

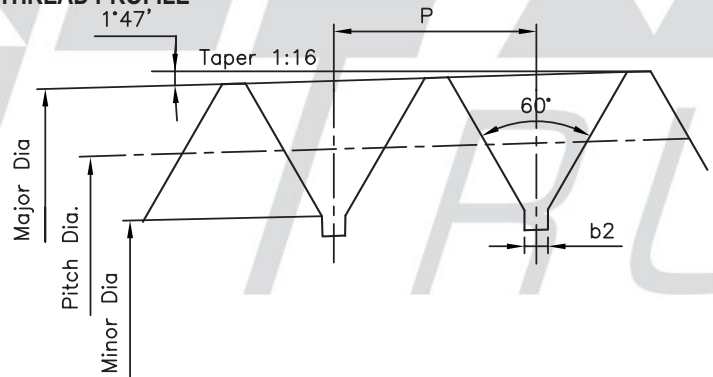
NPTF / PTF THREADS

Application: NPTF threads can provide pressure tight seal on threads without the use of a sealing compound (dry seal type) PTF are short gauges (less thickness) which are used for application similar to NPTF.

SPECIFICATION :

ANSI / ASME B1.20.6 – 1984 which is metric translation of ANSI B1.20.5 – 1978 and H-28 Part II 1957

NPTF / PTF THREAD PROFILE



MANUFACTURING RANGE

DIA IN INCH	TPI	Type of Thread Gauges used				
1/16, 1/8	27	Taper Plug Gauges	Plain Taper Plugs to check Crest of Threads.	Taper Ring Gauges	Check Plugs / Master Plugs to check L1 & L2 Taper Rings.	Crest Check Plain Taper Ring Gauge. 6 Step Design.
1/4, 3/8	18	L1 Basic		L1 Basic		
1/2, 3/4	14	L3 Basic		L2 Basic		
1, 1.1/4, 1.1/2, 2	11.5	OR		OR		
2.1/2, 3	8	L1 Step Limit		L1 Step Limit		
		L3 Step Limit		L2 Step Limit		

For Internal Threads (Thread Plug Gauges)

two types are recommended.

L1 – To check effective diameter of thread to hand tightness at the gauge line (large end dia.)

L3 – To check effective dia. of remaining thread length (small end dia.) and the taper cone.

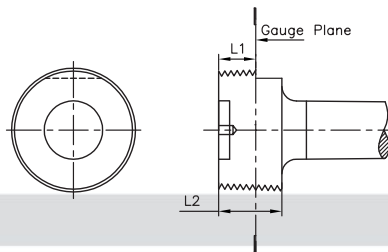
For External threads (Thread Ring Gauges)

two types are recommended.

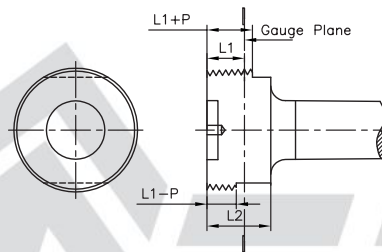
L1 – To check effective diameter of thread to hand tightness at the gauge line (large end dia.)

L2 – To check effective dia. of remaining thread length (small end dia.) and the taper of cone.

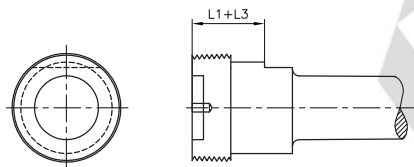
Normally L2 rings and L3 plugs are used in addition to L1 gauges, where more stringent, examination is required. The use of L2 and L3 gauges is only effective when the designed full thread length in the work piece is one thread longer than the nominal thread length.



