

BSF

Size	O/D	T.P.I.	Recommended Tapping		Low engagement		Clearance		Core Diam.	Core Area
			Drill Size	Imperial	Metric	Imperial	Metric	Imperial		
3/16	0.188	32	5/32	3.95	20	4.1	10	5	0.1475	0.0171
7/32	0.219	28	14	4.65	12	4.8	2	5.7	0.173	0.0235
1/4	0.250	26	5	5.3	3	5.5	F	6.6	0.2	0.0314
5/16	0.313	22	17/64	6.75	1	7	O	8.1	0.253	0.0503
3/8	0.375	20	P	8.25	Q	8.4	W	9.9	0.311	0.0760
7/16	0.438	18	V	9.7	W	10	29/64	11.7	0.366	0.1052
1/2	0.500	16	7/16	11.1	7/16	11.3	33/64	13	0.42	0.1385
9/16	0.563	16	1/2	12.6	1/2	12.9	37/64	14.5	0.482	0.1825
5/8	0.625	14	9/16	14		14.25	41/64	16	0.533	0.2231
3/4	0.750	12	21/32	16.75		17	49/64	19.5	0.643	0.3247
7/8	0.875	11	25/32	19.75		20	57/64	22.5	0.758	0.4513
1	1.000	10	57/64	22.75		23	1 1/64	26	0.872	0.5972

HEAD SIZES. Originally, BSF heads were one size smaller than BSW.

There was a gradual move to making them the same (smaller) size, primarily on economic grounds, and during WW2 this change became the norm.

Before about 1900, many makers used their own size for heads.

Size	Across flats	Across corners	Head height	Nut thickness
3/16	0.406	0.471	0.103	0.165
7/32	0.448	0.512	0.167	0.192
1/4	0.453	0.535	0.186	0.22
5/16	0.525	0.609	0.228	0.27
3/8	0.601	0.697	0.27	0.332
7/16	0.71	0.824	0.312	0.397
1/2	0.82	0.951	0.363	0.467
9/16	0.92	1.067	0.404	0.562
5/8	1.011	1.727	0.447	0.602
3/4	1.1	1.276	0.53	0.728
7/8	1.3	1.508	0.623	0.81
1	1.48	1.7186	0.71	0.94