.5
	OH4					
5/16-18 UNC	OH3	70	15.0	31.8	6.1	5.0
	OH4					
3/8-16 UNC	OH3	75	18.0	38.1	7.0	5.5
	OH4					
7/16-14 UNC	OH3	80	21.0	38.9	8.0	6.0
1/2-13 UNC	OH3	85	21.0	44.4	9.0	7.0
5/8-11 UNC	OH3	95	24.0	47.6	12.0	9.0
3/4-10 UNC	OH3	105	25.0	47.6	14.0	11.0
7/8-9 UNC	OH4	115	25.0	55.6	17.0	13.0
1"-8 UNC	OH4	125	30.0	63.5	20.0	15.0

Size		L_1	L_2	L_3	d_2	□
4-48 UNF	OH2	45	8.2	19.2	3.0	2.5
6-40 UNF	OH2	49	11.4	19.4	4.0	3.2
8-36 UNF	OH2	54	13.7	22.6	5.0	4.0
10-32 UNF	OH2	62	13.9	27.0	5.5	4.5
12-28 UNF	OH2	62	12.0	30.0	5.5	4.5
1/4-28 UNF	OH3	62	12.0	30.0	6.0	4.5
5/16-24 UNF	OH3	70	15.0	31.8	6.1	5.0
3/8-24 UNF	OH3	75	18.0	38.1	7.0	5.5
7/16-20 UNF	OH3	80	18.0	38.9	8.0	6.0
1/2-20 UNF	OH3	85	18.0	44.4	9.0	7.0

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Calculated

$$\text{Drill hole dia} = d - 2 \times H1 \times \left(\frac{\text{Percentage of thread engagement}}{100}\right)$$

d= Basic major dia of extenrnal H1=Basic height of thread engagement

$$\text{Percentage of thread engagement} = \frac{\text{(Basic major dia)-(drill hole dia)}}{2 \times H1} \times 100$$

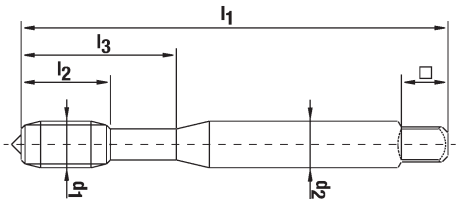
H1=Metric&unified thread 0.5413P
Whitworth thread 0.6403P
P=Pitch

Forming Taps

TIN Coating **(Standard Thread)**

1. No chips generated during tapping.
2. The machining surface of internal thread is roeled surface featuring smooth and pretty appearance.
3. The structure of material is not destroyed, that increases thread strength by 30% with consistent accuracy.
4. Greater core diameter of forming taps results in increased durability and torque. Longer service life of taps and not easy to break.

B (K9777) : For blind holes (Chamfer: 2 thread)
P (K9666) : For through holes (Chamfer: 4 thread)



Metric Thread

Size	GH	LC	L_1	L_2	d2
M2x0.4	3	B/P	40	8	3.0
	4				
	5				
M2.5x0.45	4	B/P	44	10	3.0
	5				
	6				
M3x0.5	5	B/P	46	10	4.0
	6				
	7				
	8				
M4x0.7	5	B/P	52	10	5.0
	6				
	7				
	8				
M5x0.8	6	B/P	60	11	5.5
	7				
	8				
	9				
M6x1.0	6	B/P	62	12	6.0
	7				
	8				
	9				
M8x1.25	6	B/P	70	18	6.2
	7				
	8				
	9				
M10x1.5	7	B/P	75	19	7.0
	8				
	9				
M12x1.75	7	B/P	82	23	8.5
	8				
	9				
M14x2.0	9	B/P	10.5	25	10.5
	10				
M16x2.0	9	B/P	95	27	12.5
	10				

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

US Thread ANSI B1.1

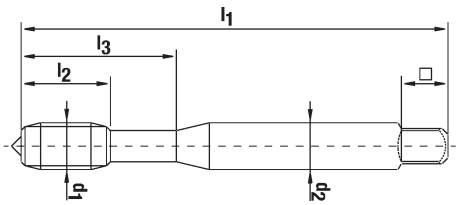
Size	GH	LC	L_1	L_2	d2
2-56 UNC	4	B/P	42	8	3.0
4-40UNC	4	B/P	44	9	3.0
6-32 UNC	5	B/P	48	10	4.0
	6				
8-32 UNC	5	B/P	52	10	5.0
	6				
10-24 UNC	5	B/P	60	11	5.5
	6				
	7				
10-32 UNF	5	B/P	60	11	5.5
	6				
	7				
12-24 UNC	5	B/P	60	11	5.5
	6				
	7				
1/4-20 UNC	6	B/P	62	14	6.0
	7				
	8				
1/4-28 UNF	5	B/P	62	14	6.0
	6				
	7				
5/16-18 UNC	7	B/P	70	18	6.1
	8				
	9				
5/16-24 UNF	7	B/P	70	18	6.1
	8				
	9				
3/8-16 UNC	7	B/P	75	21	7.0
	8				
	9				
3/8-24 UNF	7	B/P	75	21	7.0
	8				
	9				
1/2-13 UNC	8	B/P	85	25	9.0
	9				
1/2-20 UNF	8	B/P	85	25	9.0
	9				

