

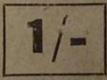
AMALGAMATED

ENGINEERING

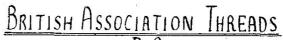
REFERENCE TABLES

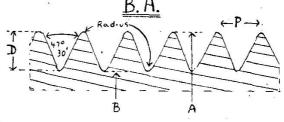
and DATA CHARTS

TOOLROOM
INSPECTION DEPT.
MACHINE SHOP
DRAWING OFFICE USE
Etc., Etc.



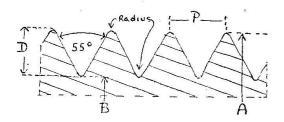
Copyright





	_		1		T	1
3. A	THRAS	DIA	DIA	PITCH	DEPTH	RABIUS
No	PER	"A"	"B"	" P"	T.D.	"R"
0	25.38	• 2362	-:890	- 0394	.0236	.0072
ı ·	28.25	- 2087	• (5 : 3	•0354	.0212	-0064
2	31+35	• 1850	1,403	• 0 3 1 7	.0191	.0058
3	34.84	+1614	. 1272	.0287	-0172	.0052
4	28.46	*14:7	• 1105	00260	+0156	.0047
5	43-10	+ 1 2 6 0	.0986	-0232	•013°	1-0042
ь	47 • 85	. 1102	.0852	10209	0125	.0038
7	52.91	.0984	-6758	.0189	•0113	•0034
8	59 - 17	•0866	•0 6 6 H	.0169	*0101	•0031
9	64.94	.0748	.0564	•0154	•0092	.0028
10	72-46	•0669	•0503	•0138	10083	-0025
П	81.97	•0591	.0445	.0122	•0073	.0022
12	90.91	•0511	•0375	.0110	• 0066	.0020
13	102.0	.0472	•0354	.0048	•0059	.0018
14	109.9	.0394	.0284	.0091	.0055	-0016
15	120.5	•0354	.0254	•0083	.0050	.0015
16	133.3	•0311	.0221	.0075	.0045	.0014
17	149-3	.0276	.0196	.0067	-0040	-0012
18	169 - 5	.0244	.0174	.0059	-0035	.0011
19	181-8	.0213	.0147	.0055	.0033	.0010
20	212.8	1.0189	.0133	.0047	•0028	.0009
21	232-6	.0165	•0.113	•0043	-0026	.0008
21	256 - 4	.0146	.0100	•0039	•0023	.000 7
23	285.7		. 0088	.0035	.0021	-0006
24	 	.0114	076	.0031	.0019	. 0006

BRITISH STANDARD FINE THREADS (B.S.F.)



DIA	DIA "	CORE DIA	THROS PER INCH	PITCH P"	DEPTH	RADIUS
7/32	-21875	. 1731	28	•03571	.0229	.0049
1/4	- 250	. 2.007	26	.0385	.0246	.0053
9/32	- 28125	- 2320	26	.0385	.0245	.0053
5/16	• 3125	. 2543	2.2	•0454	*0291	*0062
3/8	• 375	. 3110	20	•050	.0320	.0059
7/16	• 4375	+ 3664	(8	*0555	PO 356	-0075
1/2	.500	. 420	16	•0625	• 6 40	.0086
9/16	• 5625	. 4825	16	• 0625	•040	.0086
5/8	-625	• 5335	14	•0714	.0457	.0098
11/16	. 6875	.596	14	.0714	•045;	• 0098
3/4	. 750	. 6433	12	• 0833	.0534	.0114
3/16	.8125	07058	12	•0833	10534	00114
7/8	. 875	• 7586	11	.09091	•0582	•0125
14	1.000	. 8719	10	.1000	•064	0137
1/8	1. (25	. 9827	9	*	•0711	•0153
14	1.250	1-1077	9	*1111	•0711	.0153
13/8	1.375	1.2149	8	.1250	.080	.0172
1/2	1.500	1.3399	8	1250	•080	.017.2
1 5/8	1.625	1.4649	8	*1250	.080	.0172
3/4	1. 750	1.567	7	•1428	-0915	•0196
2	2.000	1.817	7	•1428	.0915	•0196
21/4	2.250	2.0366	6	•1667	.1067	• 0 2 2 9
2/2	2.500	2.2866	6	•1667	•1067	•0229
	2.750	2.5366	6	*1667	1067	•0229
3	3.000	2-7439	5	.2000	•1381	.0275