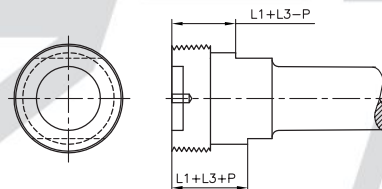
NPTF L1 Basic Plug



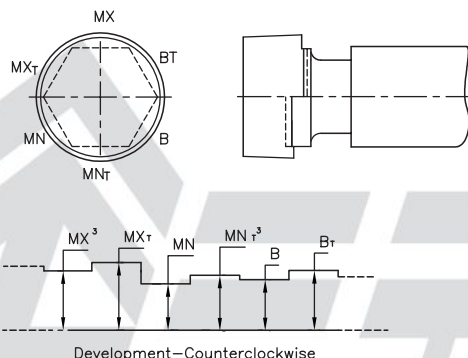
NPTF L1 Step Limit Plug



NPTF L3 Basic Plug



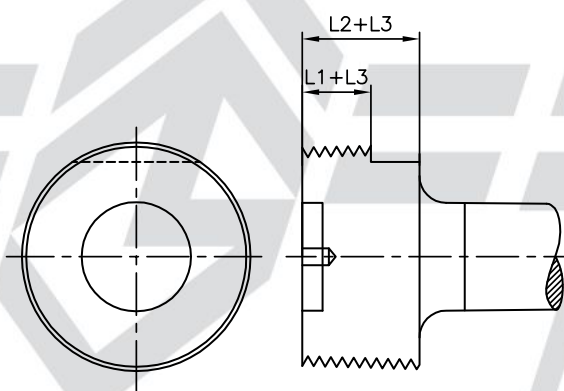
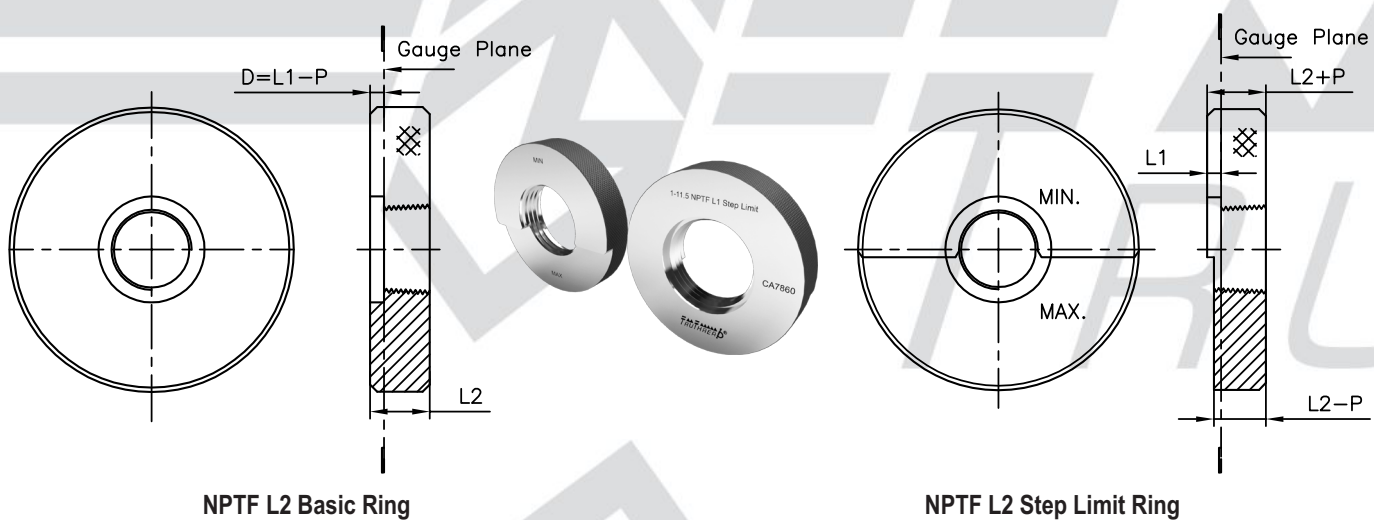
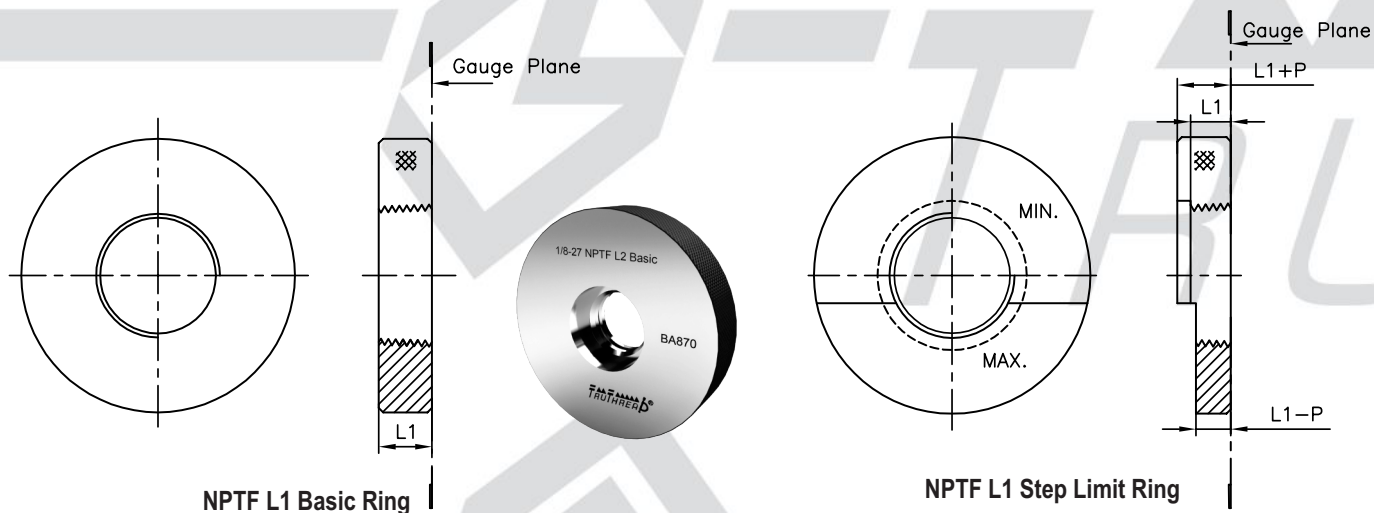
NPTF L3 Step Limit Plug



