

【Consultation】



Is the external parallel pipe threads "G" the same as "PF"?
What dies should I use? Can I produce the external parallel
pipe threads with the solid dies "D PF"?

The external parallel pipe threads "G" is basically the same as
"PF". The symbol of the threads has been changed from "PF"
to "G". You can use YAMAWA "D PF" for both of the external
parallel pipe threads, "PF" and "G".



【Answer】



"PF" is a symbol used in the old JIS standard for external parallel pipe
threads. The symbol is "G" in the current JIS standard.
Please refer to the table below. As you can see, the external parallel pipe
threads "PF 1/2-14" and "G1/2-14" have the same dimensions.

Unit: mm

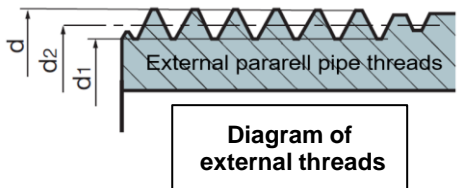


Diagram of
external threads

Specifications of external threads	Old JIS PF1/2-14(Class A)			Current JIS G 1/2-14(Class A)	
	Basic diameter	Tolerance		Basic diameter	Tolerance
d Major diameter	20.955	0 -0.284	➡	20.955	0 -0.284
d2 Pitch diameter	19.793	0 -0.142		19.793	0 -0.142
d1Minor diameter	18.631	0 ~		18.631	0 ~
Specifications of external threads	Old JIS PF1/2-14(Class B)			Current JIS G 1/2-14(Class B)	
	Basic diameter	Tolerance		Basic diameter	Tolerance
d Major diameter	20.955	0 -0.284	➡	20.955	0 -0.284
d2 Pitch diameter	19.793	0 -0.284		19.793	0 -0.284
d1Minor diameter	18.631	0 ~		18.631	0 ~



YAMAWA's solid dies for external parallel pipe threads
"D PF" have a symbol of "PF", but they can be used for
both external parallel pipe threads "PF" and "G".



【Advice】



The external parallel pipe threads "PF" and "G" are used in combination
with the internal parallel pipe threads "PF" and "G". They cannot be used
in combination with a internal taper pipe threads "PT, Rc" or internal
parallel threads for taper pipe threads "PS, Rp".
The reason for this is the purpose and standard of the pipe threads are
different, so they will not engaged properly. Pipe threads are quite
"complicated"!