EMUGE

Gewindekernloch-Vorfertigungsdurchmesser
Thread Hole Preparatory Diameters

Metrische ISO-Gewinde
ISO Metric Threads

M

Metrisches ISO-Regelgewinde DIN 13
ISO Metric coarse thread DIN 13

Nenngröße Nom. size D mm	P mm	D_1 (6H) min. mm	max. mm	mm
M 1	0,25	0,729	0,785	**0,75**
1,1	0,25	0,829	0,885	**0,85**
1,2	0,25	0,929	0,985	**0,95**
1,4	0,3	1,075	1,142	**1,1**
1,6	0,35	1,221	1,321	**1,25**
1,7	0,35	1,321	1,421	**1,35**
1,8	0,35	1,421	1,521	**1,45**
2	0,4	1,567	1,679	**1,6**
2,2	0,45	1,713	1,838	**1,75**
2,3	0,4	1,867	1,979	**1,9**
2,5	0,45	2,013	2,138	**2,05**
2,6	0,45	2,113	2,238	**2,15**
3	0,5	2,459	2,599	**2,5** (2,55)
3,5	0,6	2,850	3,010	**2,9**
4	0,7	3,242	3,422	**3,3** (3,4)
4,5	0,75	3,688	3,878	**3,7**
5	0,8	4,134	4,334	**4,2** (4,3)
5,5	0,9	4,526	4,750	**4,6**
6	1	4,917	5,153	**5** (5,1)
7	1	5,917	6,153	**6**
8	1,25	6,647	6,912	**6,8** (6,9)
9	1,25	7,647	7,912	**7,8**
10	1,5	8,376	8,676	**8,5** (8,6)
11	1,5	9,376	9,676	**9,5**
12	1,75	10,106	10,441	**10,2** (10,4)
14	2	11,835	12,210	**12** (12,2)
16	2	13,835	14,210	**14** (14,2)
18	2,5	15,294	15,744	**15,5**
20	2,5	17,294	17,744	**17,5**
22	2,5	19,294	19,744	**19,5**
24	3	20,752	21,252	**21**
27	3	23,752	24,252	**24**
30	3,5	26,211	26,771	**26,5**
33	3,5	29,211	29,771	**29,5**
36	4	31,670	32,270	**32**
39	4	34,670	35,270	**35**
42	4,5	37,129	37,799	**37,5**
45	4,5	40,129	40,799	**40,5**
48	5	42,587	43,297	**43**
52	5	46,587	47,297	**47**
56	5,5	50,046	50,796	**50,5**
60	5,5	54,046	54,796	**54,5**
64	6	57,505	58,305	**58**
68	6	61,505	62,305	**62**

P ≤ 0,3 mm = Tol. 5H

( ) = Vorfertigungsdurchmesser für Gewindebohrer Typ HCUT
Preparatory diameters for taps of type HCUT