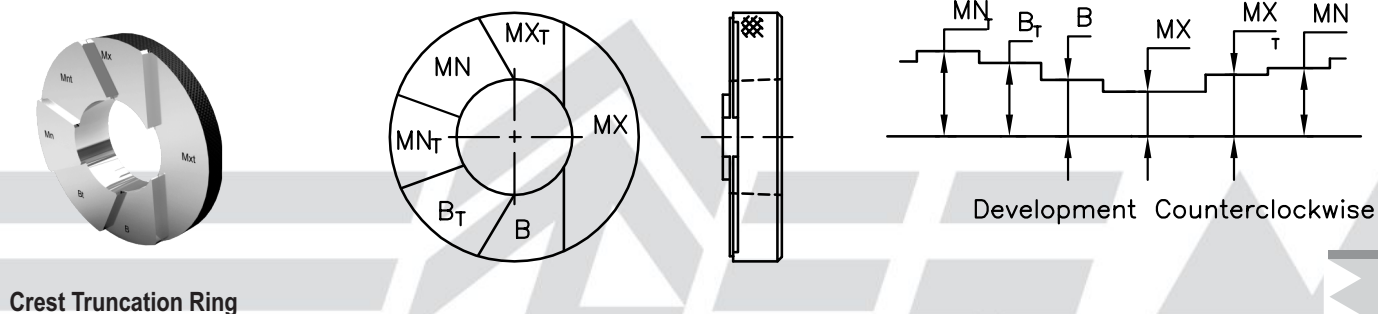
Taper Plain Plug To Check Crest Of Threads.

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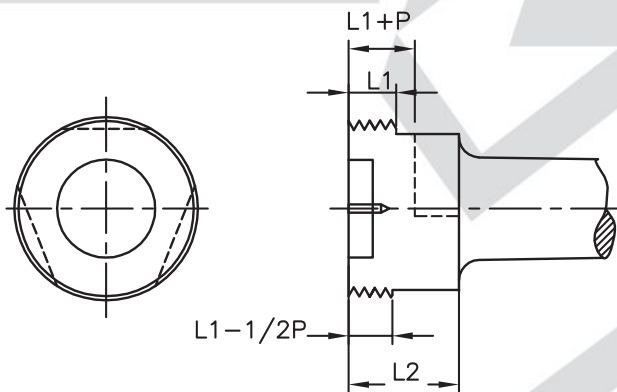
CP / Master Plug Gauge For Checking L1 & L2 Rings



