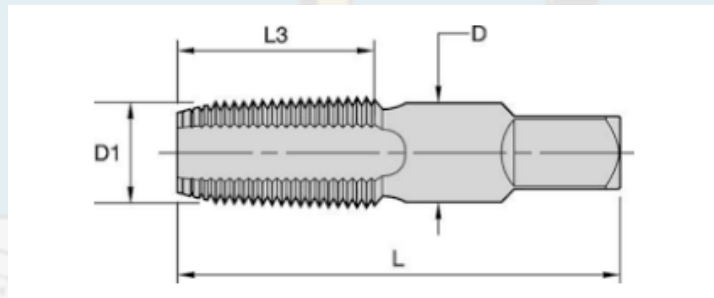


E.M PRECISE TECH TIP

Using Tapered Reamers for NPT Threading

Tapping holes with parallel threads is fairly straightforward. You just pre-drill with the proper size tool, then tap the threads.

In some cases, NPT threads may present more of a challenge.



The thread is tapered; which means if you just drill and tap, the tap is required to simultaneously open up the pre-hole to the required profile, and produce the threads. But the tool must always be fed into the work piece at the pitch rate per revolution, regardless of the work piece material or condition. On very hard, or difficult to machine materials, the extra workload may impact the quality of the finished threads. It will also shorten the tap's life. On long chipping materials, like mild steel or aluminum; there may also be an issue with chip control.

The solution is to use an NPT reamer. Each one has the correct size and taper, to ensure the pre-hole is the correct diameter all the way down, and the perimeter is now the same taper as the tap itself.



These reamers are available in NPT sizes from 1/8" to 2". Why not give one a try, on your next project?