

# Indústria Mecânica INME



## Primitivo para roscas

### SÉRIE UNC

DIA Pol	NÚMERO DE FIOS	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
1	64	1,532	1,582	4:35
2	56	1,821	1,875	4:25
3	48	2,096	2,154	4:30
4	40	2,350	2,413	4:50
5	40	2,677	2,743	4:15
6	32	2,898	2,969	4:50
8	32	3,553	3,627	4:00
10	24	4,028	4,112	4:40
12	24	4,686	4,773	4:00
1/4	20	5,403	5,497	4:10
5/16	18	6,888	6,990	3:40
3/8	16	8,349	8,461	3:25
7/16	14	9,779	9,898	3:20
1/2	13	11,265	11,392	3:10
9/16	12	12,741	12,873	3:00
5/8	11	14,196	14,336	2:55
3/4	10	17,203	17,353	2:40
7/8	9	20,183	20,343	2:30
1	8	23,114	23,287	2:30
1 1/8	7	25,979	26,162	2:30
1 1/4	7	29,149	29,337	2:15
1 3/8	6	31,910	32,113	2:25
1 1/2	6	35,082	35,288	2:10
1 3/4	5	40,856	41,082	2:15
2	4 1/2	46,820	47,061	2:10
2 1/4	4 1/2	53,165	53,411	1:55
2 1/2	4	59,032	59,296	2:00
2 3/4	4	65,377	65,644	1:45
3	4	71,722	71,994	1:35
3 1/4	4	78,064	78,341	1:30

### SÉRIE UNF

DIA Pol	NÚMERO DE FIOS	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
Nr 0	80	1,260	1,306	4:25
Nr 1	72	1,562	1,610	4:00
Nr 2	64	1,862	1,913	3:50
Nr 3	56	2,146	2,202	3:45
Nr 4	48	2,423	2,484	3:55
Nr 5	44	2,718	2,781	3:50
Nr 6	40	3,007	3,073	3:45
Nr 8	36	3,617	3,688	3:30
Nr 10	32	4,211	4,288	3:20
Nr 12	28	4,790	4,872	3:25
1/4	28	5,652	5,735	2:55
5/16	24	7,127	7,221	2:40
3/8	24	8,712	8,809	2:10
7/16	20	10,147	10,254	2:15
1/2	20	11,732	11,841	2:00
9/16	18	13,221	13,335	1:55
5/8	18	14,803	14,922	1:45
3/4	16	17,854	17,981	1:35
7/8	14	20,869	21,006	1:35
1	12	23,830	23,980	1:35
1 1/8	12	27,003	27,155	1:25
1 1/4	12	30,173	30,330	1:15
1 3/8	12	33,343	33,503	1:10
1 1/2	12	36,515	36,678	1:05
1 3/4	12	42,865	43,028	

### SÉRIE WW

DIA Pol	NÚMERO DE FIOS	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
1/8	40	2,695	2,769	4:10
3/16	24	3,995	4,084	4:45
1/4	20	5,424	5,537	4:10
5/16	18	6,915	7,034	3:40
3/8	16	8,382	8,509	3:25
7/16	14	9,816	9,951	3:20
1/2	12	11,199	11,345	3:25
9/16	12	12,787	12,933	3:00
5/8	11	14,244	14,397	2:55
11/16	11	15,837	15,984	2:40
3/4	10	17,264	17,424	2:40
7/8	9	20,250	20,419	2:30
1	8	23,189	23,368	2:30
1 1/8	7	26,062	26,253	2:30
1 1/4	7	29,237	29,428	2:15
1 3/8	6	32,008	32,215	2:25
1 1/2	6	35,184	35,391	2:10
1 5/8	5	37,797	38,024	2:25
1 3/4	5	40,972	41,199	2:15
1 7/8	4 1/2	43,773	44,012	2:20
2	4 1/2	46,948	47,187	2:10
2 1/4	4	52,833	53,086	2:10
2 1/2	4	59,183	59,436	1:55
2 3/4	3 1/2	64,934	65,205	2:00
3	3 1/2	71,285	71,556	1:50
3 1/4	3 1/4	77,267	77,548	1:50
3 1/2	3 1/4	83,618	83,899	1:40
3 3/4	3	89,540	89,832	1:45
4	3	95,890	96,182	1:35
4 1/4	2 7/8	101,998	102,297	1:35

### SÉRIE BSF

DIA Pol	NÚMERO DE FIOS	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
3/16	32	4,171	4,255	3:25
7/32	28	4,884	4,976	3:20
1/4	26	5,631	5,725	3:05
9/32	26	6,419	6,518	2:45
5/16	22	7,094	7,198	2:55
3/8	20	8,600	8,712	2:40
7/16	18	10,089	10,209	2:30
1/2	16	11,557	11,682	2:30
9/16	16	13,139	13,272	2:10
5/8	14	14,577	14,712	2:15
11/16	14	16,160	16,300	2:00
3/4	12	17,544	17,693	2:10
13/16	12	19,129	19,281	2:00
7/8	11	20,589	20,747	2:00
1	10	23,607	23,774	1:55
1 1/8	9	26,594	26,769	1:55
1 1/4	9	29,761	29,944	1:45
1 3/8	8	32,703	32,893	1:45
1 1/2	8	35,872	36,068	1:35
1 5/8	8	39,042	39,243	1:30
1 3/4	7	41,915	42,126	1:35
2	7	48,255	48,476	1:20
2 1/4	6	54,206	54,440	1:25
2 1/2	6	60,548	60,790	1:15
2 3/4	6	66,891	67,140	1:10
3	5	72,685	72,946	1:15

