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alex.helf

Joined: 31 May 2004

Posts: 88

Location: Austria EU

Posted: Sun Jul 29, 2007 6:06 pm Post subject: special thread 5/8 x 20 tpi
??

My engine is fixed with 5/8 x 20 tpi bolts.

Which thread norm is this?

It's not BSC, BSW, BA, BSF ...

Where can I buy such tap and dies?

thx

Alex

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efr215

Joined: 06 Nov 2004

Posts: 215

Location: Leigh-on-sea, Essex

Posted: Sun Jul 29, 2007 10:58 pm Post subject:

As by now you will have guessed it is a non-standard thread.
You can get specials made but you will need a mortgage.
If you are competent with a lathe you can screwcut the threads, from time to time 20tpi internal and external chasers appear on eBay and will aid finishing to a good profile. You could even use 1.25mm pitch, (0.050" = 1.27mm), close enough if needs must and particularly if you have a metric lathe. Generally it is easier to do metric threads on an Imperial lathe than English on a metric. I'd be inclined to first make a tap out of silver steel to finish the nuts, (first partially screwcut the threads). Then you can make the studs to fit the new nuts using them as go/no-go gauges, that way if the threads finish a bit off standard who cares as long as they fit? They'll never see it from the High Street!

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Gill Swan

Joined: 28 Jun 2004

Posts: 25

Posted: Mon Jul 30, 2007 9:45 am Post subject: Engine Bolts

Hi Alex

Alternatively you could purchase them from the spares scheme.

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Gill Swan

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BRIAN MARSHALL

Joined: 31 May 2004

Posts: 76

Location: East Midlands, U.K.

Posted: Thu Aug 09, 2007 5:57 pm Post subject: 20TPI screw threads

Believe it or not, but it is a standard thread or at least it was donkey's years ago. British Standard Cycle Thread superceded the previous Cycle Engineers Institute threads, and it is a common misconception that all BSC threads are 26TPI. In fact in various sizes above half an inch diameter there is an alternative at 20TPI that was a legacy of the CEI days. I own a superb set of BSC taps and dies and amongst them are a few 20tpi items AND some left hand thread items too that I believe relate to pedal cycle cranks. The wooden case stencil markings suggest that it is an ex-government set from the 1939-1945 era.

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chstorm

Joined: 02 Aug 2004

Posts: 88

Location: Oslo, Norway

Posted: Fri Aug 10, 2007 11:04 am Post subject:

Hi Alex,

BSCycle taps and dies 5/8x20tpi are available off the shelf from:

The Tap & Die Co.
445 West Green Road
London N15 3PL
www.tapdie.com

A single tap will cost £17.50, a die will cost £34.50

Here are the relevant web-adresses:

5/8x20 taps: http://www.tapdie.com/html/bscycle__taps.html
5/8x20 dies: http://www.tapdie.com/html/bscycle__dies.html

Kind regards,

Carl

Carl Henrik Stormer
Oslo, Norway
Scott TT Replica 1930
Scott DPY Flying Squirrel 1936
Scott DPZ Flying Squirrel 1938
Brum Scott Flying Squirrel 1958

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BRIAN MARSHALL

Joined: 31 May 2004

Posts: 76

Location: East Midlands, U.K.

Posted: Fri Aug 10, 2007 10:24 pm Post subject: 20TPI screw threads

Further to my previous comments, please note that the 20tpi cycle thread is NOT of Whitworth thread form. Anyone thinking of screw cutting stuff on the lathe should cut threads with a 60 degree angle and not the 55 degrees of the various whitworth-based threads. For the record, BA threads are also not of whitworth form. They have a 47.5 degree angle.

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alex.helf

Joined: 31 May 2004

Posts: 88

Location: Austria EU

Posted: Tue Sep 04, 2007 2:08 pm Post subject:

Another dealer for these tap and dies:

<http://www.tracytools.com/index.htm>

Alex