MF

Metrisches ISO-Feingewinde DIN 13
ISO Metric fine thread DIN 13

Nenngröße Nom. size D x P mm	D_1 (6H) min. mm	max. mm	mm
M 2,5 x 0,35	2,121	2,221	**2,15**
2,6 x 0,35	2,221	2,321	**2,25**
3 x 0,35	2,621	2,721	**2,65**
3,5 x 0,35	3,121	3,221	**3,15**
4 x 0,35	3,621	3,721	**3,65**
4 x 0,5	3,459	3,599	**3,5**
5 x 0,5	4,459	4,599	**4,5**
6 x 0,5	5,459	5,599	**5,5**
6 x 0,75	5,188	5,378	**5,2**
7 x 0,75	6,188	6,378	**6,2**
8 x 0,75	7,188	7,378	**7,2**
8 x 1	6,917	7,153	**7** (7,1)
9 x 0,75	8,188	8,378	**8,2**
9 x 1	7,917	8,153	**8**
10 x 0,75	9,188	9,378	**9,2**
10 x 1	8,917	9,153	**9** (9,1)
10 x 1,25	8,647	8,912	**8,8**
11 x 1	9,917	10,153	**10**
12 x 1	10,917	11,153	**11**
12 x 1,25	10,647	10,912	**10,8**
12 x 1,5	10,376	10,676	**10,5** (10,6)
14 x 1	12,917	13,153	**13**
14 x 1,25	12,647	12,912	**12,8**
14 x 1,5	12,376	12,676	**12,5** (12,6)
15 x 1	13,917	14,153	**14**
16 x 1	14,917	15,153	**15**
16 x 1,5	14,376	14,676	**14,5** (14,6)
18 x 1	16,917	17,153	**17**
18 x 1,5	16,376	16,676	**16,5**
18 x 2	15,835	16,210	**16**
20 x 1	18,917	19,153	**19**
20 x 1,5	18,376	18,676	**18,5**
20 x 2	17,835	18,210	**18**
22 x 1	20,917	21,153	**21**
22 x 1,5	20,376	20,676	**20,5**
22 x 2	19,835	20,210	**20**
24 x 1	22,917	23,153	**23**
24 x 1,5	22,376	22,676	**22,5**
24 x 2	21,835	22,210	**22**
25 x 1,5	23,376	23,676	**23,5**
26 x 1,5	24,376	24,676	**24,5**
27 x 1,5	25,376	25,676	**25,5**
27 x 2	24,835	25,210	**25**
28 x 1,5	26,376	26,676	**26,5**
28 x 2	25,835	26,210	**26**
30 x 1,5	28,376	28,676	**28,5**
30 x 2	27,835	28,210	**28**
32 x 1,5	30,376	30,676	**30,5**
32 x 2	29,835	30,210	**30**
33 x 1,5	31,376	31,676	**31,5**
33 x 2	30,835	31,210	**31**
34 x 1,5	32,376	32,676	**32,5**
35 x 1,5	33,376	33,676	**33,5**
36 x 1,5	34,376	34,676	**34,5**
36 x 2	33,835	34,210	**34**
36 x 3	32,752	33,252	**33**
38 x 1,5	36,376	36,676	**36,5**
39 x 1,5	37,376	37,676	**37,5**
39 x 2	36,835	37,210	**37**
39 x 3	35,752	36,252	**36**
40 x 1,5	38,376	38,676	**38,5**
40 x 2	37,835	38,210	**38**
42 x 1,5	40,376	40,676	**40,5**
42 x 2	39,835	40,210	**40**
42 x 3	38,752	39,252	**39**
45 x 1,5	43,376	43,676	**43,5**
45 x 2	42,835	43,210	**43**
45 x 3	41,752	42,252	**42**
48 x 1,5	46,376	46,676	**46,5**
48 x 2	45,835	46,210	**46**
48 x 3	44,752	45,252	**45**
50 x 1,5	48,376	48,676	**48,5**
50 x 2	47,835	48,210	**48**
52 x 1,5	50,376	50,676	**50,5**
52 x 2	49,835	50,210	**50**
52 x 3	48,752	49,252	**49**
56 x 3	52,752	53,252	**53**
56 x 4	51,670	52,270	**52**
60 x 4	55,670	56,270	**56**
64 x 3	60,752	61,252	**61**
64 x 4	59,670	60,270	**60**
68 x 4	63,670	64,270	**64**
70 x 3	66,752	67,252	**67**
70 x 4	65,670	66,270	**66**
72 x 3	68,752	69,252	**69**
72 x 4	67,670	68,270	**68**
72 x 6	65,505	66,305	**66**
76 x 3	72,752	73,252	**73**
76 x 4	71,670	72,270	**72**
76 x 6	69,505	70,305	**70**
80 x 4	75,670	76,270	**76**
80 x 6	73,505	74,305	**74**
85 x 3	81,752	82,252	**82**
85 x 4	80,670	81,270	**81**
90 x 3	86,752	87,252	**87**
90 x 4	85,670	86,270	**86**
90 x 6	83,505	84,305	**84**
95 x 6	88,505	89,305	**89**
100 x 4	95,670	96,270	**96**
100 x 6	93,505	94,305	**94**
110 x 6	103,505	104,305	**104**
115 x 3	111,752	112,252	**112**
120 x 4	115,670	116,270	**116**
120 x 6	113,505	114,305	**114**