BRITISH STANDARD WHITWORTH THREADS Radius > -Radius OUTSIDE CORE THROS PITCH DEPTH RADIUS DIA "D" "P" 1/16 -0625 .0412 · D167 .0107 . 0023 3/32 + 0937 • 0283 -0133 +0029 1/8 -125 0093 .0250 -016 .0034 5/32 - 1562 . 1162 32 * 03125 * 020 * 0043 3/16 - 1875 . 1341 .04167 .0267 .0057 7/32 - 2187 . 1553 .04167 .0267 .0057 1/4 + 250 #18b .0500 .032 .0069 5/16 - 3125 .0356 .0076 *2414 . 0556 3/8 . 375 . 295 +0625 *040 *0086 7/16 . 4375 = 346 +07143 +0457 +0098 1/2 +500 • 3933 0833 0534 0114 9/16 05625 04558 · 0534 • 0114 00909 . 0582 . 0125 5/8 . 525 . 5086 . 0582 . 0125 11/16 . 6875 | . 5711 .0909 * 0640 * 0137 3/4 - 750 - 6219 .1000 . 0 640 + 0137 13/16 . 8125 . 5844 .1000 7/8 0875 . 1111 .0711 .0153 • 7327 0711 0153 15/16 . 9375 • 7952 . 1111 -0800 00172 1.000 . 8399 -125

11/8 11125

13/8 1.375

1/4 1.250 1.067

1.500 1.2866

1 . 6 2 5 1 . 3 6 3 9

1.750 1.4939

1.875 1.5904

2.000 1.7154

. 94.2

1+1616

+ 1428 + 0915 + 0196

· 2222 01423 00305

4/2 - 2222 - 1423 - 0305

+ 0915 + 0196

. 1067 0229

. 1067 - 0229

· 1281 | • 0275

. 1281 | 0275

. 1428

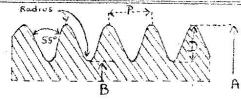
+ 1667

. 1667

.200

.200

BRITISH STANDARD GAS THREADS



51Z <i>E</i>	THROS PER INCH	PUTSIDE	CORE DIA B	PITCH P"	рертн "Д"	RAD	OUTSIDE DIA OF PIPS
1/8	28	•383	-337	-0357	.0229	-0049	•410
1/4	19	• 513	. 451	*0526	.0335	*0072	• 575
3/8	19	+656	-589	*0523	.0335	•0072	• 690
1/2	1 4	•825	•734	.07/4	•0457	*CO98	• 5 45
5/8	14	902	•.811	.0714	+0457	+0098	•940
3/4	14	1.041	• 950	.0714	·0457	.0048	1.063
7/€	14	1-189	1-098	.07:4	*0457	•0093	1-220
1"	11	1.309	1-193	.0909	•C592	•0125	1.350
1/4	11	1-650	1.53%	.0939	·0582	-0125	1.690
12	- [1	1.882	1.766	+0909	-0582	-0125	1.910
13/4	11	2-116	2.000	•0909	•053 <i>2</i> .	10125	2-160
2	11	2-347	2.231	.0907	•058 2	·0125	2.380

GAS TAPPING DRILLS

SIZE	DRILL	SIZE	DRILL	SIZE	DIA	SIZE	DRILL	SIZE	PRILE
1/8	11/32	74	24/64	1/2	47/64	3/4	61/64	1"	13/64
1/8	R	3/8	19/32	5/8	13/16	7/3	17/64		T

GAS CLEARANCE DRILLS

SIZE	DRILL DIA	SIZE	DRILL DIA	SIZE	DRILL DIA	SIZE	DRILL	SIZE	DRILL
1/8	25/64	1/4	17/32	1/2	53/64	3/4	13/64	1"	1 7/16
			43/64						

B.A. TAPPING DRILLS

B.A. Nº	DRILL SIZE	B.A.	BAILL	8.A. Nº	BRILL		DRILL SIZE
. 0	Nois	5	Nº 40	10	58	15	Nº 72
f	Nº 19	6	Nº 44	11	5.8	16	Nº 74
Ž	N° 26	7	Nº 4-8	12	63	!7	Nº 76
3	Nº 30	g	Nº 51	13	65	18	Nº 77
4.	Nº 34	9	Nº 53	14	70	19	Nº 79