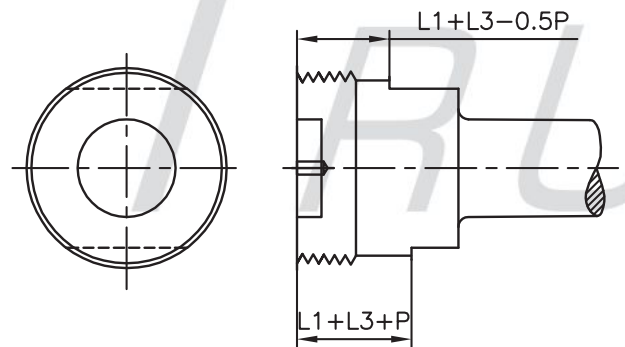
NPTF / PTF THREADS

Application: NPTF threads can provide pressure tight seal on threads without the use of a sealing compound (dry seal type) PTF are short gauges (less thickness) which are used for application similar to NPTF.

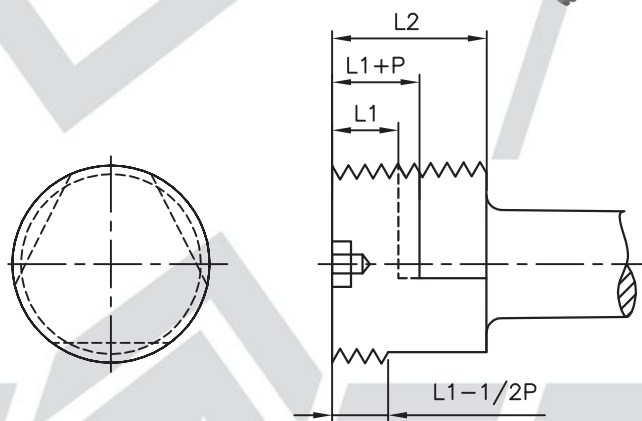
GAUGES FOR PTF (SHORT); NPSF, & NPSI THREADS



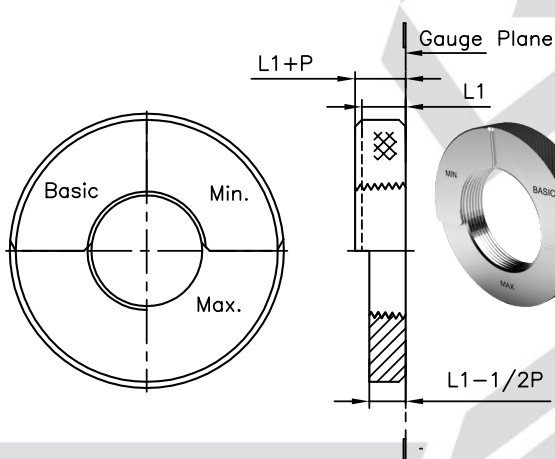
PTF SAE L1 short OR NPSF L1 PLUG



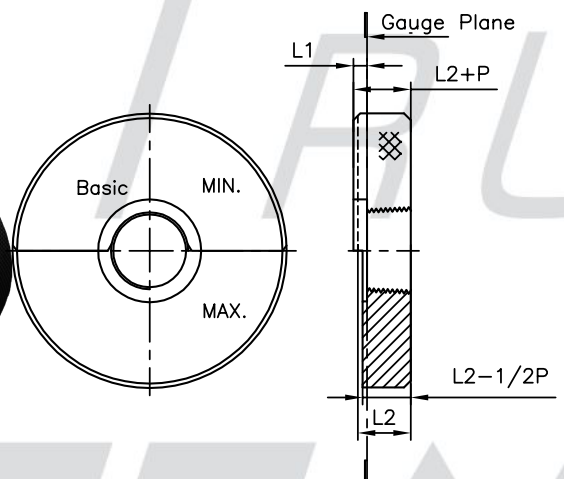
PTF SAE L3 short PLUG



NPSI L1 PLUG



PTF SAE L1 Short Ring



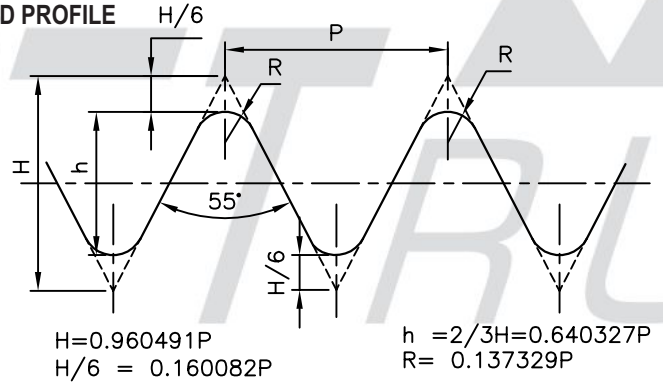
PTF SAE L2 Short Ring

PIPE / 'G' THREADS

Application: General purpose pipe threads, where pressure tight joints are not required on threads.



