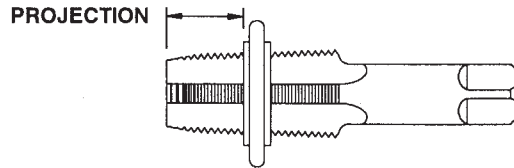


## SPECIAL TAPS ENGINEERING DATA

### TAPER PIPE TAP, THREAD 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	
Nominal Size Inches	Threads per Inch	Projection* Inches	Projection Tolerance + or -	Taper Per Foot Limits		L <sub>1</sub> Length	Tap Drill Size ** NPT,ANPT,NPTF
				Minimum	Maximum		
1/16	27	.312	.063	.719	.781	.160	C
1/8	27	.312	.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	.094	.719	.781	.400	1-9/64
1-1/4	11-1/2	.686	.094	.719	.781	.420	1-31/64
1-1/2	11-1/2	.699	.094	.719	.781	.420	1-23/32
2"	11-1/2	.667	.094	.719	.781	.436	2-3/16
2-1/2	8	.925	.094	.734	.781	.682	2-39/64
3"	8	.925	.094	.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 L<sub>1</sub> Taper Thread Ring Gage.
- \*\* Recommended size given permit direct tapping without reaming the hole, but only give a full thread for approx. the L<sub>1</sub> length.

**Lead Tolerance**

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