

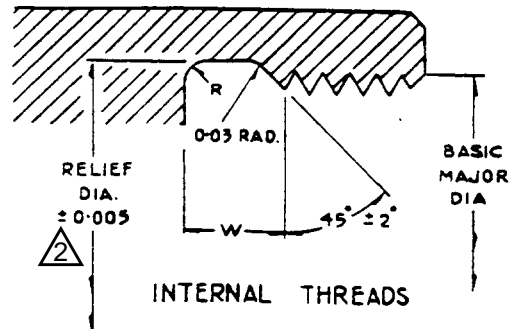
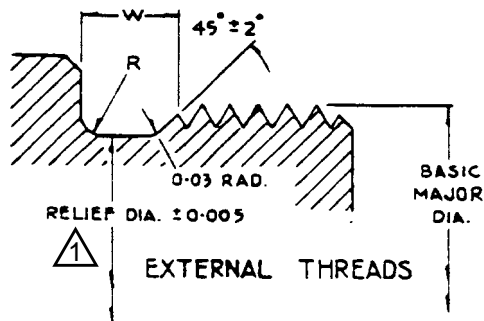
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UNIFIED AND AMERICAN NATIONAL FINE

THREAD DIA	THREADS PER INCH T.P.I.	W	R	EXTERNAL RELIEF DIA	INTERNAL RELIEF DIA
No. 4	40	.075	.01	.073	.124
No. 6	32	.094	.01	.091	.151
No. 8	32	.094	.01	.116	.178
No. 10	24	.110	.01	.129	.205
1/4	20	.125	.03	.177	.267
5/16	18	.125	.03	.233	.331
3/8	16	.141	.03	.285	.393
7/16	14	.156	.03	.336	.465
1/2	13	.172	.03	.391	.523
9/16	12	.188	.03	.444	.586
5/8	11	.203	.03	.497	.650
3/4	10	.203	.03	.609	.777
7/8	9	.234	.06	.719	.899
1	8	.250	.06	.826	1.032

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 COARSE**

DS 15

SHEET: 1 of 2

(B) STD REDRAWN & RE-INSTATED

REV:

REV:

REV:

REV:

REV: B - 7 DEC 99

REV: A - 11 NOV 99

APPROVED: MAR 1958

NOTES:

1. 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

MINIMUM PITCH DIAMETER = 0.4619

MINIMUM THREAD DEPTH = 0.0324

0.4295

MINUS ALLOWANCE = 0.003

RELIEF DIAMETER 0.426

2. 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= 0.4731

PLUS (0.7939 X P) = 0.04

PLUS ALLOWANCE = 0.005

RELIEF 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

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	S.T. GUNG	UNDERCUT, THREAD, UNIFIED AND AMERICAN NATIONAL COARSE	DS 15
CHECKED	D. BINNINGTON		
STRESSED			SHEET: 2
APPROVED	W. CLENNETT		

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 7 DEC 99