PIPE / 'G' THREAD PROFILE



SPECIFICATION :

I.S.O standard - Basic Dimensions : ISO 228 (1) – 2000(E)
 Gauging Practice : ISO 228 (2) – 1987 (E)
 Indian Standard - Basic Dimensions : IS 2643 – 2005
 Gauging Practice : IS 10216 – 1988
 BSI Standard - B.S 2779 – 1986.
 JIS standard- B 0202-1999 * See Footnote for details.

MANUFACTURING RANGE

Pipe Diameter.	TPI	Tolerance Class	
1/16, 1/8	28	Thread Plugs. Only General Class	Thread Rings • Class B • Class A Tolerance for class 'A' rings are close / tighter than Class 'B'. In case of pitch diameter tolerance, Class 'A' tolerance is exactly half the Class 'B' tolerance.
1/4, 3/8	19		
1/2, 5/8, 3/4, 7/8	14		
1, (1.1/16), 1.1/8, 1.1/4, (1.3/8), (1.5/8), 1.3/4, (1.7/8), 2, (2.1/8), 2.1/4, (2.5/16), (2.3/8), 2.1/2, 2.3/4, (2.7/8), 3, (3.1/4), 3.1/2, 4, 4.1/2, 5, 5.1/2, 6	11		

- Pipe Diameters in parenthesis () are not recommended in above refereed IS/ ISO specifications. On customer request we can manufacture gauges for these sizes.

- * JIS B 0202-1999 Specification covers sizes from 1/8" to 12". Sizes from 1/8" to 6", which are covered in ISO 228 Part 2, are based on ISO specification. The sizes above 6" Pipe Diameter are manufactured based on JIS.

The designation used for Parallel Pipe threads in JIS is **PF**.

BRITISH STANDARD PIPE TAPER THREADS (BSPT_r)

Application : Used for fastening of pipe threads where, pressure tight joints are required on threads.

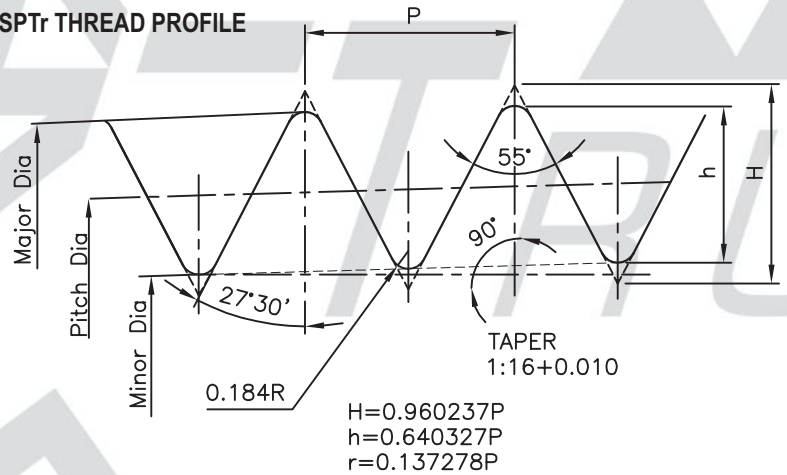
SPECIFICATION :

BS Standard: BS 21-1985.

Indian Standard: * Basic Dimensions: IS 554-1975,
* Gauging Practice: IS 8999 - 1979

* These specifications are replaced first by ISO 7/2-1984 & later on by ISO 7/2-2000. As these gauges are still used in industry. we manufacture these based on specific customer request.

