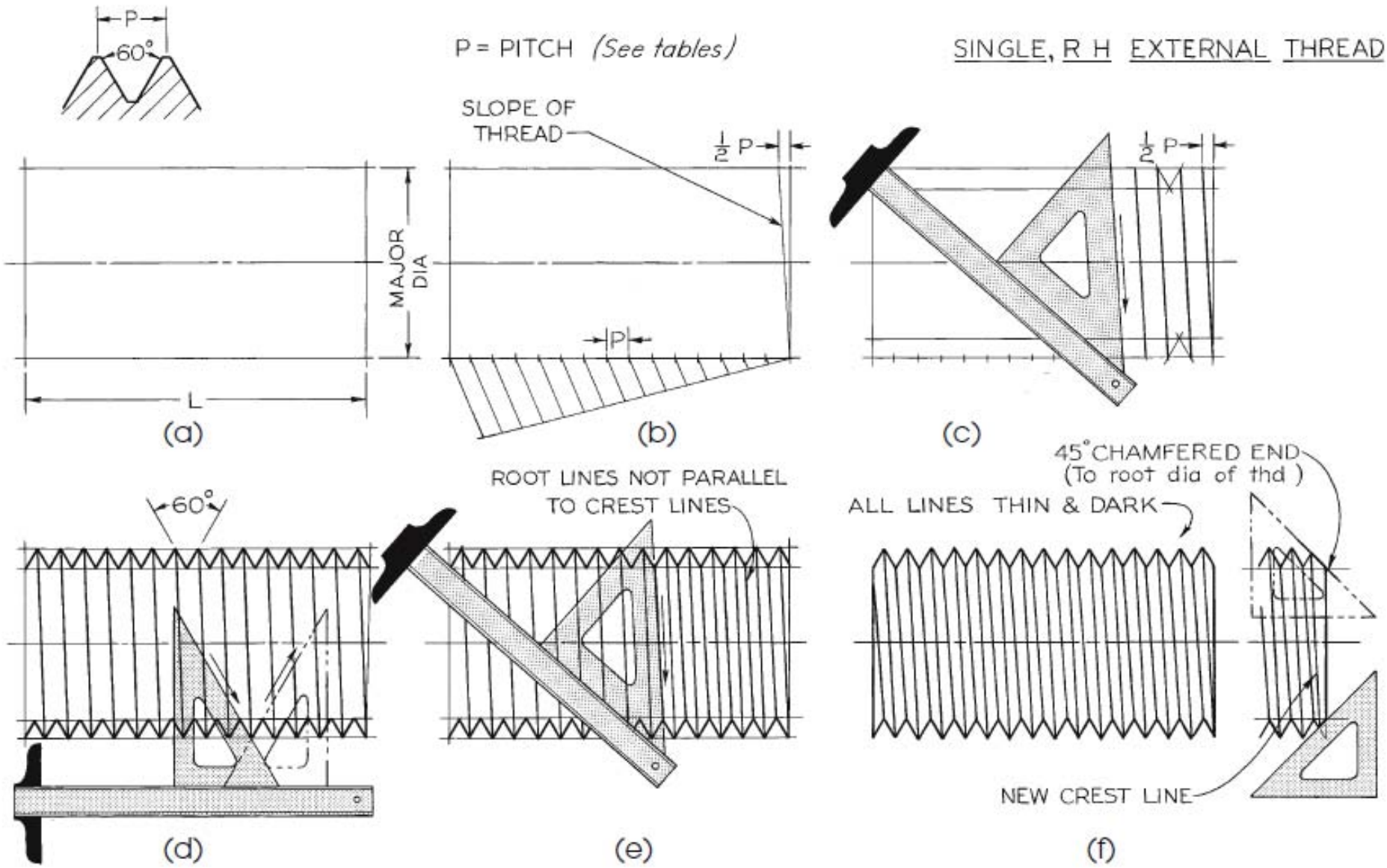
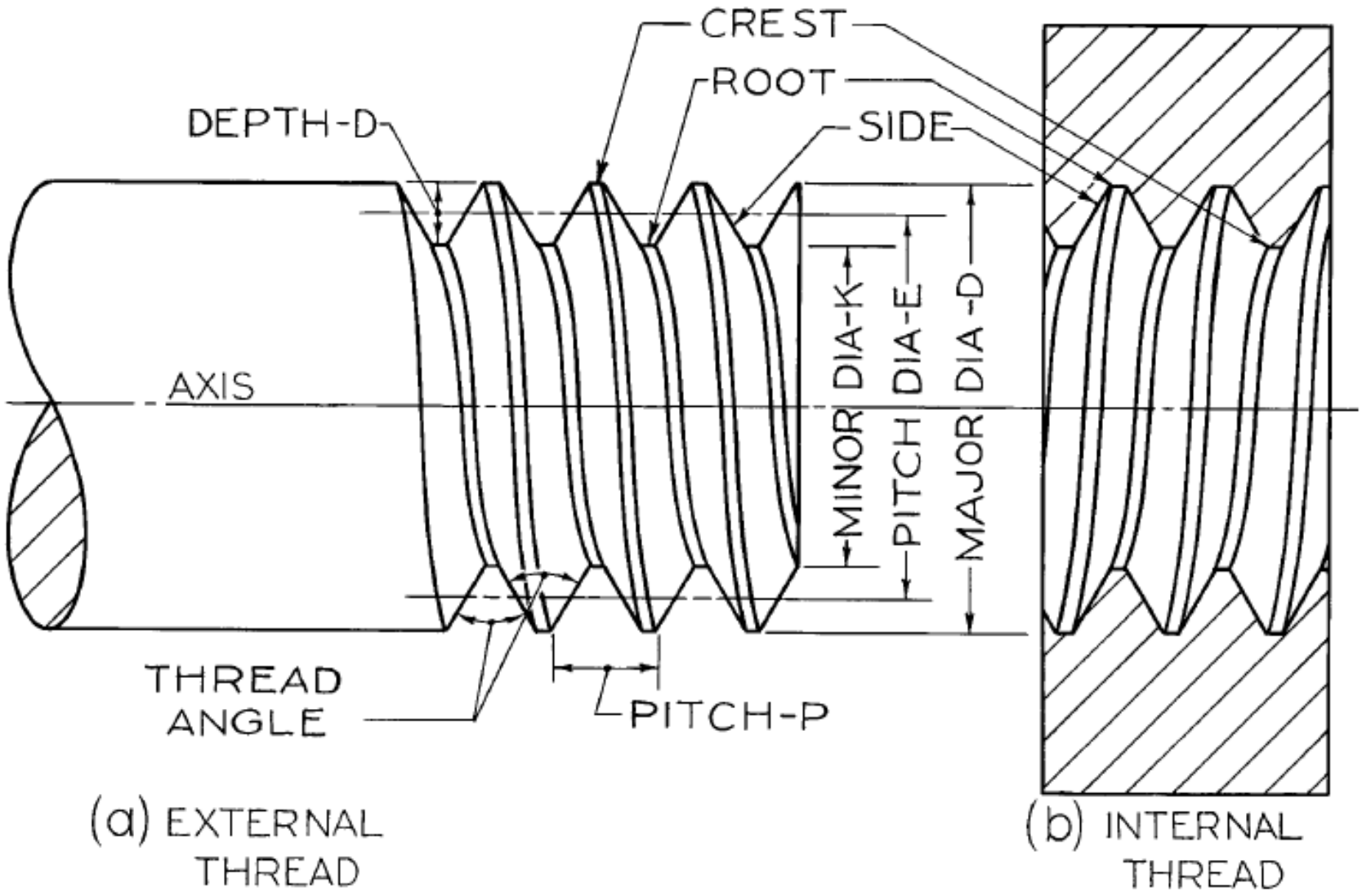

