

HIGH SPEED STEEL PIPE TAPS

GENERAL PURPOSE

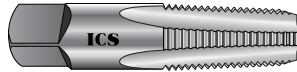
GROUND THREAD

ICS

WIS

Taper Thread

MEDIUM
HOOK



RIGHT HAND
CUT

NPT (Regular) Ground • NPTF (Dryseal) Ground

High Speed Steel Taper Pipe Taps (NPT) are designed for tapping ferrous and non-ferrous fittings used to connect pipes carrying fluids or gases and other places where very tight fits are needed. NPT threads taper 3/4" per foot and all of the threads on this tap do the cutting as compared to a (NPS) straight pipe tap where only the non-chamfered threads do the cutting. They require a sealant such as Teflon tape or pipe joint compound to prevent leakage of fluids or gases. NPT pipe taps can be used to tap threads to military aeronautical thread specifications (ANPT) and for work requiring ground thread accuracy and performance. (NPTF) Taper Thread Pipe Taps do not require sealants. Dryseal is attained by metal to metal contact.

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	LENGTH OF THREADS	OVERALL LENGTH	HIGH SPEED STEEL		TiN COATED		PIPE TAP DRILL SIZES
					TAPER REGULAR	TAPER REGULAR (DRYSEAL)	TAPER REGULAR	TAPER REGULAR (DRYSEAL)	
					NPT	NPTF	NPTT	NPTFT	
1/16	27	4	11/16	2-1/8	\$17.76	\$17.76	\$31.68	\$31.68	"C"
*1/8	27	4	3/4	2-1/8	17.76	17.76	31.68	31.68	"Q"
1/4	18	4	1-1/16	2-7/16	19.64	19.64	35.02	35.02	7/16
3/8	18	4	1-1/16	2-9/16	28.07	25.52	43.58	43.58	9/16
1/2	14	4	1-3/8	3-1/8	45.10	41.00	59.06	59.06	45/64
3/4	14	5	1-3/8	3-1/4	63.56	63.56	90.46	90.46	29/32
1	11-1/2	5	1-3/4	3-3/4	96.44	96.44	150.54	150.54	1-9/64
1-1/4	11-1/2	5	1-3/4	4	137.24	137.24	257.40	257.40	1-31/64
1-1/2	11-1/2	7	1-3/4	4-1/4	184.18	184.18	304.36	304.36	1-23/32
2	11-1/2	7	1-3/4	4-1/2	250.82	250.82	363.12	363.12	2-3/16
2-1/2	8	8	2-9/16	5-1/2	532.92	532.92	-	-	2-39/64
3	8	8	2-5/8	6	747.82	747.82	-	-	3-15/64
3-1/2	8	8	2-11/16	6-1/2	785.86	-	-	-	3-3/4
4	8	8	2-3/4	6-3/4	1067.12	-	-	-	4-1/4

* Available in large [.4375] or small [.3125] diameter shank. If not specified, large will be shipped.

Interrupted Thread



NPT (Regular) Ground • NPTF (Dryseal) Ground

MEDIUM
HOOK

Straight Thread



NPS (Regular) Ground • NPSF (Dryseal) Ground

High Speed Steel Interrupted Thread Pipe Taps (NPTI) are designed for tapping soft or tough stringy metals that tend to load threads with chips. Interrupted Thread Pipe Taps start with a few full threads and then have every other thread removed along the thread helix to provide more chip space, better lubrication, and to reduce drag. (NPTIF) Dryseal Interrupted Thread Pipe Taps do not require a sealant. Dryseal is attained by metal to metal contact. The interrupted thread design prevents tearing of material as tap threads only cut one side at a time.

High Speed Steel Straight Thread Pipe Taps (NPS) are designed for tapping holes or couplings for low pressure work that will adjust at assembly to the taper of external threads. A sealant must be used to secure a pressure tight joint. They may be used to produce NPSC and NPSM threads. (NPSF) Straight Thread Pipe Dryseal Taps do not require a sealant. Dryseal is attained by metal to metal contact. They are primarily used to tap holes that connect oil and fuel lines.

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HIGH SPEED STEEL	
			TAPER INTERRUPTED	TAPER INTERRUPTED (DRYSEAL)
			NPTI	NPTIF
1/16	27	4	\$24.32	\$24.32
*1/8	27	4	24.32	24.32
1/4	18	4	26.78	26.78
3/8	18	4	34.08	34.08
1/2	14	4	54.22	54.22
3/4	14	5	85.36	85.36
1	11-1/2	5	130.82	130.82
1-1/4	11-1/2	5	183.92	183.92
1-1/2	11-1/2	7	247.06	247.06
2	11-1/2	7	334.84	334.84

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HIGH SPEED STEEL	
			STRAIGHT	STRAIGHT (DRYSEAL)
			NPS	NPSF
1/16	27	4	\$17.96	\$17.96
*1/8	27	4	17.96	17.96
1/4	18	4	20.94	20.94
3/8	18	4	26.10	26.10
1/2	14	4	47.30	47.30
3/4	14	5	66.58	66.58
1	11-1/2	5	105.06	105.06
1-1/4	11-1/2	5	151.52	151.52
1-1/2	11-1/2	7	202.76	202.76
2	11-1/2	7	276.64	276.64

NOTE: All drilled holes should be reamed before tapping with a pipe reamer having a taper of 3/4" inch per foot – see Pipe Reamers page in Reaming Tools Catalog for correct size.