

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

S
JIS

NPS

Hand Taps for American Parallel Pipe Threads



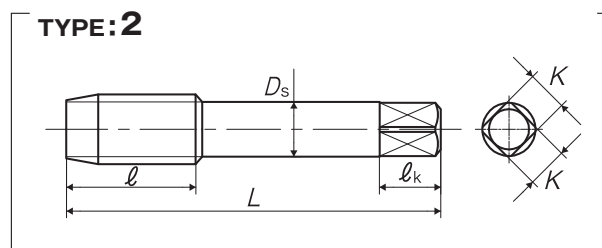
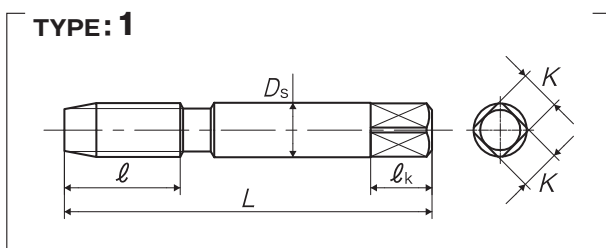
Specification



■ The NPS tap is a hand tap for American parallel threads and is used for products whose main purpose is the tightness of the threaded part in connecting pipe parts and the like.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10	5~10	5~10
(m/min)	(m/min)	(m/min)



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads												
1/16-27 NPS	ANSI G	TNPS01L	5P	7.770	54	17	8	6	9	4	1	¥ 5,210*
1/8-27 NPS	ANSI G	TNPS02L	5P	10.117	55	19	8	6	9	4	2	¥ 5,210*
1/4-18 NPS	ANSI G	TNPS04O	5P	13.426	62	28	11	9	12	4	2	¥ 7,630*
3/8-18 NPS	ANSI G	TNPS06O	5P	16.866	65	28	14	11	14	4	2	¥ 12,700*
1/2-14 NPS	ANSI G	TNPS08Q	5P	20.980	80	35	18	14	17	4	2	¥ 20,600*
3/4-14 NPS	ANSI G	TNPS12Q	5P	26.325	85	35	23	17	20	4	2	¥ 33,200*
1 -11 1/2 NPS	ANSI G	TNPS16T	5P	32.934	95	45	26	21	24	5	2	¥ 61,600*
1 1/4-11 1/2 NPS	ANSI G	TNPS20T	5P	41.689	105	45	32	26	30	5	2	¥ 94,600*
1 1/2-11 1/2 NPS	ANSI G	TNPS24T	5P	47.760	110	45	38	29	32	6	2	¥ 135,000*
2 -11 1/2 NPS	ANSI G	TNPS32T	5P	59.797	120	50	46	35	38	6	2	¥ 225,000*

The internal threads that can be machined with NPS taps are “NPSC” and “NPSM.”

■ Taps for American pipe threads

Tap Name	Product Symbol	Class	Material	Type Symbol of Thread to Be Cut	Specified Range of Shape and Dimensions
Tap for parallel pipe threads	NPS	Ground Thread	HSS	NPSC NPSM	1/8 ~ 1

NPSC internal threads are combined with NPT external threads, and NPSM internal threads are combined with NPSM external threads.

■ Combination of internal and external threads for American pipe threads

Standard	Name	Internal Thread	External Thread to Be Combined with
American standard pipe thread (ANSI/ASME B1.20.1)	American standard parallel pipe thread for straight pipe fittings	NPSC	NPT
	American standard parallel pipe thread for fixtures intended for mechanical coupling	NPSM	NPSM

For the bored hole size, please refer to page 42 of TECHNICAL INFORMATION.

Spiral Fluted Taps (for blind hole) ①

Spiral Fluted Taps (for through hole) ②

Spiral Pointed Taps (for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps ⑦

Pipe Taps ⑧

Thread Mills Premium Thread Mills ⑨

Simple Inspection Tools Related Products ⑩

Dies ⑪

Center Drills Centering Tools ⑫

Precision Machinery/ Medical Surgical Instruments ⑬