WHITWORTH TAPPING DRILLS

DIA	DAILL	AIC	DRILL S:ZE	DIR	DRILL SIZE	DIA	DRILL
1/8	Nº 42	3/8	14/64	9/16	15/32	1 1/8	61/64
3/16	Nº 29	3/8	"M"	5/8	33/64	1/4	15/64
	3/16			farmer meneral	5/8	transfer of the said	119/54
1/4	Nº 12	1/2	" X ".	7/8	47/54	13/4	12
5/16	" <i>D</i> "	1/2	13/32	1"	27/32	2 "	147/64

WHITWORTH CLEARANCE DRILLS

				<u> </u>			•
DIA	DRILL 512E	DIA	DRILL SIZE	DIA	DEILL 512E	DIA	DRILL SIZE
1/8	9/64	3/16					1 41/64
1/8	Nº30	3/8	25/64	7/8	57/54	13/4	1 49/64
3/16	13/64	3/8	" V "	1"	1/64	17/8	157/64
3/16	Nº11	7/16	29/64	1/2	19/64	2 "	2 1/64
1/4	17/64	1/2	33/64	11/4	1 17/64	24	2 17/64
1/4.	"F".	19/16	37/64	1 3/3	125/64	2 2	2 33/64
			41/64				3 1/64

FRACTION AND DECIMAL EQUIVALENTS

FRA	DECIMAL	FRA	DECIMAL	FRA	DECIMAL	FRA	DECIMAL
1/64	.01562	17/64	• 26562	33/64	• 5156	49/64	•76562
1/32	-03125	9/32	• 28125	17/32	+5312	25/32	+78125
3/64	.04687	19/64	+29687	35/64	• 5 469	51/64	• 79687
1/16	.0625	5/16	* 3125	9/16	. 5625	13/16	. 8125
5/64	+07812	21/64	• 3 2 8 1 2	37/64	≠578 t	53/64	.82812
3/32	-09375	11/32	•34375	19/32	•5937	27/32	•84375
7/64	.10937	23/64	•35937	39/64	•6094	55/64	• 85937
1/8	-125	3/8	•375	5/8	.625	7/8	• 875
9/64	.14062	25/64	•3906	41/64	•6406	57/64	. 89062
5/32	•15625	13/32	•4062	21/32	•6562	27/32	. 90525
11/64	•17187	27/64	.4219	43/64			•92187
3/16	•1875	7/16	•4375	11/16	•6875	15/16	• 9375
13/64	- 2031	29/64	• 4531	45/44	◆ 7031	61/64	• 95312
7/32	•2187	15/32	•4687	23/32	•7187	31/32	. 96875
15/64	.2344	31/64	• 4844	47/64	• 7344	63/64	• 98437
1/4	•250	1/2	•500	3/4	.750	1"	1.000

B.S.F. TAPPING DRILLS

					DRILL				DRILL
1/4	13/64	3/8	"0"	9/16	31/64	3/4	21/32	1"	7/8
1/4	Nº7	7/16	"0"	5/8	35/64	13/16	23/32	1/8	63/64
5/16	" F "	1/2	27/64	4/16	39/64	7/8	49/34	1/4	17/64

B.S.F. CLEARANCE DRILLS

DIA	DAILL SIZE	DIA	DRILL	AIG	ORILL SIZE	DIA	DAILL SIZE	DIA	DRILL SIZE
1/4	17/64	3/8	25/64	9/16	37/64	13/16	53/64	14	1 1464
									125164
									133/54
									14/64

NEWALL LIMIT AND FITS

CLASS	LIMIT	UP TO 12"	9" to 1"	116 6 2"	2 16 to 3"	3 16" to 4"
	HIGH	1 4-	.0005	÷0007	-001	1001
A	LOW	(-a_	-000Z		-	
	ToL	.0004	10007	-0009	.0015	.0015
	ния	.0005	.0007	1001	+0012	.0015
B	Low	.0005	1	-	-0007	-0007
	TOL	. 001	. 0012	. 0015	.0019	.0022
	HIGH	10005	+ 001	-0015	+0025	.003
D	LOW	10002		.001	+0015	.002
		.0003	.0003	+0005	. 001	- 001
	HIGH	+001	+002	+004	.0p6	+ 008
F	LOW		.0015	.003	+0045	.006
	TOL	-0005	.0005	.001	.0015	.002
_	HIGH	.0002.	70002	-0002	.0005	.0005
P	LOW	70007	-0007	-0007	-001	7001
	TOL	.0005	.0005	.0005	• 0005	•0005
	HIGH	T 001	*0012	.0017	.002	.0025
X	tom	7002	.0027	.0035	-0042	-005
	TOL	.001	•0015	-0018	•0022	•0025
	HIGH	-0007	.001	.0012	.0015	.002
Y,	LOW	-0012	-002	-0025	-003	- 0035
	TOL	.0005	. 001	. 0013	.0015	.0015
	HIGH	-0005	-0007	-0007	-001	5001
1	LOW	70007	50012	-0015	• 002	-0022
	TOL	.0002	.0005	.0008	.001	.0012

