

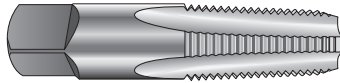
# HIGH SPEED STEEL NPT & NPTF TAPER PIPE TAPS

ICS WIS

GENERAL PURPOSE

GROUND THREAD

## Left Hand Thread



NPT (L.H. Regular) Ground

MEDIUM  
HOOK

## Long Taper Thread



NPT (Regular) Ground

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HSS	PIPE TAP DRILL SIZES
			TAPER REGULAR (LEFT HAND) NPTLH	
1/16	27	4	30.32	"C"
*1/8	27	4	30.32	"Q"
1/4	18	4	35.34	7/16
3/8	18	4	45.54	9/16
1/2	14	4	65.82	45/64
3/4	14	5	101.32	29/32
1	11-1/2	5	172.08	1-9/64
1-1/4	11-1/2	5	283.10	1-31/64
1-1/2	11-1/2	7	344.64	1-23/32
2	11-1/2	7	557.62	2-3/16

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HIGH SPEED STEEL	
			6" LENGTH NPT-06L	12" LENGTH NPT-12L
1/16	27	4	32.66	-
*1/8	27	4	32.66	-
1/4	18	4	36.90	57.82
3/8	18	4	49.30	74.58
1/2	14	4	63.50	108.46
3/4	14	5	100.62	136.90
1	11-1/2	5	128.70	185.82

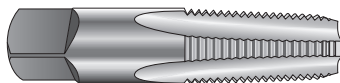
# HIGH SPEED STEEL BRITISH (METRIC) STANDARD PIPE TAPS

ICS USA

GENERAL PURPOSE

GROUND THREAD

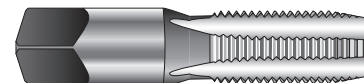
## British (Taper) Standard (Rc)



BSPT (Regular) Ground

MEDIUM  
HOOK

## British (Parallel) Standard (G or Rp)



BSPP (Regular) Ground

High Speed Steel British Standard Pipe Taper Taps (BSPT) are the European equivalent of American Standard Taper Pipe Taps (NPT) and are sometimes referred to as Metric Taper Pipe Taps. They are designed for tapping ferrous and non-ferrous pipe fittings used to connect pipes carrying fluids or gases. They require a sealant such as Teflon tape or pipe joint compound to prevent leakage of fluids or gases. (BSPT) taps are used for work requiring ground thread accuracy and performance.

High Speed Steel British Standard Pipe Parallel Taps (BSPP) are the European equivalent of American Standard Straight Pipe Taps (NPS) and are sometimes referred to as Metric Straight or Parallel Pipe Taps. They 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.

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HSS	PIPE TAP DRILL SIZES
			BRITISH STANDARD (TAPER) BSPT	
1/8	28	4	16.78	5/16
1/4	19	4	18.00	27/64
3/8	19	4	25.20	9/16
1/2	14	4	36.76	11/16
5/8	14	4	105.00	25/32
3/4	14	4	50.82	29/32
7/8	14	4	74.56	1-1/16
1	11	6	78.44	1-1/8
1-1/4	11	6	113.92	1-15/32
1-1/2	11	6	151.72	1-25/32
2	11	6	212.20	2-5/32

NOMINAL SIZE	THREADS PER INCH	NO. OF FLUTES	HSS	PIPE TAP DRILL SIZES
			BRITISH STANDARD (PARALLEL) BSPP	
1/8	28	4	16.78	"S"
1/4	19	4	18.00	15/32
3/8	19	4	25.20	19/32
1/2	14	4	36.76	3/4
5/8	14	4	46.20	53/64
3/4	14	4	50.82	31/32
7/8	14	4	74.56	1-7/64
1	11	6	78.44	1-7/32
1-1/4	11	6	113.92	1-9/16
1-1/2	11	6	151.72	1-25/32
2	11	6	212.20	2-1/4