Unified-Gewinde
Unified Threads

UNC

Unified-Grobgewinde ASME B1.1
Unified coarse thread ASME B1.1

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 (2B) min. mm	max. mm	mm
Nr. 1 - 64	1,425	1,582	**1,55**
Nr. 2 - 56	1,694	1,872	**1,85**
Nr. 3 - 48	1,941	2,146	**2,1**
Nr. 4 - 40	2,156	2,385	**2,35**
Nr. 5 - 40	2,487	2,697	**2,65**
Nr. 6 - 32	2,647	2,896	**2,85**
Nr. 8 - 32	3,307	3,528	**3,5**
Nr. 10 - 24	3,680	3,949	**3,9**
Nr. 12 - 24	4,341	4,590	**4,5**
1/4 - 20	4,976	5,268	**5,1**
5/16 - 18	6,411	6,734	**6,6**
3/8 - 16	7,805	8,164	**8**
7/16 - 14	9,149	9,550	**9,4**
1/2 - 13	10,584	11,016	**10,8**
9/16 - 12	11,996	12,456	**12,2**
5/8 - 11	13,376	13,868	**13,5**
3/4 - 10	16,299	16,833	**16,5**
7/8 - 9	19,169	19,748	**19,5**
1" - 8	21,963	22,598	**22,25**
1 1/8 - 7	24,648	25,349	**25**
1 1/4 - 7	27,823	28,524	**28**
1 3/8 - 6	30,343	31,120	**30,75**
1 1/2 - 6	33,518	34,295	**34**
1 3/4 - 5	38,951	39,814	**39,5**
2" - 4 1/2	44,689	45,598	**45**

UNF

Unified-Feingewinde ASME B1.1
Unified fine thread ASME B1.1

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 (2B) min. mm	max. mm	mm
Nr. 2 - 64	1,755	1,913	**1,85**
Nr. 3 - 56	2,024	2,197	**2,15**
Nr. 4 - 48	2,271	2,459	**2,4**
Nr. 5 - 44	2,550	2,741	**2,7**
Nr. 6 - 40	2,817	3,012	**2,95**
Nr. 8 - 36	3,401	3,597	**3,5**
Nr. 10 - 32	3,967	4,168	**4,1**
Nr. 12 - 28	4,503	4,716	**4,6**
1/4 - 28	5,367	5,580	**5,5**
5/16 - 24	6,792	7,038	**6,9**
3/8 - 24	8,379	8,626	**8,5**
7/16 - 20	9,738	10,030	**9,9**
1/2 - 20	11,326	11,618	**11,5**
9/16 - 18	12,761	13,084	**12,9**
5/8 - 18	14,348	14,671	**14,5**
3/4 - 16	17,330	17,689	**17,5**
7/8 - 14	20,262	20,663	**20,4**
1" - 12	23,109	23,569	**23,25**
1 1/8 - 12	26,284	26,744	**26,5**
1 1/4 - 12	29,459	29,919	**29,5**
1 3/8 - 12	32,634	33,094	**32,75**
1 1/2 - 12	35,809	36,269	**36**

UN-8

Unified-Gewinde ASME B1.1
Unified thread ASME B1.1

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 (2B) min. mm	max. mm	mm
1 1/8 - 8	25,138	25,773	**25,4**
1 1/4 - 8	28,313	28,948	**28,6**
1 1/2 - 8	34,663	35,298	**35**
1 3/4 - 8	41,013	41,648	**41,3**
2" - 8	47,363	47,998	**47,7**

UNEF

Unified-Extra-Feingewinde ASME B1.1
Unified extra fine thread ASME B1.1

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 (2B) min. mm	max. mm	mm
1/4 - 32	5,491	5,679	**5,55**
5/16 - 32	7,079	7,267	**7,15**
3/8 - 32	8,666	8,854	**8,7**
7/16 - 28	10,130	10,343	**10,2**
1/2 - 28	11,717	11,930	**11,8**
9/16 - 24	13,142	13,388	**13,2**
5/8 - 24	14,729	14,975	**14,8**
3/4 - 20	17,676	17,968	**17,8**
7/8 - 20	20,851	21,143	**20,95**
1" - 20	24,026	24,318	**24,15**

