

No. 092

## External Thread Length at processing with D PT

Dies

### 【Consultation】



We are planning to process a PT 3/8-19 external tapered pipe thread with a YAMAWA taper pipe thread solid die "D PT" but how far should we process the external thread length with this die?

### 【Answer】

When processing an external tapered pipe thread with a Yamawa PT 3 / 8-19 solid die "D PT", try setting the insertion length of the die to 16 mm. Since this value is a rough guide, you will need to make the final adjustment in length by using a taper pipe thread ring gauge. When processing other dimensions, please refer to the list below.



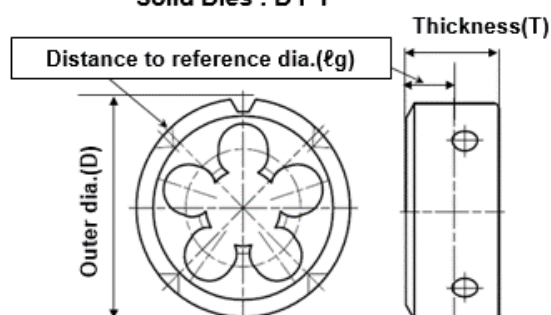
### 【Description】

## D PT

Solid Round Dies for Taper Pipe Threads



Solid Dies : D PT



Solid dies for tapered pipe threads:

D PT geometry and insertion length at processing(list)

Size	D (mm)	T (mm)	lg (mm)	Number of chip holes	Die insertion length at	
					Referenc e length	Tolerance
PT 1/16 - 28	38	13	6	4	10	9.06 ~ 10.88
PT 1/8 - 28	38	13	6	4	10	9.06 ~ 10.88
PT 1/4 - 19	38	18	8.5	5	15	13.17 ~ 15.85
<b>PT 3/8 - 19</b>	<b>50</b>	<b>22</b>	<b>10</b>	<b>5</b>	<b>16</b>	<b>15.01 ~ 17.69</b>
PT 1/2 - 14	50	22	12	6	20	18.35 ~ 21.97
PT 5/8 - 14	63	24	12	6	20	18.35 ~ 21.97
PT 3/4 - 14	63	24	12.5	6	22	20.22 ~ 23.84
PT 7/8 - 14	75	30	12.5	6	22	20.22 ~ 23.84
PT 1 - 11	75	30	15	6	25	23.08 ~ 27.70
PT 1 1/4 - 11	75	30	15	6	28	25.39 ~ 30.01
PT 1 1/2 - 11	75	30	15	6	28	25.39 ~ 30.01
PT 2 - 11	105	36	17.5	8	33	31.07 ~ 35.69

### 【Advice】



For the insertion length (F): Please use the reference length as a guide. The details of the insertion length are shown in the Tolerance difference column in the table above. Please note, there is production tolerance in the die D PT so, always check with a tapered pipe thread ring gauge.

External thread for pipe.

