

ASME B1.20.7-1991
(REVISION OF ANSI/ASME B1.20.7-1966)

REAFFIRMED 2024

HOSE COUPLING SCREW THREADS (INCH)

AN AMERICAN NATIONAL STANDARD



The American Society of
Mechanical Engineers

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The American Society of
Mechanical Engineers

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FOREWORD

(This Foreword is not part of ASME B1.20.7-1991.)

Local standards for small hose coupling threads in use prior to 1920 were summarized in a table in the Proceedings of the National Fire Protection Association, Vol. 24, 1920, p. 180. Of these, the Standard Iron Pipe Thread had been most widely used, and it had been reliably reported that this thread had been in use for small hose couplings since 1894 or earlier. In the case of the three-fourths-inch size, however, 11 and 11½ threads per inch, with a diameter of 1⅞ in. were already in very extensive use for garden hose. It was reported that the first garden hose spray nozzle had been made prior to 1890 in the shops of the W. D. Allen Mfg. Co., Chicago.

In 1918 the Fire Dept. Supply and Linen Hose Section of the War Industries Board recommended that for the duration of the war "hydrants, hose valves, hose couplings, nipples, and nozzles 1¼ in. to 2 in., inclusive, to be iron pipe thread for new work, hose gauge or special threads only to be used for replacement or extension of existing plant equipment. The adoption of such a standard will result in the elimination of the various so-called hose threads which are used locally in the different sections of the country. Such a standard will also permit repairs or connections being made in the field by the use of wrought iron pipe connections or fittings. It will also result in considerable saving in correspondence and detail now necessary in endeavoring to ascertain what particular 'hose' standard thread is desired."

A blueprint of the nominal sizes and pitches of hose thread dimensions, dated March 5, 1918, of the National Association of Brass Manufacturers was furnished the National Screw Thread Commission in November, 1918. Limits of size for iron pipe thread sizes and pitches were designed as National hose coupling thread dimensions and adopted by the National Association of Brass Manufacturers March 18, 1920. These were in agreement with those in the Progress Report of the N.S.T.C., approved June 19, 1920, and published January 4, 1921 as NBS Miscellaneous Publication No. 42. A survey in 1925 of some of the members of the National Association of Brass Manufacturers showed these standards to be satisfactory. These threads from ½ to 2 in. diameter are now designated "NPSH."

In January 1927, The American Society of Mechanical Engineers requested the American Engineering Standards Committee (later changed to the American Standards Association) to authorize the organization of a Sectional Committee to complete the standardization of firehose couplings and to attempt to unify and complete the existing dimensions of small hose couplings. This authority was given and the Sectional Committee B33 was organized in October, 1928, under the sponsorship of The American Society of Mechanical Engineers, to prepare specifications for screw threads for small hose couplings ranging from ½ to 2 in. nominal size. A draft dated July 1935 was approved by the American Standards Association and issued as ASA B33.1-1935.

At its meeting of April 13, 1961, the ASA Mechanical Standards Board assigned responsibility for future revisions of the American Standards

B26-1925, Fire-Hose Couplings Screw Thread, and

B33.1-1935, Hose Coupling Screw Threads

to Sectional Committee B2. As a result, the name of the Committee was changed to Sectional Committee B2 on the Standardization of Pipe and Hose Coupling Threads.

Subcommittee 6 on Hose Coupling Threads was organized and held its first meeting on October 24, 1962 to undertake the revision of ASA B33.1-1935.

Subcommittee 7 on Fire Hose Coupling Threads was organized and held its first meeting on October 25, 1962 to undertake the revision of ASA B26-1925. It was arranged that Subcommittee 7 would include in its scope those thread sizes in ASA B33.1-1935 which are used primarily for fire protection purposes.

The proposed revision of B33.1, designated B2.4, was submitted to the sponsor organizations and the United States of America Standards Institute, and formally designated a USA Standard on December 30, 1966.

In 1973 the American National Standards Committee B2 was absorbed by ANSI Standard Committee B1 and reorganized as Subcommittee 20. B2.4 was reaffirmed without revision by Standard Committee B1 and redesignated as ANSI/ASME Standard B1.20.7 on August 5, 1983.

This revision was approved by the American National Standards Institute on September 19, 1991.

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HOSE COUPLING SCREW THREADS

1 SCOPE

1.1 Purpose

The purpose of this document is to provide standards for application to the threaded parts of hose couplings, valves, nozzles, and all other fittings used in direct connection with hose intended for domestic, industrial, and general service in nominal sizes of $\frac{1}{2}$, $\frac{3}{8}$, $\frac{3}{4}$, 1, $1\frac{1}{4}$, $1\frac{1}{2}$, 2, $2\frac{1}{2}$, 3, $3\frac{1}{2}$, and 4 in.