Gewinde für die Luft- und Raumfahrtindustrie
Threads for the Aerospace Industry

MJ

MJ-Gewinde DIN ISO 5855
MJ thread DIN ISO 5855

Nenngröße Nom. size D x P mm	D_1 min. mm	max. mm	mm
MJ 3 x 0,5	2,513	2,653	**2,6**
4 x 0,7	3,318	3,498	**3,4**
5 x 0,8	4,221	4,421	**4,3**
6 x 1	5,026	5,216	**5,1**
8 x 1	7,026	7,216	**7,1**
8 x 1,25	6,782	6,994	**6,9**
10 x 1,25	8,782	8,994	**8,9**
10 x 1,5	8,539	8,775	**8,6**

UNJC

Unified-Grobgewinde ASME B1.15
Unified coarse thread ASME B1.15

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 min. mm	max. mm	mm
Nr. 4 - 40	2,228	2,393	**2,3**
Nr. 6 - 32	2,733	2,939	**2,85**
Nr. 8 - 32	3,393	3,599	**3,5**
Nr. 10 - 24	3,795	4,064	**3,9**
1/4 - 20	5,113	5,387	**5,25**
5/16 - 18	6,563	6,833	**6,7**
3/8 - 16	7,978	8,255	**8,1**

UNJF

Unified-Feingewinde ASME B1.15
Unified fine thread ASME B1.15

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 min. mm	max. mm	mm
Nr. 4 - 48	2,329	2,466	**2,4**
Nr. 6 - 40	2,888	3,053	**3**
Nr. 8 - 36	3,480	3,663	**3,55**
Nr. 10 - 32	4,054	4,255	**4,15**
1/4 - 28	5,466	5,662	**5,55**
5/16 - 24	6,906	7,109	**7**
3/8 - 24	8,494	8,679	**8,6**

Zylindrische Rohrgewinde
Cylindrical Pipe Threads

G

Whitworth-Rohrgewinde DIN EN ISO 228
Whitworth pipe thread DIN EN ISO 228

Nenngröße Nom. size D - P/1" (tpi)	D_1 min. mm	max. mm	mm
G 1/16 - 28	6,561	6,843	**6,8**
1/8 - 28	8,566	8,848	**8,8**
1/4 - 19	11,445	11,890	**11,8** (11,9)
3/8 - 19	14,950	15,395	**15,25** (15,35)
1/2 - 14	18,631	19,172	**19** (19,1)
5/8 - 14	20,587	21,128	**21**
3/4 - 14	24,117	24,658	**24,5**
7/8 - 14	27,877	28,418	**28,25**
1" - 11	30,291	30,931	**30,75**
1 1/8 - 11	34,939	35,579	**35,5**
1 1/4 - 11	38,952	39,592	**39,5**
1 3/8 - 11	41,365	42,005	**41,75**
1 1/2 - 11	44,845	45,485	**45,25**
1 5/8 - 11	49,030	49,670	**49,5**
1 3/4 - 11	50,788	51,428	**51**
2" - 11	56,656	57,296	**57**
2 1/4 - 11	62,752	63,392	**63,3**
2 1/2 - 11	72,226	72,866	**72,8**
2 3/4 - 11	78,576	79,216	**79,1**
3" - 11	84,926	85,566	**85,5**

( ) = Vorfertigungsdurchm. für Gewindebohrer Typ HCUT
Preparatory diameters for taps of type HCUT

NPSM

Amerikanisches zylindrisches Rohrgewinde ANSI/ASME B1.20.1
mechanisches Rohrgewinde (früher NPS)

American Standard straight pipe thread ANSI/ASME B1.20.1
for mechanical joints (previously NPS)

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 min. mm	max. mm	mm
1/8 - 27	9,093	9,246	**9,1**
1/4 - 18	11,887	12,217	**12**
3/8 - 18	15,316	15,545	**15,5**
1/2 - 14	18,921	19,279	**19**
3/4 - 14	24,333	24,638	**24,5**
1" - 11 1/2	30,505	30,759	**30,5**

NPSC

Amerikanisches zylindrisches Innengewinde ANSI/ASME B1.20.1
in Rohrverbindungen

American Standard internal straight thread ANSI/ASME B1.20.1
in pipe coupling

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 min. mm	max. mm	mm
1/8 - 27	8,636	8,814	**8,8**
1/4 - 18	11,227	11,491	**11,4**
3/8 - 18	14,656	14,920	**14,9**
1/2 - 14	18,161	18,501	**18,4**
3/4 - 14	23,495	23,835	**23,7**
1" - 11 1/2	29,489	29,903	**29,8**

