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STEP 1:

Determine if the thread is straight (parallel) or tapered

The thread is tapered if the diameter increases or decreases. If all the diameter stays the same, the thread is straight (parallel).

For example:

Tapered thread (BSPT and NPT)

Straight thread (BSPP and metric)

STEP 2:

Measure the thread diameter

Using a caliper to determine the diameter and measure on the thread tops.

- For tapered thread: measure on the 4th or 5th full thread.
- For straight thread: measure on any full thread corridor

STEP 3:

Determine the number of threads per inch (TPI) or the pitch (metric threads) with the thread gauge. Use the Teasing thread gauge to determine the pitch or the TPI. The pitch is indicated in metric thread in millimeters, withworth thread is indicated in the number of threads per inch.

Locate the possible TPI or pitch by matching the found diameter with the thread tables in this leaflet

STEP 4:

Determine the thread standard Use the parameters obtained in the steps 1,2 & 3 in order to find the appropriate thread in the table. You have already the following information:

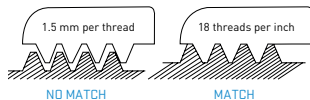
- Male or female
- Straight or tapered
- Diameter
- Pitch

Note: If diameter and pitch do not match with the table, the thread standard is different (maybe NPT)

WHITWORTH PIPE THREAD

Nominal Size withworth	Outside Ø of thread mm	T.P.I threads per inch
1/16	7.723	28
1/8	9.728	28
1/4	13.157	19
3/8	16.662	19
1/2	20.955	14
3/4	26.441	14
1	33.249	11
1 1/4	41.910	11
1 1/2	47.803	11
2	59.614	11

ISO 228-1 (DIN 259, BSPP)-G
 ISO 7-1 (DIN 2999) BSPT)-R
 Flank angle 55°
 M (ISO26 - DIN13)
 Flank angle 60°



COARSE THREAD

Thread size	Major diameter	Minor diameter	Pitch
M 3	2.98	2.459	0.5
M 4	3.978	3.242	0.7
M 5	4.976	4.134	0.8
M 6	6.974	4.917	1
M 8	7.974	6.917	1
M 10	9.968	8.376	1.5
M 12	11.97	10.106	1.75
M 16	15.96	13.835	2
M 20	19.96	17.294	2.5
M24	23.95	20.752	3

* sizes are in mm

FINE THREAD

Thread size	Major diameter	Minor diameter	Pitch
M 3x0.35	2.981	2.621	0.35
M 4x0.5	3.978	3.242	0.5
M 5x0.5	4.98	4.459	0.5
M 6x0.75	5.978	5.188	0.75
M 8x0.75	7.978	7.188	0.75
M 10x0.75	9.978	9.188	0.75
M 10x1	9.974	8.917	1
M 10x1.25	9.972	8.647	1.25
M 12x1	11.97	10.917	1
M 12x1.25	11.97	10.647	1.25
M 12x1.5	11.97	10.376	1.5
M 16x1	15.97	14.917	1
M 16x 1.5	15.97	14.376	1.5
M 20x1	19.97	18.917	1
M 20x1.5	19.97	18.376	1.5
M 20x2	19.96	17.835	2
M 24x1.0	23.97	22.917	1
M 24x1.5	23.97	22.376	1.5