

Summary of Internal Threading

Tooling Application Table (Internal Threading)

Thread Type	Metric	Unified	Parallel Pipe	Whitworth	Tapered Pipe	American National Pipe	30° Trapezoidal
	M	UN. UNC UNF. UNEF	G(PF) Rp(PS)	W	Rc (PT) (BSPT)	NPT	Tr
Thread shape							
Pitch	mm	TPI	TPI	TPI	TPI	TPI	mm
Toolholder Shape							
VNT ➔ J27 	Partial Profile	0.75~1.5 ➔ J27	28~18 ➔ J27	-	-	-	-
HPT ➔ J24 (PST) ➔ J26 	Partial Profile	0.75~1.5 (0.75~1.5) ➔ J24 (➔ J26)	28~16 (28~18) ➔ J24 (➔ J26)	-	24~18 ➔ J24	28~19 ➔ J24	-
SIN ➔ J17 	Full Profile	0.5~5.0 ➔ J7	24~8 ➔ J9	19~11 ➔ J9	16~11 ➔ J9	28~11 ➔ J11	18~11.5 ➔ J11
	Partial Profile	0.5~5.0 ➔ J13	48~8 ➔ J13	28~11 ➔ J15	24~11 ➔ J15	28~11 ➔ J15	-
CIN ➔ J17 	Full Profile	1.0~5.0 ➔ J7	24~8 ➔ J9	19~11 ➔ J9	14~11 ➔ J9	28~11 ➔ J11	11.5 ➔ J11
	Partial Profile	0.5~5.0 ➔ J13	48~8 ➔ J13	28~11 ➔ J15	24~11 ➔ J15	28~11 ➔ J15	-
KITG ➔ J23 	Partial Profile	0.5~3.0 ➔ J23	48~8 ➔ J23	28~11 ➔ J23	24~8 ➔ J23	28~11 ➔ J23	-
STWP ➔ J28 	Partial Profile	0.75~3.5 ➔ J28	28~8 ➔ J28	-	-	-	-

• For parallel pipe and tapered pipe which is not suitable for bottom diameter, it is considered to be outside of recommendation.

• Pitch inside () indicates PST.

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Threading