Rp (BSPP)

Zylindrisches Whitworth-Rohrgewinde DIN EN 10226-1 und ISO 7-1
für im Gewinde dichtende Verbindungen

Cylindrical Whitworth pipe thread DIN EN 10226-1 and ISO 7-1
where pressure-tight joints are made on the threads

Nenngröße Nom. size D - P/1" (tpi)	D_1 min. mm	max. mm	mm
Rp 1/16 - 28	6,490	6,632	**6,55**
1/8 - 28	8,495	8,637	**8,6**
1/4 - 19	11,341	11,549	**11,5**
3/8 - 19	14,846	15,054	**15**
1/2 - 14	18,489	18,773	**18,5**
3/4 - 14	23,975	24,259	**24**
1" - 11	30,111	30,471	**30,25**

NPSF

Amerikanisches zylindrisches Rohrgewinde ANSI B1.20.3
zylindrisches Rohrdichtgewinde, gepaart mit kegeligem Außengewinde NPTF oder PTF-SAE-SHORT; Lehrung: konisch

American Standard straight pipe thread ANSI B1.20.3
drysealinternal straight pipe thread for fuel, combined with external tapered pipe thread NPTF or PTF-SAE-SHORT; Gauge with tapered gauges

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 min. mm	max. mm	mm
1/16 - 27	6,304	6,393	**6,35**
1/8 - 27	8,651	8,740	**8,7**
1/4 - 18	11,232	11,364	**11,3**
3/8 - 18	14,671	14,803	**14,75**
1/2 - 14	18,118	18,288	**18,2**
3/4 - 14	23,465	23,635	**23,5**
1" - 11 1/2	29,464	29,670	**29,5**

Britische Gewinde
British Threads

BSW

Whitworth-Gewinde BS 84
Whitworth thread BS 84

Nenngröße Nom. size D - P/1" (tpi)	D_1 min. mm	max. mm	mm
BSW 1/16 - 60	1,045	1,230	**1,15**
3/32 - 48	1,704	1,912	**1,85**
1/8 - 40	2,362	2,591	**2,55**
5/32 - 32	2,952	3,214	**3,2**
3/16 - 24	3,406	3,744	**3,7**
7/32 - 24	4,201	4,539	**4,5**
1/4 - 20	4,724	5,156	**5,1**
5/16 - 18	6,129	6,589	**6,5**
3/8 - 16	7,493	7,988	**7,9**
7/16 - 14	8,791	9,332	**9,25**
1/2 - 12	9,987	10,589	**10,5**
9/16 - 12	11,575	12,177	**12**
5/8 - 11	12,918	13,559	**13,5**
3/4 - 10	15,799	16,485	**16,4**
7/8 - 9	18,613	19,355	**19,25**
1" - 8	21,336	22,149	**22**
1 1/8 - 7	23,927	24,831	**24,75**
1 1/4 - 7	27,102	28,006	**27,75**
1 3/8 - 6	29,504	30,528	**30,5**
1 1/2 - 6	32,680	33,703	**33,5**
1 5/8 - 5	34,769	35,963	**35,5**
1 3/4 - 5	37,943	39,136	**39**
1 7/8 - 4 1/2	40,396	41,702	**41,5**
2" - 4 1/2	43,571	44,877	**44,5**

BSF

Whitworth-Feingewinde BS 84
Whitworth fine thread BS 84

Nenngröße Nom. size D - P/1" (tpi)	D_1 min. mm	max. mm	mm
BSF 3/16 - 32	3,747	4,006	**4**
1/4 - 26	5,100	5,398	**5,3**
5/16 - 22	6,459	6,817	**6,8**
3/8 - 20	7,899	8,331	**8,3**
7/16 - 18	9,304	9,764	**9,7**
1/2 - 16	10,668	11,163	**11,1**
5/8 - 14	13,553	14,094	**14**
3/4 - 12	16,337	16,939	**16,75**
7/8 - 11	19,268	19,909	**19,75**
1" - 10	22,149	22,835	**22,75**