P
60°
P = PITCH (See tables)
SINGLE, R H EXTERNAL THREAD
SLOPE OF THREAD
½ P
MAJOR DIA
P
L
(a)
(b)
(c)
60°
ROOT LINES NOT PARALLEL TO CREST LINES
45° CHAMFERED END (To root dia of thd)
ALL LINES THIN & DARK
NEW CREST LINE
(d)
(e)
(f)


CREST
ROOT
SIDE
DEPTH-D
AXIS
MINOR DIA-K
PITCH DIA-E
MAJOR DIA-D
THREAD ANGLE
PITCH-P
(a) EXTERNAL THREAD
(b) INTERNAL THREAD

thread depth = 0.86603 × thread pitch

where thread pitch = 1/ number of threads per inch

For example, to cut 8 threads per inch on a 1.00-inch rod, the threading tool is set with its axis perpendicular to the axis of the rod to be threaded. (Fig. 8) The calculation is

$$\begin{aligned}\text{thread depth} &= 0.86603 \times \text{thread pitch} \\ &= 0.86603 \times \tfrac{1}{8} \text{ inch} \\ &= 0.86603 \times 0.125 \text{ inch} \\ &= 0.10825 \text{ inch}\end{aligned}$$

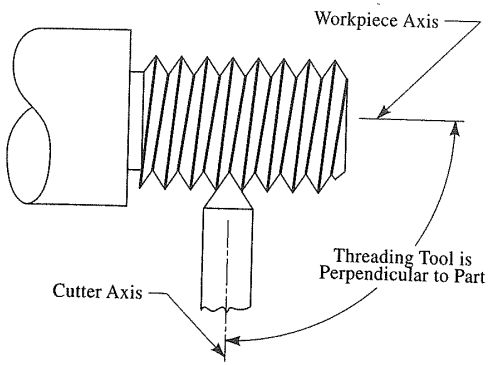


Fig. 8.

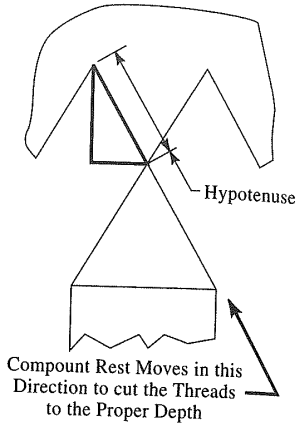


Fig. 9.

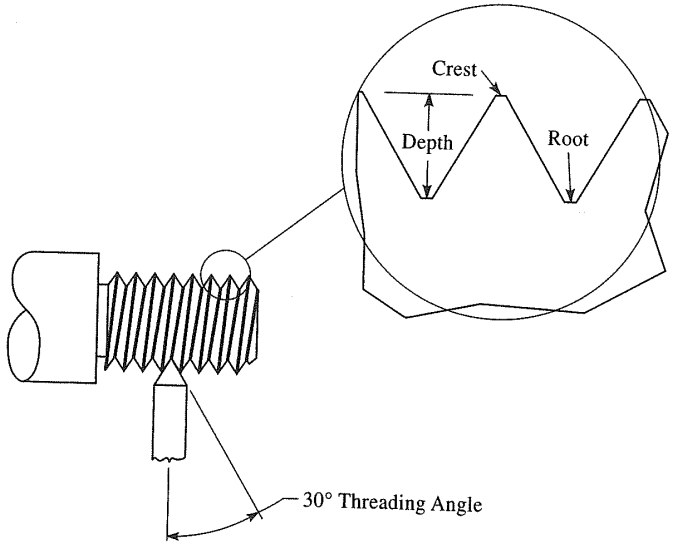


Fig. 10.