The normal sequence of connections, in relation to the direction of flow, is from an externally threaded nipple into an internally threaded coupling.

The basic dimensions are given in Table 1 while complete detailed dimensions and thread form are given in Tables 2 and 3.

1.2 Federal Government Use

When this Standard is approved by the Department of Defense and Federal Agencies and is incorporated into FED-STD-H28/10, Screw Thread Standards for Federal Services Section 10, the use of this Standard by the Federal Government is subject to all the requirements and limitations of FED-STD-H28/10.

1.3 Reference Documents

The latest issues of the following documents form a part of this Standard to the extent specified herein:

- | | |
|-----------------|---|
| ANSI/ASME B1.7M | Nomenclature, Definitions, and Letter Symbols for Screw Threads |
| ANSI/ASME B1.3M | Screw Thread Gaging Systems for Dimensional Acceptability |

- | | |
|-----------------|---|
| ANSI/ASME B1.2 | Gages and Gaging for Unified Inch Screw Threads |
| ASME/ANSI B47.1 | Gage Blanks |

2 THREAD DESIGNATIONS

Threads are designated NH, NHR, and NPSH. The significance of each designation is as follows:

- | | |
|------|---|
| NH | Standard hose coupling threads of full form and fire hose. |
| NHR | Standard hose coupling threads for garden hose application where the design utilizes thin walled material which is formed to the desired thread. |
| NPSH | Hose coupling joints ordinarily made with straight internal and external loose-fitting threads. By the use of this thread series, it is possible to join small hose couplings in sizes $\frac{1}{2}$ to 4; inclusive, to ends of standard pipe having NPT threads using a gasket to seal the joint. |

3 TOLERANCES

Figure 1 shows the relationship between external (nipple) and internal (coupling swivel) dimensions.

The pitch diameter tolerances for a mating nipple and coupling swivel are the same. Pitch diameter tolerances include lead and angle variations. Values for variations in lead and half-angles consuming one-half of the pitch diameter tolerance are shown in Table 5.

The tolerance relationships are as follows.

3.1 For Nipple (External) Threads (except NHR)

(a) Major Diameter Tolerances = $2 \times$ Pitch Diameter Tolerance

(b) Minor Diameter Tolerance = Pitch Diameter Tolerance + $2h/9$ (h = Basic Thread Height. See Fig. 1).

The minimum minor diameter of the nipple is such as to result in a flat equal to $1/3$ of the $P/8$ basic flat or $P/24$ at the root, when the pitch diameter of the nipple is at its minimum value. The maximum minor diameter is such as to result in a $P/8$ flat at the root of the nipple thread at maximum pitch diameter, but may be such as what would be produced by the use of a worm or rounded threading tool. This is the maximum minor diameter shown in Fig. 1 and is the diameter on which the minor diameter tolerance formula shown above is based. In practice, the minor diameter of an external thread is satisfactory when accepted by a gage or gaging method that represents the maximum material condition of the internal thread.

3.2 For Coupling Swivel (Internal) Threads (except NHR)

(a) Minor Diameter Tolerance = $2 \times$ Pitch Diameter Tolerance. The minimum minor diameter of the cou-

pling swivel is such as to result in a basic flat of $P/8$ at the crest when the pitch diameter of the coupling swivel is at its minimum value.

(b) Major Diameter Tolerance = Pitch Diameter Tolerance + $2h/9$. The minimum major diameter of the coupling swivel is such as to result in a basic flat of $P/8$ at the root of the thread when the pitch diameter is at its minimum value.

4 ACCEPTABILITY

Acceptability of product screw threads, based on the method specified, shall be in accordance with ANSI/ASME B1.3M. Gages and gaging are in accordance with ANSI/ASME B1.2. Gage dimensions are specified in Tables 6, 7, and 8. The maximum minor diameter of the GO thread gage for external product threads is equal to the minimum minor diameter of the internal product thread. All other gage dimensions are calculated in accordance with ANSI/ASME B1.2. Gage design shall be in accordance with American National Standard ASME/ANSI B47.1.