Aufnahmegewinde für Gewindedrahteinsätze
Helical Coil Threads for Wire Thread Inserts

EG M (STI)

Metrisches ISO-Regelgewinde DIN 8140-2
ISO Metric coarse thread DIN 8140-2

Nenngröße Nom. size D mm	P mm	D_{EG} min. mm	D_{1EG} min. mm	max. mm	mm
EG M 2,5	0,45	3,084	2,597	2,697	**2,65**
3	0,5	3,650	3,108	3,220	**3,15**
4	0,7	4,910	4,152	4,292	**4,2**
5	0,8	6,040	5,174	5,334	**5,25**
6	1	7,300	6,217	6,407	**6,3**
8	1,25	9,624	8,271	8,483	**8,4**
10	1,5	11,948	10,324	10,560	**10,5**
12	1,75	14,274	12,379	12,644	**12,5**
14	2	16,598	14,433	14,733	**14,5**
16	2	18,598	16,433	16,733	**16,5**
18	2,5	21,248	18,541	18,896	**18,75**
20	2,5	23,248	20,541	20,896	**20,75**

EG UNC (STI)

Unified-Grobgewinde ASME B18.29.1
Unified coarse thread ASME B18.29.1

Nenngröße Nom. size D P/1" (tpi)	D_{EG} min. mm	D_{1EG} min. mm	max. mm	mm
EG Nr. 4 - 40	3,671	2,982	3,178	**3,1**
Nr. 6 - 32	4,536	3,678	3,879	**3,8**
Nr. 8 - 32	5,197	4,338	4,523	**4,4**
Nr. 10 - 24	6,200	5,054	5,283	**5,2**
1/4 - 20	8,002	6,628	6,872	**6,7**
5/16 - 18	9,771	8,244	8,490	**8,4**
3/8 - 16	11,587	9,867	10,126	**10**
7/16 - 14	13,469	11,506	11,783	**11,6**
1/2 - 13	15,237	13,121	13,393	**13,3**
9/16 - 12	17,039	14,747	15,031	**14,9**
5/8 - 11	18,875	16,376	16,673	**16,5**
3/4 - 10	22,349	19,598	19,908	**19,75**

EG UNF (STI)

Unified-Feingewinde ASME B18.29.1
Unified fine thread ASME B18.29.1

Nenngröße Nom. size D P/1" (tpi)	D_{EG} min. mm	D_{1EG} min. mm	max. mm	mm
EG Nr. 4 - 48	3,533	2,959	3,119	**3**
Nr. 6 - 40	4,330	3,642	3,815	**3,7**
Nr. 8 - 36	5,083	4,318	4,496	**4,4**
Nr. 10 - 32	5,858	4,999	5,184	**5,1**
1/4 - 28	7,528	6,545	6,720	**6,6**
5/16 - 24	9,312	8,166	8,351	**8,25**
3/8 - 24	10,899	9,753	9,931	**9,8**
7/16 - 20	12,763	11,389	11,587	**11,5**
1/2 - 20	14,352	12,978	13,176	**13,1**
9/16 - 18	16,121	14,594	14,800	**14,7**
5/8 - 18	17,709	16,182	16,388	**16,25**
3/4 - 16	21,112	19,392	19,608	**19,5**

Kegelige Rohrgewinde
Tapered Pipe Threads

Rc (BSPT)

Kegeliges Whitworth-Rohrgewinde DIN EN 10226-2 und ISO 7-1 für im Gewinde dichtende Verbindungen, Kegel 1:16

Tapered Whitworth pipe thread DIN EN 10226-2 and ISO 7-1 where pressure-tight joints are made on the threads, taper 1:16

Zylindrisch vorarbeiten
Cylindrical preparation of thread hole

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 mm	t_1 mm	t_4 mm
Rc 1/16 - 28	6,15	11,1	9,5
1/8 - 28	8,15	11,1	9,5
1/4 - 19	10,85	16,3	14,0
3/8 - 19	14,30	16,7	14,4
1/2 - 14	17,80	22,3	19,1
3/4 - 14	23,20	23,6	20,4
1" - 11	29,20	28,3	24,3

