



Machine tap, uncoated, NPT: 1/4-18



Order data

Order number	138090 1/4-18
GTIN	4045197585523
Item class	12H

Description

Version:

Sturdy version, with straight flutes.

Application:

Tapered pipe threads (NPT) to **ANSI B1.20.1**, for threads with sealants. See the table for the specified minimum size of the tapping hole.

Recommendation:

Tapping hole Ø A:

Pre-drill a plain hole **without using a reamer**.

Tapping hole Ø B:

Pre-drill a plain hole and then **ream it using a 1:16 taper reamer (see No. 162650)**. The taper bore Ø can then be checked laterally by reference to the D_{max} check dimension (see table). **Variant B** for drilling the tapping hole offers the best process reliability for the tapping operation.

Threads per inch: 18

Overall length L: 100 mm

Shank Ø D_s : 11 mm

Shank square □: 9 mm

Tapping hole Ø A: 11.1 mm

Tapping hole Ø B: 10.75 mm

Technical description

Thread pitch	1.411 mm
Tapping hole Ø A	11.1 mm
Threads per inch	18

Thread Ø	13.616 mm
Number of clamping slots	5
Thread gauge Ø $D_{max} + 0.05$	11.36 mm
Tapping hole minimum depth	17.5 mm
Tapping hole Ø B	10.75 mm
Number of cutting edges Z	5
Shank Ø D_s	11 mm
Overall length L	100 mm
Shank square □	9 mm
Thread depth	25.84 mm
Thread size	1/4-18 NPT
Coating	uncoated
Thread type	NPT
Flank angle	60 degrees
Tool material	HSS E
Standard	Manufacturer's standard
Thread standard	ANSI B 1.20.1
Taper lead form	C
Taper ratio	1:16
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	for blind holes and through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for conventional machining
Colour ring	without
Type of product	Tap

