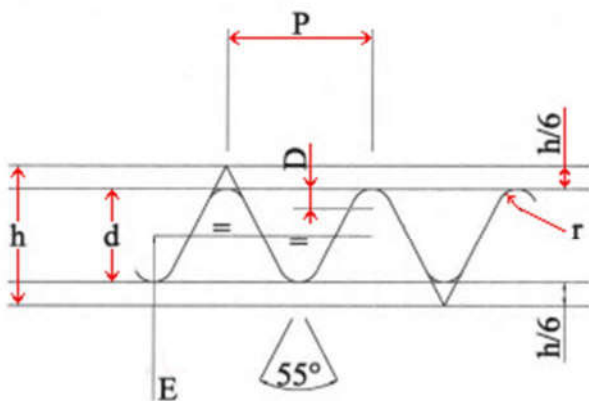


Model Engineer Thread (ME)

Major diameter	tpi	Pitch P	Triangular height h	Actual Depth d	Rounding depth D	Crest & Root		Effective Diameter E	Tapping Drill		Clearance Drill		BA A/F inch
						Shortening h/6	Radius r		inch	mm	inch	mm	
1/8	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.1050	0.0930	2.36	0.135	3.43	0.219
5/32	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.1362	0.1242	3.16	0.166	4.22	0.273
3/16	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.1675	0.1555	3.95	0.198	5.02	0.328
7/32	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.1987	0.1867	4.74	0.229	5.81	0.383
1/4	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.2300	0.2180	5.54	0.260	6.60	0.438
9/32	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.2612	0.2492	6.33	0.291	7.40	0.492
5/16	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.2925	0.2805	7.12	0.323	8.19	0.547
3/8	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.3550	0.3430	8.71	0.385	9.78	0.656
7/16	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.4175	0.4055	10.30	0.448	11.37	0.766
1/2	32	0.0313	0.030	0.020	0.0023	0.005	0.0043	0.4800	0.4680	11.89	0.510	12.95	0.875
1/8	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.1090	0.0994	2.52	0.135	3.43	0.219
5/32	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.1402	0.1306	3.32	0.166	4.22	0.273
3/16	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.1715	0.1619	4.11	0.198	5.02	0.328
7/32	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.2027	0.1931	4.91	0.229	5.81	0.383
1/4	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.2340	0.2244	5.70	0.260	6.60	0.438
9/32	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.2652	0.2556	6.49	0.291	7.40	0.492
5/16	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.2965	0.2869	7.29	0.323	8.19	0.547
3/8	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.3590	0.3494	8.87	0.385	9.78	0.656
7/16	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.4215	0.4119	10.46	0.448	11.37	0.766
1/2	40	0.0250	0.024	0.016	0.0018	0.004	0.0034	0.4840	0.4744	12.05	0.510	12.95	0.875

The model engineer threads are based on the Whitworth thread and are fixed pitch in two ranges 32 and 40 tpi. Some model boiler fittings use these threads but otherwise it is not used commercially and there are no nuts bolts etc. made to this standard.



- P = Pitch = 1/Number of threads per inch (tpi)
- h = Angular Depth = $0.960491 \times P$
- D = Depth of Rounding = $0.073917 \times P$
- h/6 = Shortening = $0.160083 \times P$
- d = Actual Depth = $0.640327 \times P$
- r = Radius at the Crest & Root = $0.137329 \times P$
- C = Core diameter = Major Diameter - $1.280654 \times P$
- Effective or Pitch Diameter = Major Diameter - $.640327 \times P$

Model Engineer Thread

Mike Brown