B.A. CLEARANCE DRILLS

B.A	DRILL	B.A Nº	DRILL	B. A	DRILL		DRILL
٥	" C "	4	A-26	8	Nº42	12	Nº 54
f	Nº3	5	Nº 29	9	Nº46	13	Nº 54.
- 2	Nº 11	6	Nº32	10	Nº49	14	3/64
3	Nº19	7	Nº 37	11	Nº51	15	Nº 60

DRILL SIZES

LETTER DRILLS

Letter	51.2E	L	SIZE	L	SIZE	L	SIZE
Α .	• 234	14	-266	٥	•316	V	- 377
В	.238	1	-272	P	• 323	W	• 386
, c	• 242	7.	• 2.77	Q	• 332	X	•397
· D	• 246	K	. 281	R	• 339	Y.	•404
E	256	L	-290	S	•348	Z.	• 413
F	• 257	M	• 295	Т	•358		
G	-261	N	. 302	U	.368		

NUMBER DRILLS

Nº	SIZE	No	SIZE	Nº	517E	No	512E
1	•228	21	• 159	41	• 696	61	-039
2	. 221	22	• 157	42	0 0935	62	.038
3	+ 213	23	1 154	43	•089	63	• 0 37
Lq-	. 209	24	• 152	44	•086	64	•036
5	. 2055	25	•1495	45	-082	65	.035
6.	* 204	26	• 147	46	•081	66	• 0 3 3
7	. 201	2.7	• 144	47	• 0785	67	.032
8	• 199	28	• 1405	48	.076	68	•031
9	- 196	29	.136	49	.073	69	•0292
(0	• 1435	30	• 1285	50	.070	70	.028
. 11	• 191	31	. 120	51	.067	71	.026
12	• 189	32	• 116	52	• 0635	72	.025
13	• 185	33	• 113	53	.0595	73	•024
14	• 182	34	• 111	54	• 055	74	.0225
15	• 180	35	- 110	55	•052	75	•021
16.	• 177	36	• 1065	56	•0465	76	.020
17	• 173	37	• 104	57	•043	77	•018
18	-1695	38	• 1015	58	•042	78	.016
19	• 166	39	• 0995	59	•041	79	•0148
20	- 161	40	• 098	60	•040	80	•0135

BIRMINGHAM SHEET METAL GAUGE (B.G)

N٥	SIZE	20	SIZE	Nº	SIZE	No	らレスモ
7/0	.6666	9	•1398	24	• 0247	39	•0043
6/0.	·6·25	10	• 125	25	-022	40	•0038
5/0	• 5883	u	•11/3	26	00196	41	•0034
4/0	•5416	12	•0991	27	•0174	42	•0030
3/0	.500	13	•0882	28	-0156	43	-0027
2/0	•4452	14	•0785	29	•0139	44	•0024
0	•3964	15	• 0699	30	•0123	45	+0021
1	• 3532	16	• 0625	31	•011	46	•0019
2	• 3147	17	.0556	32	.0098	47	-0017
3	. 2804	18	+0495	33	•0087	48	.0016.
4-	• 250	19	1044	34	•0077	49	.0013
5	• 2225	20	0392	35	•0069	50	-0012
6	•1981	21	0349	36	-0061		
7	• 1764	22	00312	37	• 0054		
8	.1570	23	0278	38	• 0048	!	