Kegelig vorarbeiten
Tapered preparation of thread hole

Nenngröße Nom. size D - P/1" inch (tpi)	D_2 mm	D_3 JS11 mm	t_1 mm	t_4 mm
Rc 1/16 - 28	6,10	6,56	11,1	9,5
1/8 - 28	8,10	8,57	11,1	9,5
1/4 - 19	10,75	11,45	16,3	14,0
3/8 - 19	14,25	14,95	16,7	14,4
1/2 - 14	17,70	18,63	22,3	19,1
3/4 - 14	23,10	24,12	23,6	20,4
1" - 11	29,10	30,29	28,3	24,3

Vorarbeiten von Grundlöchern
Preparation of blind holes

Nenngröße Nom. size D - P/1" inch (tpi)	D_3 JS11 mm	b mm	t min. mm	D_4 min. mm
Rc 1/16 - 28	6,56	5,6	9,9	7,6 +0,3
1/8 - 28	8,57	5,6	9,9	9,6 +0,3
1/4 - 19	11,45	8,4	14,6	13,0 +0,5
3/8 - 19	14,95	8,8	15,0	16,5 +0,5
1/2 - 14	18,63	11,4	20,0	20,6 +0,5
3/4 - 14	24,12	12,7	21,3	26,0 +0,5
1" - 11	30,29	14,5	25,4	32,8 +0,5

Auslauf
Run-out

D_4 min.

Ausführung mit Einstich bevorzugt anwenden
We recommend using a recessed design wherever possible

NPT

Amerikanisches kegeliges Rohrgewinde ANSI/ASME B1.20.1 für Gewinde **mit Dichtmittel**, Kegel 1:16

American tapered pipe thread ANSI/ASME B1.20.1 for threads **with dryseal material**, taper 1:16

Nenngröße Nom. size D - P/1" inch (tpi)	D_1 mm	t_1 mm	t_4 mm
1/16 - 27	6,15	11,8	9,70
1/8 - 27	8,50	11,9	9,75
1/4 - 18	11,00	17,4	14,25
3/8 - 18	14,40	17,7	14,55
1/2 - 14	17,80	23,1	19,00
3/4 - 14	23,15	23,6	19,50
1" - 11 1/2	29,05	28,4	23,40
1 1/4 - 11 1/2	37,80	28,9	23,90
1 1/2 - 11 1/2	43,85	28,9	23,90
2" - 11 1/2	55,85	29,3	24,35

Nenngröße Nom. size D - P/1" inch (tpi)	D_2 mm	D_3 +0,05 mm	t_1 mm	t_4 mm
1/16 - 27	5,95	6,39	11,8	9,70
1/8 - 27	8,30	8,74	11,9	9,75
1/4 - 18	10,75	11,36	17,4	14,25
3/8 - 18	14,15	14,80	17,7	14,55
1/2 - 14	17,45	18,32	23,1	19,00
3/4 - 14	22,80	23,67	23,6	19,50
1" - 11 1/2	28,65	29,69	28,4	23,40
1 1/4 - 11 1/2	37,35	38,45	28,9	23,90
1 1/2 - 11 1/2	43,45	44,52	28,9	23,90
2" - 11 1/2	55,45	56,56	29,3	24,35

Nenngröße Nom. size D - P/1" inch (tpi)	D_3 +0,05 mm	b mm	t min. mm	D_4 min. mm
1/16 - 27	6,39	7,0	10,0	7,6
1/8 - 27	8,74	7,0	10,0	10,0
1/4 - 18	11,36	10,2	14,5	13,1
3/8 - 18	14,80	10,6	15,0	16,5
1/2 - 14	18,32	13,8	19,0	20,5
3/4 - 14	23,67	14,2	20,0	25,8
1" - 11 1/2	29,69	17,0	24,0	32,2
1 1/4 - 11 1/2	38,45	17,5	24,5	41,0
1 1/2 - 11 1/2	44,52	17,5	24,5	47,2
2" - 11 1/2	56,56	18,0	25,0	59,2

NPTF

Amerikanisches kegeliges Rohrgewinde ANSI B1.20.3 für Gewinde **ohne Dichtmittel**, Kegel 1:16

American tapered pipe thread ANSI B1.20.3 for threads **without drysealmaterial**, taper 1:16