



Thread Measuring Wire Set includes:

16 Sizes, each with 3 wires per size

Diameter Sizes: Inch

0.018"	0.024"	0.029"	0.032"	0.040"	0.045"
0.055"	0.063"	0.072"	0.081"	0.092"	0.108"
0.120"	0.127"	0.143"	0.185"	-----	-----

Accuracy:

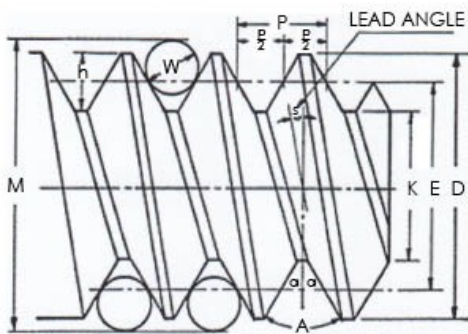
Sizes	Accuracy
0.018" – 0.108"	± 0.0004"
0.120" – 0.185"	± 0.0005"

Measures all U.S. 60° threads from 3 – 48 TPI.

Laminated conversion chart for 60° metric threads included with each set

Packed Weight and Dimensions

Code	Description	Weight g	W mm	H mm	L mm
52-485-048	Thread Measuring Wires	130	90	8	90



- M Measurement over wires
- E Pitch diameter of thread
- D Basic Major diameter (Outside Diameter)
- W Wire diameter
- P Thread Pitch

Measured Pitch Diameter (E) equals measurement over wires (M) minus decimal in "CONST" column

Note:

Basic Pitch diameter = Basic Major diameter + decimal in "ADD" column – decimal in "CONST" column

Instructions: Using Thread Wire Holders 52-016-707



Select the correct set of wires to suit the thread to be measured

Select the holder to suit the wire size

Assemble 2 wires into the oval slot

Fit the holder to the micrometer anvil

With the holder and wires in place, hold the micrometer in one hand and the third wire in the other hand.

Operate the micrometer bringing the spindle and anvil together to touch the 3 wires which should be seated in the thread to be measured. Use the micrometer ratchet to achieve the final measurement

Measured Pitch diameter = M - CONST

Thread Measuring Wires

Page: 2 of 2

Thread Chart for all U.S. 60° Threads

Threads per Inch	Wire Size D	ADD	CONST
48	0.018	0.02243	0.03596
44	0.018	0.01956	0.03432
40	0.018	0.01611	0.03235
36	0.018	0.01190	0.02994
32	0.024	0.02464	0.04494
28	0.024	0.01787	0.04107
27	0.024	0.01587	0.03993
24	0.029	0.02385	0.05092
20	0.029	0.01122	0.04370
18	0.032	0.01180	0.04789
16	0.040	0.02528	0.06587
14	0.040	0.01175	0.05814
13	0.045	0.01842	0.06838
12	0.055	0.03870	0.09283
11 ½	0.055	0.03321	0.08969
11	0.055	0.02722	0.08627
10	0.055	0.01345	0.07840
9	0.063	0.02061	0.09277
8	0.072	0.02656	0.10775
7 ½	0.081	0.04093	0.12753
7	0.081	0.02649	0.11928
6	0.092	0.02341	0.13166
5 ½	0.108	0.04845	0.16654
5	0.120	0.05689	0.18679
4 ½	0.127	0.04421	0.18855
4	0.143	0.05011	0.21249
3 ½	0.185	0.12199	0.30756
3	0.185	0.04982	0.26632

Conversion Chart for 60° Metric Threads

Pitch mm	Wire Size mm	Wire Size Inch	ADD mm	ADD Inch	CONST mm	CONST Inch
0.5	0.4572	0.018	0.6138	0.02417	0.9386	0.03695
0.6	0.4572	0.018	0.4623	0.01820	0.8520	0.03354
0.7	0.4572	0.018	0.3107	0.01223	0.7654	0.03013
0.75	0.4572	0.018	0.2349	0.00925	0.7221	0.02843
0.8	0.6096	0.024	0.6164	0.02427	1.1360	0.04472
1.0	0.6096	0.024	0.3133	0.01233	0.9628	0.03790
1.25	0.7366	0.029	0.3154	0.01242	1.1273	0.04438
1.5	1.0160	0.040	0.7747	0.03050	1.7490	0.06886
1.75	1.0160	0.040	0.3958	0.01558	1.5324	0.06033
2.0	1.1430	0.045	0.3979	0.01567	1.6969	0.06681
2.5	1.3970	0.055	0.4021	0.01583	2.0259	0.07976
3.0	1.6002	0.063	0.2540	0.01000	2.2025	0.08671
3.5	2.0574	0.081	0.8678	0.03416	3.1411	0.12367
4.0	2.3368	0.092	0.9482	0.03733	3.5463	0.13962
4.5	2.7432	0.108	1.4096	0.05550	4.3325	0.17057
5.0	2.7432	0.108	0.6519	0.02566	3.8995	0.15352
5.5	3.0480	0.120	0.8085	0.03183	4.3808	0.17247
6.0	3.2258	0.127	0.5841	0.02300	4.4812	0.17643