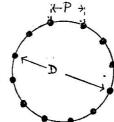
BRITISH IMPERIAL WIRE GAUGE (S.W.C)

Nº	SIZE	No	SIZE	N°	517 E	No	512E
7/0	-500	9	•144	24	•022	39	.0052
6/0	-464	10	• / 28	25	.020	40	.0048
5/0	• 432	11	-116	28	•018	41	.0044
4/0	-400	12	•104	27	• 0164	42	.0040
3/0	• 372	13	.092	28	00148	43	.0036
2/0	. 3 48	14	•080	29	•0136	44	.0032
0	-324	15	• 072	30	•0124	45	.0028
1	.300	16	•064	3/	-0116	4.6	•0024
2	• 276	17	•056	32	-0108	47	•0020
3	• 252	18	•048	33	00100	48	.0016
4	• 232	19	0040	34	•0092	49	.0012
5	• 2/2	20	• 036	35	-0084	50	.0010
6	-192	21	0032	36	•0076		
7	• 176	22	• 028	37	• 0068		
8	• 160	23	.024	38	.0000		

METRIC TO DECIMAL EQUIVALENTS

MM	INC H .	Min	INCH	MIN	INCH	M/ne	INCH
						• 9 4	
-01	*00:04		*0126	-63	• 0248		• 03701
+02	.0008	33	•013	- 64	* 0252	• 95	•0374
.03	.0012	. 24	1.0134	-63	• 0256	• 96	•0378
* 04-	.001b	•35	*p138	• 66	026	- 97	•0382
• 05	-0020	+36	-0142	•67	•0264	• 98	•0386
.06	-0024	•37	.0146	• 63	.0588	• 99	•03898
.07	• 00 23	#3 P	.0150	-69	•0272	1	•0394
.03	•0032	•39	.0154	•70	• 0276	2	•0787
.09	•0036	*10	.0158	• 71	• 0279	3	•1181
.10	1004	-41	.0162	• 72	*0283	4-	•1575
•11	-0043	•42	•01.66	•73	• 0287	5	• 1968
-12	•0047	+43	*0169	*74	1950	٠,4	. 2362
. 13	• cn 5/	- 1+ 4	•0173	•75	• 0295	7	• 2756
• /4	• 0055	-4:	+0177	• 76	• 0299	8	•315
+/5	-0059	04.5	.0181	•77	• 0303	9	•3543
· / i,	.0063	* 47	•0185	•78	• 0367	10	• 3937
•17	.0067	+48	*0189	•79	• 0311	11	• 4331
•/3	*007/	• 49	+0193	-80	•0315	12	• 4724
.19	•00°5	•50	.0197	*81	• 0319	13	• 5118
+20	• 00 7 9	p 5 j	00201	.82	-0323	14.	.5512
•2/	*0083	-52	.0205	.83	• c327	15	. 5905
.22	·0087	•53	00209	•84	• 0331	16	. 6299
•23	*0091	· 54.	•02:3	*85	*0335	17	• 6693
024	-0055	•55	0.2.17	.86	• 0337	18	• 7082
•25	40099	* £ 6	.02,21	•87	•0343	19	. 748
. 26	.0103	• 5 7	00225	•88	•0347	20	• 7874
•27	.0166	+55	.0228	*89	•0350	2.1	.8268
•28	*0110	1 59	•0232	•90	•0354	2.2	* 8661
• 29	0114	• 60	• 0236	•91	•0358	23	• 9055
• 30	•0118	16	■ 0240	•92	•0362	24	• 9449
• 31	•0/22	• ¢ Z	•0244	•93	•0366	25	• 9842

