

# UNIFIED THREADS

With the steady introduction of unified threads, not only on new models, but for service spares on old ones, a certain responsibility is put upon fitters and mechanics to examine all threaded components before installing them to ensure correct fitting. Since genuine Austin spares are produced on the same factory machines which produce original parts, it would handicap production to change back to British threads each time service spares were produced. For this reason many components which were originally Whitworth or B.S.F. will be supplied with unified threads. In many cases the part numbers will be changed to facilitate identification, but this will not always be the case. Where unified threads are encountered, the associated studs, screws and nuts will have to be replaced, and the part numbers of suitable ones can be readily found by reference to the charts given in this article.

The "Unified" thread is, however, interchangeable with the American National Fine (A.N.F.) thread for all practical purposes.

## British Threads

**British Standard Whitworth (known as B.S.W. or Whitworth).** Thread comparatively coarse, 20 threads per inch on  $\frac{1}{4}$ " diameter screw. Sizes quoted by diameter of bolt.

**British Standard Fine (B.S.F.).** Used where finer thread required, 26 threads per inch in  $\frac{1}{4}$ " size. Sizes quoted by diameter of bolt.

**British Association (B.A.).** Used for practically all electrical purposes in sizes from just under  $\frac{1}{4}$ " diameter down to minute sizes. Fine thread. Sizes quoted by numbers ranging from Number 0 (diameter 0.236", 25.4 threads per inch) to Number 25 (diameter 0.010").

## IDENTIFICATION OF "UNIFIED" SCREW THREADS

Identification has been standardized and is effected in the following manner:—

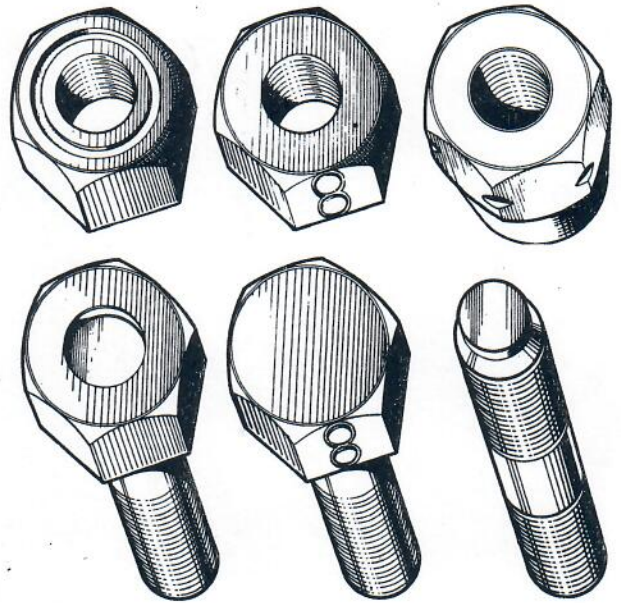
**Nuts.** By a circular groove turned on the end face of the nut or by connected circles stamped on one flat of the hexagon.

**Bolts and Setscrews.** By a circular depression turned on the head or by connected circles stamped on one flat of the hexagon.

**Studs.** By a protruded end.

**Wheel Stud Nuts.** By a notch cut in all the corners of the hexagon.

These identification marks are clearly shown in the illustration, and it is obviously of the utmost importance that any nuts, bolts, setscrews or studs so marked are used only in conjunction with associated components having "Unified" threads and that only replacement parts with "Unified" threads are used, as these are not interchangeable with Whitworth, B.S.F. or Metric threads.



STR 1781

The identification marks for nuts, bolts and studs

Continued

FOR YOUR RECORDS	PARTS LISTS
	STOCK CARDS
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