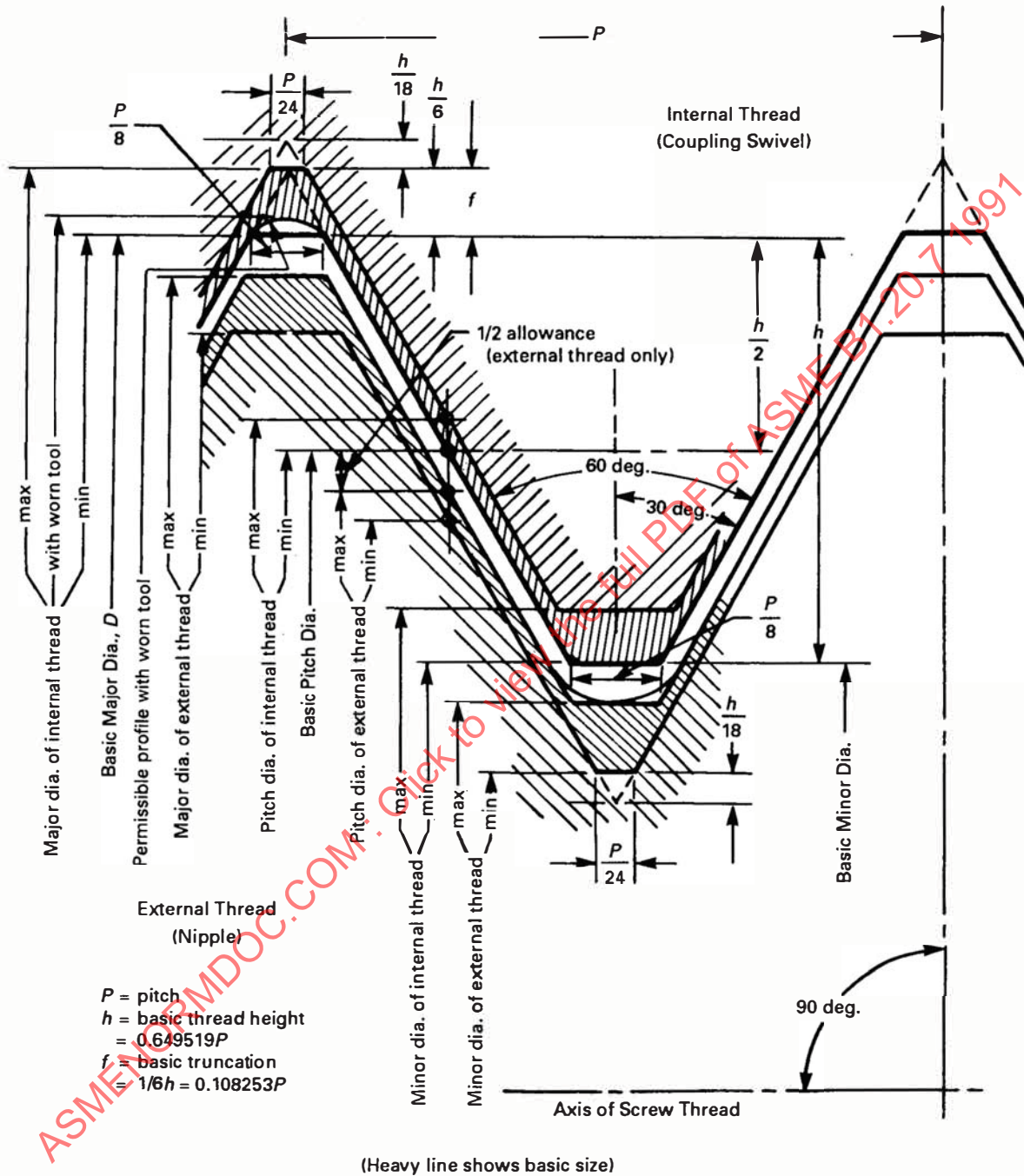


FIG. 1 THREAD FORM FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR

TABLE 1 DESIGN DIMENSIONS OF AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation	Service	Pitch	Basic Height of Thread	Maximum Nipple Dimensions (External Thread)				Minimum (Basic) Coupling Dimensions (Internal Thread)		
						Allowance	Major Diameter	Pitch Diameter	Minor Diameter	Minor Diameter	Pitch Diameter	Major Diameter
1	2	3	4	5	6	7	8	9	10	11	12	13
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NH	Garden hose	0.08696	0.05648	0.0100	1.0625	1.0060	0.9495	0.9595	1.0160	1.0725
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NHR	Garden hose formed thread	0.08696	0.05648	0.0160	1.0520	1.0100	0.9495	0.9720	1.0160	1.0680
$\frac{1}{2}$	14	$\frac{1}{2}$ -14NPSH	Steam, air, water, and all other hose connections to be made up with standard pipe threads. Marine applications	0.07143	0.04639	0.0075	0.8248	0.7784	0.7320	0.7395	0.7859	0.8323
$\frac{3}{4}$	14	$\frac{3}{4}$ -14NPSH		0.07143	0.04639	0.0075	1.0353	0.9889	0.9425	0.9500	0.9964	1.0428
1	11.5	1-11.5NPSH		0.08696	0.05648	0.0100	1.2951	1.2386	1.1821	1.1921	1.2486	1.3051
$1\frac{1}{4}$	11.5	$1\frac{1}{4}$ -11.5NPSH		0.08696	0.05648	0.0100	1.6399	1.5834	1.5269	1.5369	1.5934	1.6499
$1\frac{1}{2}$	11.5	$1\frac{1}{2}$ -11.5NPSH		0.08696	0.05648	0.0100	1.8788	1.8223	1.7658	1.7758	1.8323	1.8888
2	11.5	2-11.5NPSH		0.08696	0.05648	0.0100	2.3528	2.2963	2.2398	2.2498	2.3063	2.3628
$2\frac{1}{2}$	8	$2\frac{1}{2}$ -8NPSH		0.12500	0.08119	0.0120	2.8434	2.7622	2.6810	2.6930	2.7742	2.8554
3	8	3-8NPSH		0.12500	0.08119	0.0120	3.4697	3.3885	3.3073	3.3193	3.4005	3.4817
$3\frac{1}{2}$	8	$3\frac{1}{2}$ -8NPSH	Marine applications	0.12500	0.08119	0.0120	3.9700	3.8888	3.8076	3.8196	3.9008	3.9820
4	8	4-8NPSH		0.12500	0.08119	0.0120	4.4683	4.3871	4.3059	4.3179	4.3991	4.4803
4	6	4-6NH(SPL)		0.16667	0.10825	0.0201	4.9082	4.7999	4.6916	4.7117	4.8200	4.9283

