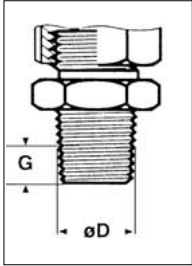


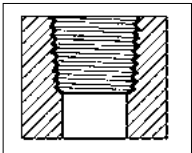
## NPT-NPTF threads

NPT – National Pipe Taper threads for connections where pressure-tight joints are made on the threads utilising a thread sealant.

NPTF – National Pipe Taper Fuel threads for connections where pressure-tight joints are made on the threads, without a thread sealant.



NPTF male thread



NPTF female thread

### NPT threads

The National Pipe Taper thread has a thread angle of 60° and is used mainly in the petrochemical and process industries.

NPTF thread – to SAE J476-B2 –  
60° form 1 in 16 taper – Conicity 6,25 %

thread size NPTF		threads per inch	Pitch	D	G	Assembly turns (steel)
						TFFT
1/8"	in mm	27	0.037 0.94	0.40 10.24	0.16 4.1	2-3
1/4"	in mm	18	0.056 1.41	0.54 13.61	0.23 5.8	2-3
3/8"	in mm	18	0.056 1.41	0.67 17.05	0.24 6.1	2-3
1/2"	in mm	14	0.071 1.81	0.84 21.22	0.32 8.1	2-3
3/4"	in mm	14	0.071 1.81	1.05 26.56	0.34 8.6	1.5-2.5
1 1/4"	in mm	11 1/2	0.087 2.21	1.33 33.78	0.42 10.7	1.5-2.5
1 1/2"	in mm	11 1/2	0.087 2.21	1.89 48.05	0.42 10.7	1.5-2.5

### Important:

Taper threads should not be used for new projects or designs. Parker Hannifin recommends elastomerically sealed components.

### Turns from Finger Tight (T.F.F.T.) method

The proper method of assembling pipe threaded connectors is to assemble them finger tight and then wrench tighten further to the specified number of turns from finger tight (T.F.F.T.) given in the table. The assembly procedure given below is recommended to minimize the risk of leakage and/or damage to components.

- 1 Inspect port and connectors to ensure that threads on both are free of dirt, burrs and excessive nicks.
- 2 Apply sealant/lubricant to male pipe threads (Pre-applied dry sealants are preferred over other sealants). With any sealant, the first one to two threads should be left uncovered to avoid system contamination. If PTFE tape is used it should be wrapped 1½ to 2 turns in clockwise direction when viewed from the pipe thread end.

Caution: more than two turns of tape may cause distortion or cracking of the port.

- 3 Screw the connector into the port to the finger tight position.

- 4 Wrench tighten the connector to the appropriate T.F.F.T. values shown in the table, making sure that the tube end of a shaped connector is aligned to receive the incoming tube or hose assembly.

Never back off (loosen) pipe threaded connectors to achieve alignment.

- 5 If leakage persists after following the above steps, check for damaged threads and total number of threads engaged.