### WHITWORTH THREAD – BSW & BSF 55°

**EXTERNAL THREAD**
- $d =$ Major diameter
- $d_2 =$ Pitch diameter
- $d_1 =$ Minor diameter

**INTERNAL THREAD**
- $D =$ Major diameter
- $D_2 =$ Pitch diameter
- $D_1 =$ Minor diameter

$P =$ Pitch in Threads Per Inch (T.P.I.)

$\alpha =$ Flank angle 55°

### BSW (Ref. BRITISH STANDARD 84 : 1956)

<table>
<thead>
<tr>
<th>Nominal diameter</th>
<th>Diameter mm</th>
<th>$P$ T.P.I.</th>
<th>External thread, Medium Class</th>
<th>Internal thread, Normal Class</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>Pitch diameter $d_2$</td>
<td>Pitch diameter $D_2$</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>max</td>
<td>min</td>
</tr>
<tr>
<td>1/8</td>
<td>3.175</td>
<td>40</td>
<td>2.738</td>
<td>2.664</td>
</tr>
<tr>
<td>1/4</td>
<td>6.350</td>
<td>20</td>
<td>5.507</td>
<td>5.408</td>
</tr>
<tr>
<td>5/16</td>
<td>7.938</td>
<td>18</td>
<td>7.000</td>
<td>6.894</td>
</tr>
<tr>
<td>1/2</td>
<td>12,700</td>
<td>12</td>
<td>11.306</td>
<td>11.173</td>
</tr>
<tr>
<td>11/16</td>
<td>17,462</td>
<td>11</td>
<td>15.941</td>
<td>15.794</td>
</tr>
<tr>
<td>3/4</td>
<td>19,050</td>
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<td>7/8</td>
<td>22,225</td>
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<td>20.419</td>
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<tr>
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<td>25,400</td>
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</tr>
<tr>
<td>1 1/4</td>
<td>31,750</td>
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<tr>
<td>1 1/2</td>
<td>38,100</td>
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<tr>
<td>1 3/4</td>
<td>44,450</td>
<td>5</td>
<td>44.196</td>
<td>43.978</td>
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<td>2</td>
<td>50,800</td>
<td>4,5</td>
<td>47.186</td>
<td>46.954</td>
</tr>
<tr>
<td>2 1/4</td>
<td>57,150</td>
<td>4</td>
<td>53,083</td>
<td>52,840</td>
</tr>
<tr>
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<td>63,500</td>
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<td>71,277</td>
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<td>82,550</td>
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<td>3,25</td>
<td>83,896</td>
<td>83,607</td>
</tr>
<tr>
<td>3 3/4</td>
<td>95,250</td>
<td>3</td>
<td>89,830</td>
<td>89,530</td>
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<tr>
<td>4</td>
<td>101,600</td>
<td>3</td>
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<td>95,872</td>
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<tr>
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<td>6</td>
<td>152,400</td>
<td>2,5</td>
<td>145,895</td>
<td>145,537</td>
</tr>
</tbody>
</table>

**WWW.F-M-S.DK**
WHITWORTH GEVIND – BSW & BSF 55°

EXTERNAL THREAD
\[ d = \text{Major diameter} \]
\[ d_2 = \text{Pitch diameter} \]
\[ d_1 = \text{Minor diameter} \]

INTERNAL THREAD
\[ D = \text{Major diameter} \]
\[ D_2 = \text{Pitch diameter} \]
\[ D_1 = \text{Minor diameter} \]
\[ P = \text{Pitch in Threads Per Inch (T.P.I.)} \]
\[ \alpha = \text{Flank angle 55°} \]

BSF (Ref. BRITISH STANDARD 84 : 1956)

<table>
<thead>
<tr>
<th>Nominal diameter inches</th>
<th>Diameter (mm)</th>
<th>P T.P.I.</th>
<th>External thread, Medium Class</th>
<th>Internal thread, Normal Class</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>Pitch diameter (d_2)</td>
<td>Pitch diameter (D_2)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>max</td>
<td>min</td>
</tr>
<tr>
<td>7/32 5.556</td>
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<tr>
<td>¼ 6.350</td>
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<tr>
<td>5/16 7.938</td>
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<td>11.519</td>
<td>11.872</td>
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<tr>
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</tr>
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<td>72.685</td>
<td>73.340</td>
</tr>
</tbody>
</table>

mm to inches mm / 25.4

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