

(continued from the previous page)

Thread system according to ISO thread profiles

Unified fine threads UNF

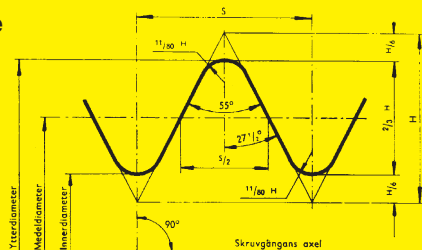
Thread diameter	UNF	No 0 ($\frac{3}{64}$)	No 1 ($\frac{1}{16}$)	No 2 ($\frac{5}{64}$)	No 3 ($\frac{3}{32}$)	No 4 ($\frac{7}{64}$)	No 5 ($\frac{1}{8}$)
No. of threads	per inch	80	72	64	56	48	44
Nom. o.d.	mm	1.52	1.85	2.18	2.52	2.85	3.18
Suitable drill	mm	1.2	1.5	1.8	2.1	2.4	2.7
Thread diameter	UNF	No 6 ($\frac{5}{64}$)	No 8 ($\frac{3}{32}$)	No 10 ($\frac{1}{8}$)	No 12 ($\frac{7}{32}$)	$\frac{1}{4}$	$\frac{5}{16}$
No. of threads	per inch	40	36	32	28	28	24
Nom. o.d.	mm	3.51	4.17	4.83	4.49	6.35	7.94
Suitable drill	mm	2.9	3.5	4.1	4.7	5.5	6.9
Thread diameter	UNF	$\frac{3}{8}$	$\frac{7}{16}$	$\frac{1}{2}$	$\frac{9}{16}$	$\frac{5}{8}$	$\frac{3}{4}$
No. of threads	per inch	24	20	20	18	18	16
Nom. o.d.	mm	9.53	11.11	12.7	14.29	15.88	19.05
Suitable drill	mm	8.5	9.9	11.5	13.0	14.5	17.5
Thread diameter	UNF	$\frac{7}{8}$	1	$1\frac{1}{8}$	$1\frac{1}{4}$	$1\frac{3}{8}$	$1\frac{1}{2}$
No. of threads	per inch	14	12	12	12	12	12
Nom. o.d.	mm	22.23	25.4	28.58	31.75	34.93	38.1
Suitable drill	mm	20.5	23.5	26.5	30.0	33.0	36.0

The closest imperial measurement has been given for UNF No-dimensions.

Thread system according to Whitworth basic profile

Whitworth coarse threads = Designation e.g. W 1.

Cylindrical pipe threads Whitworth = Designation e.g. G 1 (previously R 1).



Whitworth coarse threads W

Thread diameter	W	$\frac{1}{8}$	$\frac{3}{16}$	$\frac{1}{4}$	$\frac{5}{16}$	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{9}{16}$	$\frac{5}{8}$	$\frac{3}{4}$	$\frac{7}{8}$	1	$1\frac{1}{8}$	
No. of threads	per inch	40	24	20	18	16	14	12	12	11	10	9	8	7
Suitable drill	mm	2.6	3.7	5.1	6.5	7.9	9.2	10.5	12.0	13.5	16.5	19.25	22.0	25.0
Thread diameter	W	$1\frac{1}{4}$	$1\frac{3}{8}$	$1\frac{1}{2}$	$1\frac{5}{8}$	$1\frac{3}{4}$	$1\frac{7}{8}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$	3	$3\frac{1}{2}$	4
No. of threads	per inch	7	6	6	5	5	$4\frac{1}{2}$	$4\frac{1}{2}$	4	4	$3\frac{1}{2}$	$3\frac{1}{2}$	$3\frac{1}{4}$	3
Suitable drill	mm	28.0	30.5	33.5	35.5	39.0	41.5	44.5	50.0	57.0	63.0	70.0	82.0	94.0

Whitworth pipe threads G (R)

Thread diameter	G (R)	$\frac{1}{8}$	$\frac{1}{4}$	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{5}{8}$	$\frac{3}{4}$	$\frac{7}{8}$	1
Outside diameter	mm	9.73	13.16	16.66	20.96	22.91	26.44	30.20	33.25
No. of threads	per inch	28	19	14	14	14	14	14	11
Suitable drill	mm	8.8	11.8	15.25	19.0	21.0	24.5	28.25	30.75
Thread diameter	G(R)	$1\frac{1}{4}$	$1\frac{1}{2}$	$1\frac{3}{4}$	2	$2\frac{1}{2}$	3	$3\frac{1}{2}$	4
Outside diameter	mm	41.91	47.80	53.75	59.61	75.18	87.88	100.33	113.03
No. of threads	per inch	11	11	11	11	11	11	11	11
Suitable drill	mm	39.5	45.0	51.0	57.0	73.0	85.0	98.0	110.0