Whitworth BSW/BSF/BSP & Metric thread sizes

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Whitworth thread sizes[4]

Whitworth size (in) Core diameter (in) Threads per inch Pitch (in) Tapping drill size

1/16
0.0411
60
0.0167
Number Drill 56 (1.2 mm)

3/32
0.0672
48
0.0208
Number Drill 49 (1.85 mm)

1/8
0.0930
40
0.025
Number Drill 39 (2.55 mm)

5/32
0.1162
32
0.0313
Number Drill 30 (3.2 mm)

3/16
0.1341
24
0.0417
Number Drill 26 (3.7 mm)

7/32
0.1654
24
0.0417
Number Drill 16 (4.5 mm)

1/4
0.1860
20
0.05
Number Drill 9 (5.1 mm)

5/16
0.2414
18
0.0556
Letter Drill F (6.5 mm)

3/8
0.2950
16
0.0625
5/16 in (7.94 mm)

7/16
0.3460
14
0.0714
Letter Drill U (9.3 mm)

1/2
0.3933
12
0.0833
Letter Drill Z (10.5 mm)

9/16
0.4558
12
0.0833
12.1 mm (0.4764 in)

5/8
0.5086
11
0.0909
13.5 mm (0.5315 in)

11/16
0.5711
11
0.0909
15 mm (0.5906 in)

3/4
0.6219
10
0.1

16.27 mm (0.6406 in)

13/16
0.6845
10
0.1
18 mm (0.7087 in)

7/8
0.7327
9
0.1111
19.25 mm (0.7579 in)

15/16
0.7953
9
0.1111
20.75 mm (0.8169 in)

1
0.8399
8
0.125
22 mm (0.8661 in)

1 1/8
0.9420
7
0.1429

1 1/4
1.0670
7
0.1429

1 1/2
1.2866
6
0.1667

1 3/4
1.4939
5
0.2

2
1.7154
4.5
0.2222

2 1/2
2.180
4
0.250

BSF threads (use the 55 degree Whitworth thread form).

fractional inches decimal inches thread per inch BSC match Jaw mm exact or ~inch drill for tap

3/16
0.19
32tpi
`=
8.59mm
11/32" 6pt
5/32"

7/32
0.22
28tpi

?
?
4.6mm

1/4
0.25
26tpi
`=
11.30mm
--
5.3mm

5/16
0.31
22tpi

13.34mm
17/32"

17/64"

3/8
0.375
20tpi

15.24mm
5/8"
8.2mm

7/16
0.44
18tpi

18.03mm
--
9.7mm

1/2
0.50
16tpi

20.83mm
13/16
7/16"

9/16
0.56
16tpi

23.37mm
15/16
1/2"

5/8
0.63
14tpi

25.65mm
1" 6pt
14mm

11/16
0.69
14tpi

27.94mm
1'1/8" 6pt

15.5mm

3/4
0.75
12tpi

30.48mm
1"1/4 6pt
16.75mm

7/8
0.88
11tpi

33.02mm
1"5/16
25/32"

1"
1.00
10tpi

37.59mm
1"1/2
22.75mm

1?"
1.13
9tpi

42.42mm
1"11/16
26.50mm

1¼"
1.25
9tpi

47.24mm
1"7/8
28.75mm

1½"
1.50
8tpi

56.39mm
2"1/4

34.50mm

Dash
thread
size BSP
size
(in) Thread pitch Thread major
diameter Thread minor
diameter[1][2] A/F
(mm) Gauge
length
(mm)

Corresponding pipe Tapping drill
size (mm)

/in
(TPI) (mm) (mm) (in) (mm) (in) DN
(mm) OD
(mm) OD
(in) Thickness
(mm) BSP.PL
(Rp) BSP.F
(G)

?1
1?16
28
0.907
7.723
0.304
6.561
0.2583

4±0.9

6.60
6.80

?2
1?8
28
0.907

9.728
0.383
8.565
0.3372
15
4±0.9
6
10.2
0.40
2
8.60
8.80

?4
1?4
19
1.337
13.157
0.518
11.445
0.4506
19
6±1.3
8
13.5
0.53
2.3
11.50
11.80

?6
3?8
19
1.337
16.662
0.656
14.950
0.5886
22/23
6.4±1.3
10
17.2
0.68
2.3
15.00
15.25

?8
1?2
14
1.814
20.955
0.825
18.633
0.7336
27
8.2±1.8

15
21.3
0.84
2.6
18.75
19.00

?10
5?8
14
1.814
22.911
0.902
20.589
0.8106

16

2.6
-
21.00

?12
3?4
14
1.814
26.441
1.041
24.120
0.9496
32
9.5±1.8
20
26.9
1.06
2.6
24.25
24.50

?16
1
11
2.309
33.249
1.309
30.292
1.1926
43
10.4±2.3
25
33.7

1.33
3.2
30.40
30.75

?20
1 1?4
11
2.309
41.910
1.650
38.953
1.5336
53
12.7±2.3
32
42.4
1.67
3.2
39.00
39.50

?24
1 1?2
11
2.309
47.803
1.882
44.846
1.7656
57
12.7±2.3
40
48.3
1.90
3.2
45.00
45.00

?32
2
11
2.309
59.614
2.347
56.657
2.2306
70
15.9±2.3
50
60.3
2.37
3.6
56.75
57.00

?40
2 1?2
11
2.309
75.184
2.960
72.227
2.8436

17.5±3.5
65
76.1
3.00
3.6

?48
3
11
2.309
87.884
3.460
84.927
3.3436

20.6±3.5
80
88.9
3.50
4

?64
4
11
2.309
113.030
4.450
110.073
4.3336

25.5±3.5
100
114.3
4.50
4.5

?80
5
11
2.309
138.430
5.450
135.472
5.3335

28.6±3.5
125
139.7
5.50
5

?96
6
11
2.309
163.830
6.450
160.872
6.3335

28.6±3.5
150
165.1
6.50
5