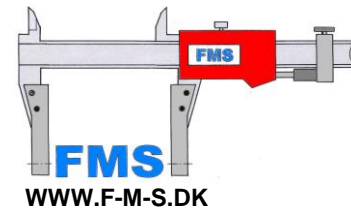


**FLEXIBLE  
MEASURING  
SYSTEMS**

**WHITWORTH  
PIPE THREAD  
BSP / G**



**NOMINAL PITCH DIAMETER  $d_2$  &  $D_2$**

$$d_2/D_2 = d/D - PDn$$

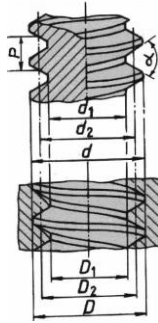
$$(PDn = 0.6495P)$$

**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 (mm)  
25.4 / T.P.I.

$\alpha$  = Flank angle  
 $55^\circ$

Denomination	T.P.I. Threads per inch	$d = D$	Internal thread Pitch diameter $D_2$		External thread Pitch diameter $d_2$		
			max	min	max	min class A	min class B
1/16	28	7.723	7.249	7.142	7.142	7.035	6.928
1/8	28	9.728	9.254	9.147	9.147	9.040	8.933
1/4	19	13.157	12.426	12.301	12.301	12.176	12.051
3/8	19	16.662	15.931	15.806	15.806	15.681	15.556
1/2	14	20.955	19.935	19.793	19.793	19.651	19.509
5/8	14	22.911	21.891	21.749	21.749	21.607	21.465
3/4	14	26.441	25.421	25.279	25.279	25.137	24.995
7/8	14	30.201	29.181	29.039	29.039	28.897	28.755
1	11	33.249	31.950	31.770	31.770	31.590	31.410
1 1/8	11	37.897	36.598	36.418	36.418	36.238	36.058
1 1/4	11	41.910	40.611	40.431	40.431	40.251	40.071
1 1/2	11	47.803	46.504	46.324	46.324	46.144	45.964
1 3/4	11	53.746	52.447	52.267	52.267	52.087	51.907
2	11	59.614	58.315	58.135	58.135	57.955	57.775
2 1/4	11	65.710	64.448	64.231	64.231	64.014	63.797
2 1/2	11	75.184	73.922	73.705	73.705	73.488	73.271
2 3/4	11	81.534	80.272	80.055	80.055	79.838	79.621
3	11	87.884	86.622	86.405	86.405	86.188	85.971
3 1/2	11	100.330	99.068	98.851	98.851	98.634	98.417
4	11	113.030	111.768	111.551	111.551	111.334	111.117
4 1/2	11	125.730	124.468	124.251	124.251	124.034	123.817
5	11	138.430	137.168	136.951	136.951	136.734	136.517
5 1/2	11	151.130	149.868	149.651	149.651	149.434	149.217
6	11	163.830	162.568	162.351	162.351	162.134	161.917

Ref.: ISO 228-1 PIPE THREADS WHERE PRESSURE-TIGHT JOINTS ARE NOT MADE ON THE THREADS (WHITWORTH)

Correct denomination for a 1 1/2 Whitworth pipe thread :  
Internal thread ISO 228 – G 1 1/2 and for an external thread either ISO 228 – G 1 1/2 A or B (depending on the tolerance chosen). For left hand threads add LH to the denomination.