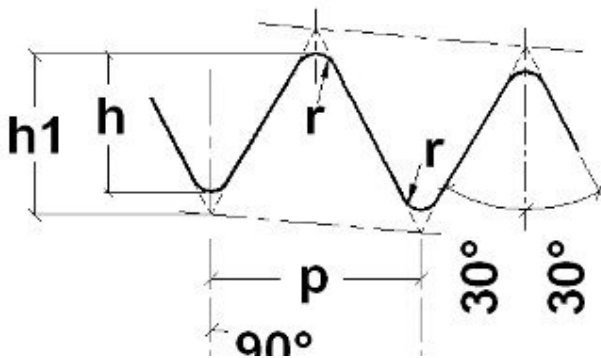




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BRITISH STANDARD PIPE THREADS (BSPP, BSPF)

Dash Size	Nominal Thread Size - t.p.i.	Basic depth of thread (h) (in.)	Basic Major Dia. (in.)	Basic effective Dia. (in.)	Basic Minor Dia. (in.)	Recommended tap drill size	
						size Rp (mm)	Size G (mm)
-1	1/16-28	.0229	.304	.2812	.2583	6.60	6.80
-2	1/8-28	.0229	.383	.3601	.3372	8.60	8.80
-4	1/4-19	.0337	.518	.4843	.4506	11.50	11.80
-6	3/8-19	.0337	.656	.6223	.5886	15.00	15.25
-8	1/2-14	.0457	.825	.7793	.7336	18.50	19.00
-10	5/8-14	.0457	.902	.8563	.8106	-	21.00
-12	3/4-14	.0457	1.041	.9953	.9496	24.00	24.50
-14	7/8-14	.0457	1.189	1.1433	1.0976	-	23.25
-16	1-11	.0582	1.309	1.2508	1.1926	30.25	30.75
-20	1 1/4-11	.0582	1.650	1.5918	1.5336	39.00	39.50
-24	1 1/2-11	.0582	1.882	1.8238	1.7656	45.00	45.00
-28	1 3/4-11	.0582	2.116	2.0578	1.9996	-	51.00
-32	2-11	.0582	2.347	2.2888	2.2306	56.50	57.00
-36	2 1/4-11	.0582	2.587	2.5288	2.4706	No Sizes of B.S. (British Standard) drills are recommended in B.S. 1157:1975 for this range	
-40	2 1/2-11	.0582	2.960	2.9018	2.8436		
-44	2 3/4-11	.0582	3.210	3.1518	3.0936		
-48	3-11	.0582	3.460	3.4018	3.3436		
-52	3 1/4-11	.0582	3.700	3.6418	3.5836		
-56	3 1/2-11	.0582	3.950	3.8918	3.8336		
-60	3 3/4-11	.0582	4.200	4.1418	4.0836		
-64	4-11	.0582	4.450	4.3918	4.3336		



**British Standard Pipe(BSPP, BSPF) Thread Form**

$r = \text{Basic Radius} = * 137329 p$   
 $h = \text{Basic Depth of Thread} = *640327 p$   
 $p = \text{Pitch} = 1/t.p.i. (\text{Threads per Inch})$   
 ISO 228, DIN 259, BS2779, JIS B0202  
 In Japan this thread is known as (PF)  
 Use prefix G for parallel thread. Example: G1/2