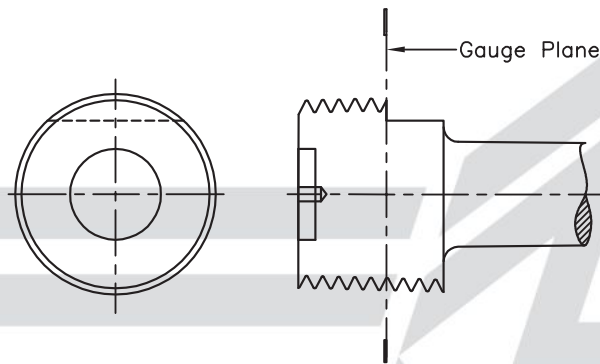
BSPT_r THREAD PROFILE



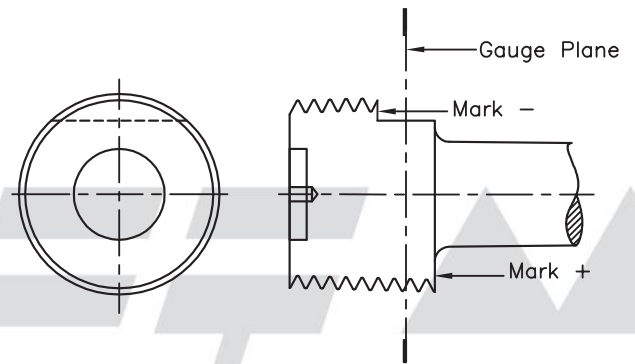
MANUFACTURING RANGE.

Diameter (Inch)	TPI	Type of Gauges			
1/16, & 1/8	28	Thread Plug Gauges	Thread Ring Gauges	Check Plug to check NEW Rings	Wear Check Plug Gauges to check/ calibrate used Rings.
1/4 & 3/8	19				
1/2 & 3/4	14	System A. & System B.	System A & System B	System A & System B	System A & System B
1, 1.1/4, 1.1/2, 2, 2.1/2, 3	11				
4, 5, 6					

Specification recommends,
To check Internal Taper Threads -
Taper Thread Plug either System 'A' OR System 'B'

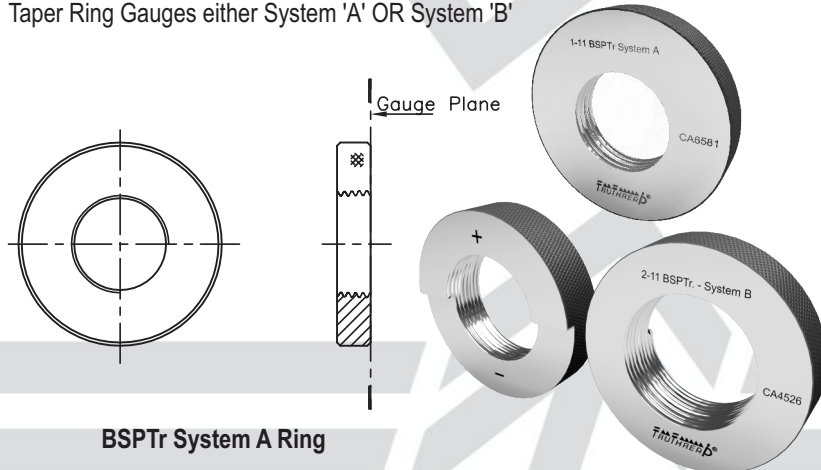


BSPT_r System A Plug

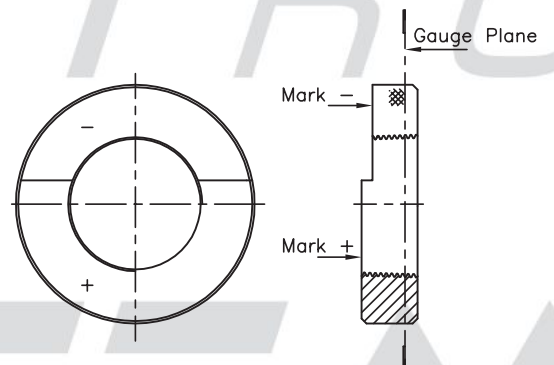


BSPT_r System B Plug

To check external Taper Threads.
Taper Ring Gauges either System 'A' OR System 'B'



BSPT_r System A Ring



BSPT_r System B Ring