### SÉRIE BSP

DIA Pol	NÚMERO DE FIOS	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
1/8	28	9,040	9,147	1:50
1/4	19	12,176	12,301	2:00
3/8	19	15,679	15,806	1:30
1/2	14	19,651	19,793	1:40
5/8	14	21,607	21,749	1:30
3/4	14	25,137	25,279	1:20
7/8	14	28,897	29,039	1:10
1	11	31,590	31,770	1:20
1 1/8	11	36,238	36,418	1:10
1 1/4	11	40,251	40,431	1:00
1 3/8	11	42,664	42,844	1:00
1 1/2	11	46,144	46,324	0:55
1 3/4	11	52,087	52,267	0:50
2	11	57,955	58,135	0:40
2 1/4	11	64,014	64,231	0:40
2 1/2	11	73,488	73,705	0:35
2 3/4	11	79,838	80,055	0:30
3	11	86,188	86,405	0:30
3 1/4	11	92,284	92,501	0:30
3 1/2	11	98,634	98,851	0:25
3 3/4	11	104,984	105,201	0:25
4	11	111,334	111,551	0:20
4 1/2	11	124,034	124,251	0:20
5	11	136,734	136,951	0:20
5 1/2	11	149,434	149,651	0:15
6	11	162,134	162,351	0:15

### MÉTRICA

DIA mm	PASSO	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
M 1	0,25	0,785	0,838	5:25
M 1	0,2	0,840	0,870	4:10
M 1,1	0,25	0,885	0,938	4:50
M 1,1	0,2	0,940	0,970	3:45
M 1,2	0,25	0,985	1,038	4:25
M 1,2	0,2	1,040	1,070	3:25
M 1,4	0,3	1,149	1,205	4:30
M 1,4	0,2	1,240	1,270	2:50
M 1,6	0,35	1,291	1,354	4:40
M 1,6	0,2	1,403	1,453	2:30
M 1,8	0,35	1,491	1,554	4:05
M 1,8	0,2	1,603	1,653	2:10
M 2	0,4	1,654	1,721	4:15
M 2	0,25	1,764	1,820	2:30
M 2,2	0,45	1,817	1,888	4:20
M 2,2	0,25	1,964	2,020	2:15
M 2,5	0,45	2,117	2,188	3:45
M 2,5	0,35	2,191	2,254	2:50
M 3	0,5	2,580	2,655	3:25
M 3	0,35	2,687	2,754	2:20
M 3,5	0,6	3,004	3,089	3:30
M 3,5	0,35	3,187	3,254	2:00
M 4	0,7	3,433	3,523	3:40
M 4	0,5	3,580	3,655	2:30
M 4,5	0,75	3,901	3,991	3:25
M 4,5	0,5	4,080	4,155	2:10
M 5	0,8	4,361	4,456	3:15
M 5	0,5	4,580	4,655	2:00
M 5,5	0,5	5,080	5,155	1:45
M 6	1	5,212	5,324	3:25
M 6	0,75	5,391	5,491	2:30

### MÉTRICA

DIA mm	PASSO	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
M 7	1	6,212	6,324	2:55
M 7	0,75	6,391	6,491	2:05
M 8	1,25	7,042	7,160	3:10
M 8	0,75	7,391	7,491	1:50
M 8	1	7,212	7,324	2:30
M 9	1,25	8,042	8,160	2:50
M 9	0,75	8,391	8,491	1:35
M 9	1	8,212	8,324	2:10
M 10	1,5	8,862	8,994	3:00
M 10	0,75	9,391	9,491	1:25
M 10	1	9,212	9,324	2:00
M 10	1,25	9,042	9,160	2:30
M 11	1,5	9,862	9,994	2:45
M 11	0,75	10,391	10,491	1:20
M 11	1	10,212	10,324	1:45
M 12	1,75	10,679	10,829	2:55
M 12	1	11,206	11,324	1:35
M 12	1,25	11,028	11,160	2:05
M 12	1,5	10,854	10,994	2:30
M 14	2	12,503	12,663	2:50
M 14	1	13,206	13,324	1:20
M 14	1,25	13,028	13,160	1:45
M 14	1,5	12,854	12,994	2:05
M 15	1	14,206	14,324	1:15
M 15	1,5	13,854	13,994	2:00
M 16	2	14,503	14,663	2:30
M 16	1	15,206	15,324	1:10
M 16	1,5	14,854	14,994	1:50
M 17	1	16,206	16,324	1:05
M 17	1,5	15,854	15,994	1:45

### MÉTRICA

DIA mm	PASSO	DIÂMETRO MÉDIO		GRAUS EM MINUTOS
		MÍNIMO	MÁXIMO	
M 18	2,5	16,164	16,334	2:50
M 18	1	17,206	17,324	1:00
M 18	1,5	16,854	16,994	1:35
M 18	2	16,503	16,663	2:10
M 20	2,5	18,164	18,334	2:30
M 20	1	19,206	19,324	0:55
M 20	1,5	18,854	18,994	1:25
M 20	2	18,503	18,663	2:00
M 22	2,5	20,164	20,334	2:15
M 22	1	21,206	21,324	0:50
M 22	1,5	20,854	20,994	1:20
M 22	2	20,503	20,663	1:45
M 24	3	21,803	22,003	2:30