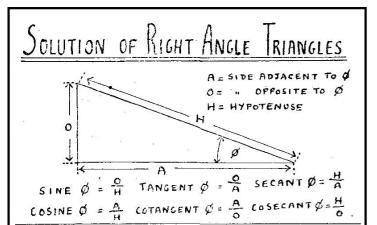
DIVIDING CIRCLES

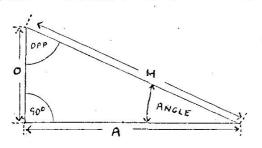


LET
D = DIAMETER OF CIRCLE
N = Number of Holes
P = PITCH ALONG CHORD

K=CONSTANT
THEN P=DxK

	THEN PEDAK						
No	K .	Nº	К	N°	K	N°	K
3	- 86603	28	-11197	53	•05924	78	-04-027
4	. 70711	29	-10812	54	-05814	79	-03976
5	• 58779	30	-10453	55	•05709	80	•03926
6	. 50000	31	-10117	56	•05607	81	•03877
7	• 43388	32	•09802	57	•05509	82	•03830
8	.38268	33	-09506	58	•05414	83	.03784
9	• 34202	34	*09227	59	•05322	84	.03739
10	• 30902	35	•08964	60	•05234	85	•03695
11	.28173	36	•08716	61	05148	86	•03552
12	•25882	37	•08480	62	•05065	87	.03610
13	•23932	38	.08258	63	•04984	88	-03569
14	• 22252	39	-08047	64	•04.907	89	03529
1,5	• 20791	40	-07846	.65	-04831	90	-03490
16	•19509	41	• 07655	66	-04758	91	-03452
17	418375	42	-07473	67	•04687	92	*03414
18	.17365	43	•07299	68	.04618	93	•03377
19	•16460	44	•07134	69	104551	94	•03341
20	•156 4 3	45	-06976	70	*04466	95	.03306
21	•14904	4.6	-06824	71	•04423	96	•03272
22	•14232	47	-06679	72	.04362	97	-03238
23	-13617	48	-06540	73	.04302	98	.03205
24	-13053	49	-06407	74	.04244	99	•03173
25	-12523	50	-06279	75	•04187	100	.03141
26	-12054	51	•06156	76	-04132		
27	11609	52	-06038	77	-04079		

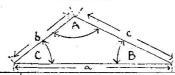




PARTS	PAR	TS TO E	E FOU	ND	
GIVEN	HYP	ADT SIDE	SIDE	ANGLE	OPP
HYPOTENUSE AND ADJACENT			WYF -ADJ	COSINE ADT	SINE ADT
HYPOTENUSE AND OPPOSITE		VHYP2- 0PP2		SINE -	COSINE OPP
HYPOTENUSE AND ANGLE		HYPX	HYPX		90°- ANGLE
ADJACENT AND OPROSITE	ADT+OIP			i—	COTAN = OPP ADT
ADTACENT AND ANGLE	ADY .		ADJ X Tangent		90°- ANGLE
OPPOSITE AND ANGLE	SINE	OPP X		. —	90°-

SOLUTION OF OBLIQUE ANGLED TRIANGLES

ANGLES



	a		
PARTS	ANGLES	TO BE F	OUND
GIVEN	ANGLE A	ANGLEB	
a.b.c	2 bc = CosA	2ac = (05 B	$\frac{a^2+b^2-c^2}{2ab=cosc}$
b,c, ANGLE A		BSINA - TAN	csin A = Tan b-closA C
ANGLE B	CalosB A		a-c CosB C
ANGLE C	asinc TAN b-a Cost A	b SINC TAN	
A.b. ANGLE A		BSINA SIN	180°-(A+B)
ANGLE B	a SINB SIN		180°-(A+.B)
ANGLE A		180°-(A+C)	c SINA SIN
a.c. ANGLE C	a SINC SIN	180°-(A+C)	
b. c ANGLE B	180°-(B+C)		ESINB SIN
Angles A.B.	=		180° (A+B)
ANGLES M.C	=	180°-(A+C)	
ANGLES B. C	180°-(B+C)		
ANGLES A.B			130°-(A+B)
ANGLES A.C		180°-(A+C)	
	180°-(B+C)		
	180°-(B+C)	c = B	
ANGLES A. B			180°-(A+B)
ANGLES A.C		180°-(A+C)	

SCLUTION OF OBLIGUE ANGLED TRIANGLES SIDES



•	H T	~ \	<u> </u>
PARTS	SIDE'S	TO BE F	FOUND
GIVEN	Side a =	Side b=	514 C =
b.c anole A	b2+c2-2belosA		
a.c ANGLE B		Jairer-Laclos B	
a.b ANGLE C			a2+b2-lablos C
a.b Angle A			a x Sin C SIN A
a.b Angle B			bx SIN C SIN B
A. E ANGLE A		SIN A	
a.c Angle C		CX SINB	
b c ANGLEB	bx SIN A		
b C ANGLE (CX SIN A		
ANGLES A.B		ax SIN B	a K SIN C
ANGLES A.C	. 16	A X SIN B	SINA
ANGLES B. C		AX SINF SIN A	A × SIN C SIN A
ANGLES A.B	DX SIN A		BX SIN C
ANGLES A.C	B X SINA		bx SINC
ANGLES B.C	D X SINA SIN B		b x SIN C
ANGLES A B	C X SINA	C X SIN B	
ANGLES A.C	SIN C	C X SIN B	
ANGLES B.C	SIN C	C X 5 1 N B	=======================================

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