

【Question】



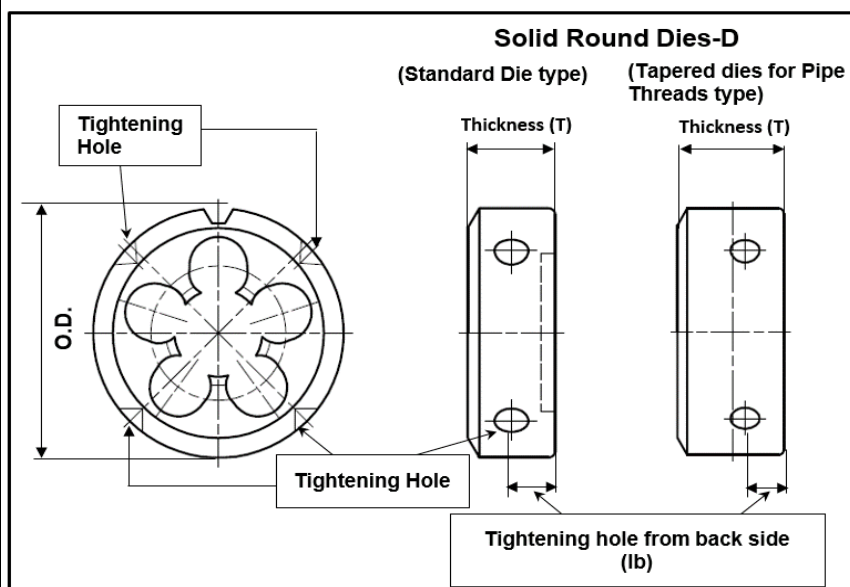
In order to machine a external PT Threads, I heard that Solid Dies are better than conventional dies. When I attached a PT 1/4 Solid Die for Pipe Threads with a 38mm outside diameter into a standard 38mm die holder to process metric threads it does not work. It seems that the tightening hole positions for fixing the die into the holder is different. How can I use a Pipe PT Solid Die in a standard holder?

【Answer】

Even though they have the same outside diameter, the PT Solid Dies for JIS standard pipes have different tightening hole positions than the standard dies for Metric Threads. YAMAWA Solid Round Dies-D cannot be used with a standard die holder. However, the new YAMAWA "D PT Solid Round Dies for Taper Pipe threads" has the same tightening hole position as a metric die, so you can install and tighten it. Please designate "Solid Round Dies for Taper Pipe Threads when purchasing".



【Guide】



The table below compares the tightening hole positions of a "Standard Die", a conventional "Pipe Taper Thread Solid Die" and the new "Solid Round Dies for Taper Pipe Threads: D". Most of the tightening hole positions of the conventional Pipe Tapered Solid Dies are not in the same location as that of a Standard Die. The new YAMAWA "Solid Round Dies-D" tightening hole positions match all the standard dies locations so you can use a Standard Die holder.

Thickness and Tightening hole position of Standard Die and Dies for Taper Pipe Threads

Standard Die

O.D.	Thickness (T)	Tightening hole (lb)
φ38	13	6.5
φ50	16	8
φ63	20	10
φ75	25	12.5

Solid Round Dies for Taper Pipe Thread

O.D.	Size	Thickness (T)	Tightening hole from back side (lb)
φ38	PT1/16	13	6.5
	PT1/8		
	PT1/4	18	
φ50	PT3/8	22	8
	PT1/2		
φ63	PT5/8	24	10
	PT3/4		
φ75	PT7/8	30	12.5
	PT1"		
	PT1 1/4"		
	PT1 1/2"		

Solid die shape for conventional Taper Pipe Thread (JIS standard)

O.D.	Size	Thickness (T)	Tightening hole from back side (lb)
φ38	PT1/16	11	5.5
	PT1/8		
	PT1/4	16	
φ50	PT3/8	18	9
	PT1/2	22	11
φ63	PT5/8	22	11
	PT3/4	24	12
φ75	PT7/8	25	12.5
	PT1"	28	14
	PT1 1/4"	30	15
	PT1 1/2"	30	15



**D PT:
Solid
Round
Dies for
Taper
Pipe
Threads**