

Summary of Internal Threading

Tooling Application Table (Internal Threading)

Thread Type	Metric	Unified	Parallel Pipe	Whitworth	Tapered Pipe	American National Tapered 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 ⚙️ J27) 	Partial Profile	0.75~1.5 (0.75~1.5) ⚙️ J24 (⚙️ J27)	28~16 (28~18) ⚙️ J24 (⚙️ J27)	28~19 ⚙️ J24	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	40~5 ⚙️ J15	28~11 ⚙️ J15	-
CIN ⚙️ J17 	Full Profile	1.0~5.0 ⚙️ J7	24~8 ⚙️ J9	19~11 ⚙️ J9	16~11 ⚙️ J9	28~11 ⚙️ J11	18~11.5 ⚙️ J11
	Partial Profile	0.5~5.0 ⚙️ J13	48~5 ⚙️ J13	28~11 ⚙️ J15	40~5 ⚙️ 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 the average values are only to be used if specifically recommended.
• Pitch inside () indicates PST.

