



Details of Standard Thread Forms

METRIC / BRITISH / USA / ISO

BRITISH STANDARD WHITWORTH

(B.S.W.)

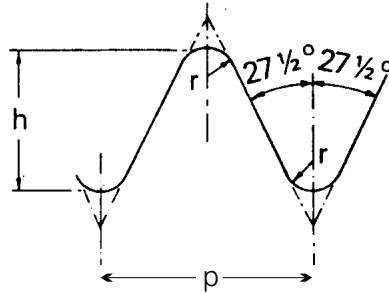
THREAD FORM

$$r = \text{Basic Radius} = \cdot 137329 p$$

$$h = \text{Basic Depth of Thread} = \cdot 640327 p$$

$$p = \text{Pitch} = \frac{1}{\text{t.p.i.}}$$

BS 84-1956
DIN 11-1930



nom. diameter	t.p.i.	basic depth of thread	basic major diameter	basic effective diameter	basic minor diameter	recmd. tap drill size	clearance drill size
inches		inches	inches	inches	inches	mm	mm
1/16	60	0.0107	0.0625	0.0518	0.0411	1.20	1.65
3/32	48	0.0133	0.0938	0.0805	0.0672	1.85	2.50
1/8	40	0.0160	0.1250	0.1090	0.0930	2.55	3.30
5/32	32	0.0200	0.1562	0.1362	0.1162	3.20	4.10
3/16	24	0.0267	0.1875	0.1608	0.1341	3.70	4.90
7/32	24	0.0267	0.2188	0.1921	0.1654	4.50	5.70
1/4	20	0.0320	0.2500	0.2180	0.1860	5.10	6.50
5/16	18	0.0356	0.3125	0.2769	0.2413	6.50	8.10
3/8	16	0.0400	0.3750	0.3350	0.2950	7.90	9.70
7/16	14	0.0457	0.4375	0.3918	0.3461	9.30	11.30
1/2	12	0.0534	0.5000	0.4466	0.3932	10.50	13.00
9/16	12	0.0534	0.5625	0.5091	0.4557	12.10	14.50
5/8	11	0.0582	0.6250	0.5668	0.5086	13.50	16.25
11/16	11	0.0582	0.6875	0.6293	0.5711	15.00	17.75
3/4	10	0.0640	0.7500	0.6860	0.6220	16.25	19.25
13/16	10	0.0640	0.8125	0.7485	0.6845	18.00	21.00
7/8	9	0.0711	0.8750	0.8039	0.7328	19.25	22.50
15/16	9	0.0711	0.9375	0.8664	0.7953	20.75	24.00
1	8	0.0800	1.0000	0.9200	0.8400	22.00	25.75
1 1/8	7	0.0915	1.1250	1.0335	0.9420	24.75	29.00
1 1/4	7	0.0915	1.2500	1.1585	1.0670	28.00	32.00
1 3/8	6	0.1067	1.3750	1.2683	1.1616	30.25	35.50
1 1/2	6	0.1067	1.5000	1.3933	1.2866	33.50	38.50
1 5/8	5	0.1281	1.6250	1.4969	1.3688	35.50	41.50
1 3/4	5	0.1281	1.7500	1.6219	1.4938	39.00	45.00
1 7/8	4 1/2	0.1423	1.8750	1.7327	1.5904	41.50	48.00
2	4 1/2	0.1423	2.0000	1.8577	1.7154	44.50	51.00
2 1/4	4	0.1601	2.2500	2.0899	1.9298	51.00	58.00
2 1/2	4	0.1601	2.5000	2.3399	2.1798	57.00	64.00

BRITISH STANDARD FINE

(B.S.F.)

