

Taper threads

Sl. No.	Designation	Small end major diameter (mm)	Taper on diameter	Thread angle	Thread per inch (TPI)	Specification	Remarks			
1a	1/8-27 NGT	9.984	1:16	60°	27	CGA V-1	Also as per IS : 12300 for refrigerant valves			
1b	1/4-18 NGT	13.253			18					
1c	3/8-18 NGT	16.672			14					
1d	1/2-14 NGT	20.716			Type 1, Size 1 of IS 3224	Also as per CGA V-1				
1e	3/4-14 NGT	26.029			Type 1, Size 2 of IS 3224					
i)	3/4-14 NGT (CI)-1	26.029			Standard size for Chlorine as per IS 3224					
ii)	3/4-14 NGT (CI)-2	26.484			4 turns oversize as per IS 3224 for Chlorine and other gases					
iii)	3/4-14 NGT	26.824			7 turns oversize as per IS 3224 : 2002 other than Chlorine					
iv)	3/4-14 NGT (CI)-3	26.995			8-1/2 turns oversize as per IS 3224 for Chlorine					
v)	3/4-14 NGT (CI)-4	27.617			14 turns oversize as per IS 3224 for Chlorine					
vi)	3/4-14 NGT (CI)-5	29.204			28 turns oversize as per CGA V-1 for Chlorine					
1f	1-11 1/2 NGT	32.593			1:16		60°	11.5	Type 1, Size 3 of IS 3224	Also as per CGA V-1
i)	1-11 1/2 NGT (CI)-1	32.593							Standard size as per CGA V-1 for Chlorine	Also as per Chlorine Institute P-17
ii)	1-11 1/2 NGT (CI)-2	33.144				4 turns oversize as per CGA V-1 for Chlorine				
iii)	1-11 1/2 NGT (CI)-3	33.766	8-1/2 turns oversize as per CGA V-1 for Chlorine							
iv)	1-11 1/2 NGT (CI)-4	34.523	14 turns oversize as per CGA V-1 for Chlorine							
v)	1-11 1/2 NGT (CI)-5	36.454	28 turns oversize as per CGA V-1 for Chlorine							
2a	W 19.8 (17E)	17.4	3:25	55°	14	Type 2 Size 1 of IS 3224 : 2014	Equivalent to 19.8 mm of DIN 477-1 : 1990, E 17 con of EN 144-1 and 17E of EN ISO 11363-1			
2b	W 28.8 (25E)	25.8				Type 2 Size 2 of IS 3224	Equivalent to 28.8 mm of DIN 477-1 : 1990, 25T of BS: 341-1991, 25E of EN ISO 11363-1 (supersedes EN 629-1 : 1996)			
2c	W 31.3 (28E)	28.3				DIN 477-1				

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3a	18.16* (18T)	18.16	1:8	55°	14	Type 4, Size 1 of IS 3224	Equivalent to 18T of BS 341-1 : 1991 and 0.715-18AU of AS 2473.2 Also as per BS 341-1962
3b	25.4 (1"BS)	25.4				Type 4, Size 2 of IS 3224	
i)	26.194 (1 1/32")	26.194				3.5 turns oversize as per IS 3224	Also as per BS 341-1962
ii)	26.987 (1 1/16")	26.987				7 turns oversize as per IS 3224	
iii)	27.781 (1 1/32")	27.781				10.5 turns oversize as per IS 3224	
iv)	28.574 (1 1/8")	28.574				14 turns oversize as per IS 3224	
3c	31.75* (32T)	31.75					
Sl. No.	Designation	Large end major diameter (mm)	Taper on diameter	Thread angle	Thread per inch (TPI)	Specification	Remarks
4a	V1	21.2	3:26	55°	14	JIS 8246	
4b	V2	29.5					
4c	V3	29.5					
4d	1.455"	40.3 (Approx.)					

* Oversize of 18.16 and 31.75 are also available (Refer IS 3224)

Parallel threads

Sl. No.	Designation	Thread angle	Major diameter (mm)	Specification	Remarks
1	3/4-16 UNF-2A	60°	19.012 / 18.773	JIS B 8246	Also as per IS 3224 : 2014
2	1 1/8-12 UNF-2A		28.529 / 28.240		
3	3/4-14 NPSM		26.264 / 26.010	JIS B 8246 and IS 3224 : 2014	Equivalent to 3/4-14 NGS-2A as per AS 2473.2
4	M18X1.5-6g		17.968 / 17.732	EN ISO 15245	Also as per EN 144-1, BS 341-1 : 1991 and IS 3224 : 2014
5	M25X2.0-6g		24.962 / 24.682		
6	M30X2.0-6g		29.982 / 29.662		

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