

NPT, NPTF

ANSI B1.20.1, ANSI B1.20.3

HSSE



							N410-3	N410V-3	N411V-3	N410-3
N410-3										
N410V-3										
N411V-3										
N410-3										
$\varnothing d_1$ NPT, NPTF	P TPI	l_1 mm	l_2 mm	d_2 mm	a mm		ID	ID	ID	ID
1/16	27	71	13.0	7.0	5.5	3	101961	102021	102031	101971
1/8	27	71	13.0	8.0	6.2	5	101964	102024	102034	101974
1/4	18	80	20.0	11.0	9.0	5	101963	102023	102033	101973
3/8	18	90	20.0	12.0	9.0	5	101968	102028	102038	101978
1/2	14	100	26.0	16.0	12.0	5	101962	102022	102032	101972
3/4	14	110	26.0	20.0	16.0	5	101967	102027	102037	101977
1	11.5	125	32.0	25.0	20.0	5	101965	102025	102035	101975
1 1/4	11.5	125	32.0	32.0	24.0	5	101960	102020		
1 1/2	11.5	140	32.0	36.0	29.0	5	101959	102019		* 101969
2	11.5	160	32.0	36.0	29.0	7	101966	102026		* 101976

Vc (m/min) $\varnothing d1$				
NPT, NPTF 1/16" - 1/4"		3/8" - 1/2"	3/4" - 1"	1.1/4" - 2"
	6	5	4	3
	5	4	3	2
	10	8	7	5
	18	15	13	10

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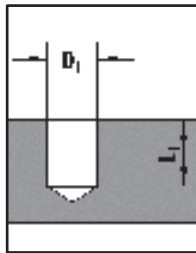


					D5800			
Ø" NPT, NPTF	l ₁ mm	l ₂ mm	d ₂ mm	α mm	ID			
1/16	70	17.0	6.0	4.9	118701			
1/8	70	17.0	8.0	6.2	110531			
1/4	80	27.0	10.0	8.0	110530			
3/8	85	27.0	12.0	9.0	110535			
1/2	95	35.0	16.0	12.0	110529			
3/4	105	35.0	20.0	16.0	110534			
1	130	43.0	25.0	20.0	110532			

Core hole diameters for NPT and NPTF threads Taladros previos para roscas NPT y NPTF

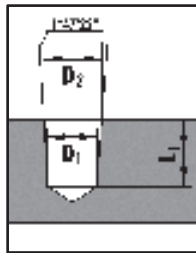
Parallel hole
Increased tap wear, not recommended

Taladros previos cilíndricos
Desgaste más rápido del macho. A evitar.



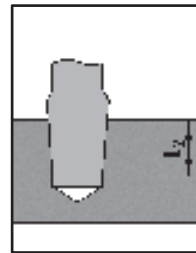
Tapered hole 1:16
Pre-drill at Ø D₁ and taper-ream to Ø D₂

Taladros previos cónicos 1:16
Taladrar cilíndrico según Ø D₁ y escariar cónico según Ø D₂



Tapped hole
Engage tap to hole depth L₂ = nominal Ø

Roscar
Roscar hasta la profundidad L₂ = Ø nominal



*Taper-ream at upper limit D₂ is recommended

*Es recomendado de escariar D₂ al máximo

Ø" NPT, NPTF	L ₁ min. mm	D ₁ mm	*D ₂ mini mm	*D ₂ maxi mm	L ₂ mm
1/16	11.40	6.00	6.413	6.505	10.179
1/8	11.65	8.30	8.760	8.852	10.217
1/4	16.85	10.80	11.397	11.483	14.958
3/8	17.20	14.20	14.836	14.922	15.268
1/2	22.25	17.50	18.333	18.419	19.920
3/4	22.70	22.80	23.678	23.764	20.403
1	27.20	28.65	29.726	29.812	24.518

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