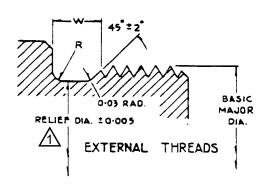
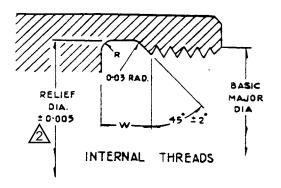
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UNIFIED AND AMERICAN NATIONAL FINE						
THREAD DIA	THREADS PER INCH T.P.I.	W	R	EXTERNAL RELIEF DIA	INTERNAL RELIEF DIA	
No. 10	32	.094	.01	.143	.203	
1/4	28	.094	.03	.196	.265	
5/16	24	.110	.03	.251	.328	
3/8	24	.110	.03	.313	.391	
7/16	20	.125	.03	.364	.455	
1/2	20	.125	.03	.426	.518	
9/16	18	.125	.03	.481	.581	
5/8	18	.125	.03	.544	.644	
3/4	16	.141	.03	.659	.771	
7/8	14	.156	.06	.772	.897	
1	12	.156	.06	.881	1.025	
1-1/8	12	.188	.06	1.006	1.150	
1-1/4	12	.188	.06	1.131	1.273	
1-3/8	12	.188	.06	1.260	1.400	
1-1/2	12	.188	.06	1.380	1.525	
1-1/2	8	.250	.06	$\triangle$	<b>2</b>	

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	S.T. GUNG	
CHECKED	D. BINNINGTON	
STRESSED		
APPROVED	W. CLENNETT	

UNDERCUT, THREAD, UNIFIED AND AMERICAN NATIONAL FINE

**DS 14** 

SHEET: 1 of 2

APPROVED: MAR 1958

REV:

REV:

REV:

REV:

REV: B - 7 DEC 99

REV: A - 11 NOV 99

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NOTES:

FOR EXTERNAL THREADS THE RELIEF DIA. IS OBTAINED BY SUBTRACTING THE BASIC THREAD DEPTH FROM THE MIN. PITCH DIAMETER AND THEN SUBTRACTING A FURTHER .003 FOR ECCENTRICITY

**EXAMPLE - 1/2-20 UNF-2A** 

 $\begin{array}{ll} \text{MINIMUM PITCH DIAMETER} = 0.4619 \\ \text{MINIMUM THREAD DEPTH} &= \underbrace{0.0324}_{0.4295} \end{array}$ 

MINUS ALLOWANCE = 0.003RELIEF DIAMETER 0.426

<u> 2</u>

FOR INTERNAL THREADS THE RELIEF DIA IS OBTAINED BY ADDING 0.7939 X PITCH TO THE MAXIMUM PITCH DIA. AND THEN ADDING A FURTHER 0.005 FOR ECCENTRICITY.

**EXAMPLE - 1/2-20 UNF-2B** 

MAXIMUM PITCH DIAMETER= 0.4731PLUS (0.7939 X P) = 0.04PLUS ALLOWANCE = 0.005RELIEF DIAMETER 0.518

- 3. FOR LARGER SIZES THAN 1-1/2 INCHES DIA. IN 16 PITCH, 12 PITCH AND 8 PITCH SERIES USE THE UNDERCUT FOR THE APPROPRIATE T.P.I. AND CALCULATE RELIEF DIA AS PER NOTES 1 OR 2 AS APPLICABLE.
- 4. ALL RELIEF DIAMETERS GIVEN IN THE TABLE ARE BASED ON THE UNIFIED THREAD CLASSES 2A & 2B. THEY ARE ACCEPTABLE FOR THE AMERICAN NATIONAL CLASSES 2 & 3 AND FOR THE UNIFIED NATIONAL CLASSES 2A, 2B, 3A & 3B
- 5. FINISH ON UNDERCUT: 125 RMS OR BETTER
- 6. THIS DRAWING SUPERSEDES CS-78

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	S.T. GUNG	UNDERCUT, THREAD,
CHECKED	D. BINNINGTON	UNIFIED AND AMERICAN
STRESSED		
APPROVED	W. CLENNETT	NATIONAL FINE

**DS 14** 

SHEET: 2

APPROVED: 7 DEC 99 | REV:

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