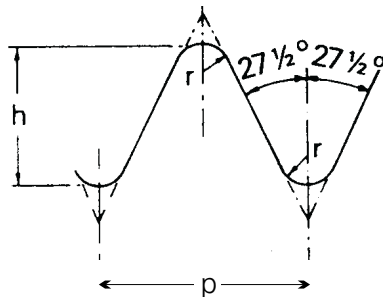
THREAD FORM

$$r = \text{Basic Radius} = \cdot 137329 p$$

$$h = \text{Basic Depth of Thread} = \cdot 640327 p$$

$$p = \text{Pitch} = \frac{1}{\text{t.p.i.}}$$

BS 84-1956
DIN 11-1930



nom. diameter	t.p.i.	basic depth of thread	basic major diameter	basic effective diameter	basic minor diameter	recmd. tap drill size	clearance drill size
inches		inches	inches	inches	inches	mm	mm
3/16	32	0.0200	0.1875	0.1675	0.1475	4.00	4.90
7/32	28	0.0229	0.2188	0.1959	0.1730	4.60	5.70
1/4	26	0.0246	0.2500	0.2254	0.2008	5.30	6.50
5/16	22	0.0291	0.3125	0.2834	0.2543	6.80	8.10
3/8	20	0.0320	0.3750	0.3430	0.3110	8.30	9.70
7/16	18	0.0356	0.4375	0.4019	0.3663	9.70	11.30
1/2	16	0.0400	0.5000	0.4600	0.4200	11.10	13.00
9/16	16	0.0400	0.5625	0.5225	0.4825	12.70	14.50
5/8	14	0.0457	0.6250	0.5793	0.5336	14.00	16.25
11/16	14	0.0457	0.6875	0.6418	0.5961	15.50	17.75
3/4	12	0.0534	0.7500	0.6966	0.6432	16.75	19.25
7/8	11	0.0582	0.8750	0.8168	0.7586	19.75	22.50
1	10	0.0640	1.0000	0.9360	0.8720	22.75	25.75
1 1/8	9	0.0711	1.1250	1.0539	0.9828	25.50	29.00
1 1/4	9	0.0711	1.2500	1.1789	1.1078	28.50	32.00
1 3/8	8	0.0800	1.3750	1.2950	1.2150	31.50	35.50
1 1/2	8	0.0800	1.5000	1.4200	1.3400	34.50	38.50
1 3/4	7	0.0915	1.7500	1.6585	1.5670	41.00	45.00
2	7	0.0915	2.0000	1.9085	1.8170	47.00	52.00
2 1/4	6	0.1067	2.2500	2.1433	2.0366	53.00	58.00
2 1/2	6	0.1067	2.5000	2.3933	2.2866	58.00	64.00

BRITISH ASSOCIATION

(B.A.)

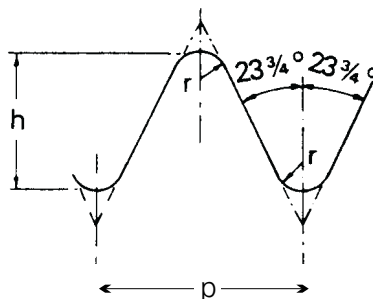
THREAD FORM

$$r = \text{Basic Radius} = \cdot 1808346 p$$

$$h = \text{Basic Depth of Thread} = \cdot 6 p$$

$$p = \text{Pitch}$$

BS 93-1951



B.A. number	pitch	basic depth of thread	basic major diameter	basic effective diameter	basic minor diameter	recmd. tap drill size	clearance drill size
	inches	inches	inches	inches	inches	mm	mm
0	0.0394	0.0236	0.2362	0.2126	0.1890	5.10	6.10
1	0.0354	0.0213	0.2087	0.1874	0.1661	4.50	5.40
2	0.0319	0.0191	0.1850	0.1659	0.1468	4.00	4.80
3	0.0287	0.0172	0.1614	0.1441	0.1268	3.40	4.20
4	0.0260	0.0156	0.1417	0.1262	0.1106	3.00	3.70
5	0.0232	0.0139	0.1260	0.1120	0.0980	2.65	3.30
6	0.0209	0.0125	0.1102	0.0976	0.0850	2.30	2.90
7	0.0189	0.0113	0.0984	0.0870	0.0756	2.05	2.60
8	0.0169	0.0102	0.0866	0.0764	0.0661	1.80	2.25
9	0.0154	0.0092	0.0748	0.0656	0.0563	1.55	1.95
10	0.0138	0.0083	0.0669	0.0587	0.0504	1.40	1.75
11	0.0122	0.0073	0.0591	0.0518	0.0445	1.20	1.60
12	0.0110	0.0066	0.0512	0.0445	0.0378	1.05	1.40
13	0.0098	0.0059	0.0472	0.0413	0.0354	0.98	1.30
14	0.0091	0.0054	0.0394	0.0339	0.0283	0.80	1.10
15	0.0083	0.0050	0.0354	0.0305	0.0256	0.70	0.98
16	0.0075	0.0045	0.0311	0.0266	0.0220	0.60	0.88

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