



### NPTF Thread Tapping Tools\*

NPTF taps are available for taper pipe thread connections in sizes 1/8" through 1 1/2". All taps are bottoming type manufactured from high speed steel.

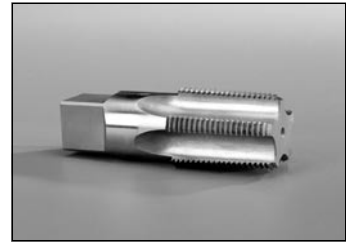


Fig. S87 — NPTF Port Tap

Shank Dia. (in.)	Overall Length (in.)	Thread Size	Part No.
0.438	2 1/8	1/8-27	974244-1/8
0.563	2 7/16	1/4-18	974244-1/4
0.700	2 9/16	3/8-18	974244-3/8
0.688	3 1/8	1/2-14	974244-1/2
0.906	3 1/4	3/4-14	974244-3/4
1.125	3 3/4	1-11 1/2	974244-1
1.313	4	1 1/4-11 1/2	974244-1-1/4
1.500	4 1/4	1 1/2-11 1/2	974244-1-1/2

### ISO 6149-1 Straight Thread Port Tapping Tools\*

ISO 6149-1 female straight thread port taps are available for M8 to M48 port sizes. Taps are bottoming type and made from high speed steel.



Fig. S88 — ISO 6149-1 Straight Thread Port Tap

Overall Length (in.)	Shank Dia. (in.)	Wrench Flat Size (in.)	Thread Size	Part No.
2 23/32	0.318	0.238	M8x1	M8X1
2 15/16	0.381	0.286	M10x1	M10X1-6H
3 3/8	0.367	0.275	M12x1.5	M12X1.5-6H TAP
3 19/32	0.429	0.322	M14x1.5	M14X1.5-6H-TAP
3 13/16	0.400	0.360	M16x1.5	M16X1.5-6H-TAP
4 1/32	0.542	0.406	M18x1.5	M18X1.5-6H-TAP
4 11/16	0.697	0.523	M22x1.5	M22X1.5-6H-TAP
5 1/8	0.896	0.672	M27x2	M27X2-6H-TAP
5 3/4	1.108	0.831	M33x2	M33X2-6H-TAP
7	1.430	1.072	M42x2	M42X2-6H-TAP
7 5/8	1.644	1.233	M48x2	M48X2-6H-TAP

### ISO 6149-1 Straight Thread Port Counterbore\*

Tool..... [See page \(S37\)](#)

### ISO 6149-1 Straight Thread Port Counterbore\*

Tool w/I.D. Groove..... [See page \(S37\)](#)

\* See [Appendix](#) for recommended use of port tools.

Dimensions and pressures for reference only, subject to change.