Forming Taps

TIN Coating **(Long Thread)**

1. No chips generated during tapping.
2. The machining surface of internal thread is roeled surface featuring smooth and pretty appearance.
3. The structure of material is not destroyed, that increases thread strength by 30% with consistent accuracy.
4. Greater core diameter of forming taps results in increased durability and torque. Longer service life of taps and not easy to break.

B (K9777L) : For blind holes (Chamfer: 2 thread)
P (K9666L) : For through holes (Chamfer: 4 thread)



Metric Thread

Size	GH	LC	L_1	L_2	d2
M2x0.4	4	B/P	40	11	3
	5				
	6				
M2.5x0.45	4	B/P	44	15	3
	5				
	6				
M3x0.5	4	B/P	46	18	4
	5				
	6				
	7				
M4x0.7	5	B/P	52	20	5
	6				
	7				
	8				
M5x0.8	6	B/P	60	22	5.5
	7				
	8				
M6x1.0	6	B/P	62	24	6
	7				
	8				

US Thread ANSI B1.1

Size	GH	LC	L_1	L_2	d2
4-40UNC	5	B/P	44	12	3
	6				
6-32 UNC	5	B/P	48	18	4
	6				
8-32 UNC	5	B/P	52	20	5
	6				
10-24 UNC	6	B/P	60	22	5.5
	7				
10-32 UNF	6	B/P	60	22	5.5
	7				
1/4-20 UNC	6	B/P	62	24	6
	7				
	8				
1/4-28 UNF	5	B/P	62	24	6
	6				
	7				

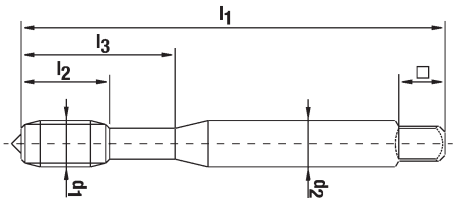
※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Forming Taps

TICN Coating **(Long Thread)**

1. No chips generated during tapping.
2. The machining surface of internal thread is roeled surface featuring smooth and pretty appearance.
3. The structure of material is not destroyed, that increases thread strength by 30% with consistent accuracy.
4. Greater core diameter of forming taps results in increased durability and torque. Longer service life of taps and not easy to break.

B (K9777L) : For blind holes (Chamfer: 2 thread)
P (K9666L) : For through holes (Chamfer: 4 thread)



Metric Thread

Size	GH	LC	L_1	L_2	d2
M1.0x0.25	4	B/P	31	5.5	3
	5				
M1.2x0.25	4	B/P	31	6	3
	5				
M1.4x0.3	4	B/P	34	6.5	3
	5				
M1.6x0.35	4	B/P	36	7	3
	5				
M2x0.4	4	B/P	40	11	3
	5				
	6				
M2.5x0.45	4	B/P	44	15	3
	5				
	6				
M3x0.5	4	B/P	46	18	4
	5				
	6				
	7				
M4x0.7	5	B/P	52	20	5
	6				
	7				
	8				
M5x0.8	6	B/P	60	22	5.5
	7				
	8				
M6x1.0	6	B/P	62	24	6
	7				
	8				

US Thread ANSI B1.1

Size	GH	LC	L_1	L_2	d2
2-56 UNC	4	B/P	42	11	3
4-40UNC	5	B/P	44	12	3
	6				
6-32 UNC	5	B/P	48	18	4
	6				
8-32 UNC	5	B/P	52	20	5
	6				
10-24 UNC	6	B/P	60	22	5.5
	7				
10-32 UNF	6	B/P	60	22	5.5
	7				
1/4-20 UNC	6	B/P	62	24	6
	7				
	8				
1/4-28 UNF	5	B/P	62	24	6
	6				
	7				

※If you request bigger tolerance than GH value mentioned on above GH column. Your inquiries are mostly welcome.

Calculated

Drill hole dia=
D-(0.2xPitch)-(0.00403xpercentage of thread engagementxPitch)+(0.00127xGH)