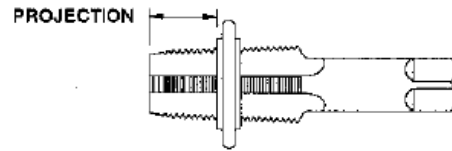


## TAPER PIPE TAP, THREADS LIMITS, GROUND THREAD

(ref.USCTI Table 338)

- American National Standard Taper Pipe Thread Form (NPT)
- Aeronautical National Taper Pipe Thread Form (ANPT)
- Dryseal American National Standard Taper Pipe Thread Form (NPTF)



Tap Thread Limits						Reference Dimensions	
Normal Size Inches	Threads Per Inch	Projection * Inches	Projection Tolerance + or -	Taper Per Foot Limits		L <sub>1</sub> Length	Tap Drill Size**
				Minimum	Maximum		NPT, ANPT, NPTF
1/16	27	.312	.063	.719	.781	.160	C
1/8	27	.063	.063	.719	.781	.1615	Q
1/4	18	.459	.063	.719	.781	.2278	7/16
3/8	18	.454	.063	.719	.781	.240	9/16
1/2	14	.579	.063	.719	.781	.320	45/64
3/4	14	.565	.063	.719	.781	.339	29/32
1"	11 - 1/2	.678	.94	.719	.781	.400	1-9/64
1 - 1/4	11 - 1/2	.686	.94	.719	.781	.420	1-31/64
1 - 1/2	11 - 1/2	.699	.94	.719	.781	.420	1-23/32
2"	11 - 1/2	.667	.94	.719	.781	.436	2-3/16
2 - 1/2	8	.925	.94	.734	.781	.682	2-39/64
3"	8	.925	.94	.734	.781	.766	3-15/64
3 - 1/2	8	.938	.125	.734	.781	.821	.....
4	8	.950	.125	.734	.781	.844	.....

### Note:

\* Distance small end of tap projects through L1 Taper Thread Ring Gage.

\*\* Recommended size given permit direct tapping without reaming the hole, but only give a full thread fro approx. the L1 length.

### Lead Tolerance

A maximum lead deviation of plus or minus .0005" within any two threads not father than 1" is permitted.