



NPT Taper Pipe Taps. These general purpose taper pipe taps are ideal for threading a wide variety of materials, such as steels and irons, can also be used for nonferrous and nonmetallic materials.

Ground thread taper pipe taps are standard in American Standard Pipe Form (NPT).

The nominal size of a pipe taps is that of the pipe fitting to be tapped, not the actual size of the tap. The thread tapers 3/4 of an inch per foot.

Taper Pipe Taps- General Purpose

NPT



NPT taps have an Oxide Surface Treatment Custom Blend High Vanadium HSS

List 3430 NPT ANPT

All pipe taps have a chamfer of 2-1/2 to 3-1/2 threads

Nominal Size	Threads per Inch	No. of Flutes	EDP Numbers NPT or ANPT	Dimensions	
				Length of Thread	Length Overall
1/16	27	4	383100	11/16	2- 1/8
1/8 (Lg. Shank)	27	4	383101	3/4	2- 1/8
1/8 (Sm. Shank)	27	4	383102	3/4	2- 1/8
1/4	18	4	383103	1- 1/16	2- 7/16
3/8	18	4	383104	1- 1/16	2- 9/16
1/2	14	4	383105	1- 3/8	3- 1/8
3/4	14	5	383106	1- 3/8	3- 1/4
1	11- 1/2	5	383107	1- 3/4	3- 3/4
1- 1/4	11- 1/2	5	383108	1- 3/4	4
1- 1/2	11- 1/2	7	383109	1- 3/4	4- 1/4
2	11- 1/2	7	383110	1- 3/4	4- 1/2

Troubleshooting

Problem	Causes	Solutions
Chipping	Excessive Tapping Speed Misalignment Hole Size is Too Small Poor Tapping Fluid	Increase Tapping Speed to 15-18 SFM Adjust or Use Radial Float Tapping Head Check Hole Size Use a Heavy Duty Lubricant
Poor Finish (Chatter Mark)	Excessive Tapping Speed Excessive Hook Angle Poor Tapping Fluid	Reduce Tapping Speed to 10-15 SFM Adjust Hook Angle During Re grind Use Cutting Oil or tapping Lubricant
Stop Mark	Excessive Tapping Speed Poor Tapping Head Poor Setup	Reduce Tapping Speeds to 10-15 SFM Use Floating Tapping Head Use Special Design Taps or Thread Mill