

NPS AND NPSF THREDFLOER PIPE TAPS

NPS and NPSF threads require reamed pre-tap holes because of the requirement for 100% threads with controlled crest dimensions. NPSF taps are being successfully used in diecast applications, however, care in their application and use is required. Diecast aluminum containing high-silicon can become brittle when cold formed and may crumble at the crest of the thread.



TAP SIZE	NPS EDP#	NPSC EDP#	NPSM EDP#	NPSF EDP#	*HOLE SIZE FOR 75% THREAD	
					FOR NPS, NPSC, NPSM	FOR NPSF
1/16-27				02030	-	.281 - .282"
1/8-27 SM (.3125 SHANK)	02120	02122	02124	02130	.379 - .380"	.373 - .374"
1/8-27 LG (.4375 SHANK)	02220	02222	02224	02230	.379 - .380"	.373 - .374"
1/4-18	02320	02322	02324	02330	.499 - .500"	.491 - .492"
3/8-18	02420	02422	02424	02430	.636 - .637"	.626 - .627"
1/2-14	02520	02522	02524	02530	.788 - .790"	.777 - .779"
3/4-14	02620	02622	02624	02630	.998 - 1.000"	.988 - .990"

** For diecast parts, subtract .001" - .002" to compensate for porosity.*

IN-LINE STUB THREDFLOERS

Balax In-line Stub Thredfloers feature a bottom style thread chamfer and controlled blank dimensions and chamfer length. Tap front points are removed to reduce the tapping stroke to provide clearance within the tapping die. In-line taps are available with TiN, TiCN and TiALN surface treatments.



ANSI

TAP SIZE	H4	H5	H6	H7	H8
2-56	10344				
4-40		10865			
6-32		11425			
8-32		11765			
10-24				12107	
10-32		12325			
1/4-20					12788
1/4-28				13007	

METRIC

TAP SIZE	D5	D6	D7	D8	D9
M2 x .4	17365				
M2.5 x .45		17506			
M3 x .5		17686			
M3.5 x .6			17887		
M4 x .7			18087		
M5 x .8				18288	
M6 x 1.0					18489