NOTE:

(1) Data on the 4-6NH(SPL) thread are included since this thread is used extensively aboard ship by the Navy Department.

TABLE 2 PRODUCT EXTERNAL THREAD LIMITS OF SIZE AND TOLERANCES FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR NIPPLES

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation	Service	Pitch	Basic Height of Thread	Nipple (External) Thread						
						Major Diameter			Pitch Diameter			Minor Diameter [Note (1)]
						Max	Min	Tol.	Max	Min	Tol.	Max
1	2	3	4	5	6	7	8	9	10	11	12	13
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NH	Garden hose	0.08696	0.05648	1.0625	1.0455	0.0170	1.0060	0.9975	0.0085	0.9495
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NHR	Garden hose formed thread	0.08696	0.05648	1.0520	1.0350	0.0170	0.0100	0.9930	0.0170	0.9495
$\frac{1}{2}$	14	$\frac{1}{2}$ -14NPSH	Steam, air, and all other hose connections to be made up with standard pipe threads.	0.07143	0.04639	0.8248	0.8108	0.0140	0.7784	0.7714	0.0070	0.7320
$\frac{3}{4}$	14	$\frac{3}{4}$ -14NPSH		0.07143	0.04639	1.0353	1.0213	0.0140	0.9889	0.9819	0.0070	0.9425
1	11.5	1-11.5NPSH		0.08696	0.05648	1.2951	1.2781	0.0170	1.2386	1.2301	0.0085	1.1821
$1\frac{1}{4}$	11.5	$1\frac{1}{4}$ -11.5NPSH		0.08696	0.05648	1.6399	1.6229	0.0170	1.5834	1.5749	0.0085	1.5269
$1\frac{1}{2}$	11.5	$1\frac{1}{2}$ -11.5NPSH		0.08696	0.05648	1.8788	1.8618	0.0170	1.8223	1.8138	0.0085	1.7658
2	11.5	2-11.5NPSH		0.08696	0.05648	2.3528	2.3358	0.0170	2.2963	2.2878	0.0085	2.2398
$2\frac{1}{2}$	8	$2\frac{1}{2}$ -8NPSH		0.12500	0.08119	2.8434	2.8212	0.0222	2.7622	2.7511	0.0111	2.6810
3	8	3-8NPSH		0.12500	0.08119	3.4697	3.4475	0.0222	3.3885	3.3774	0.0111	3.3073
$3\frac{1}{2}$	8	$3\frac{1}{2}$ -8NPSH	Marine applications	0.12500	0.08119	3.9700	3.9478	0.0222	3.8888	3.8777	0.0111	3.8076
4	8	4-8NPSH		0.12500	0.08119	4.4683	4.4461	0.0222	4.3871	4.3760	0.0111	4.3059
4	6	4-6NH(SPL)		0.16667	0.10825	4.9082	4.8722	0.0360	4.7999	4.7819	0.0180	4.6916

NOTES:

- (1) Dimensions given for the maximum minor diameter of the nipple are figured to the intersection of the worn tool arc with a centerline through crest and root. For reference only the minimum minor diameter of the nipple shall be that corresponding to a flat at the minor diameter of the minimum nipple equal to $\frac{1}{4} \times P$ and may be determined by subtracting $1\frac{1}{2} \times h$ (or $0.7939P$) from the minimum pitch diameter of the nipple.
- (2) Data on the 4-6NH(SPL) thread are included since this thread is used extensively aboard ship by the Navy Department.

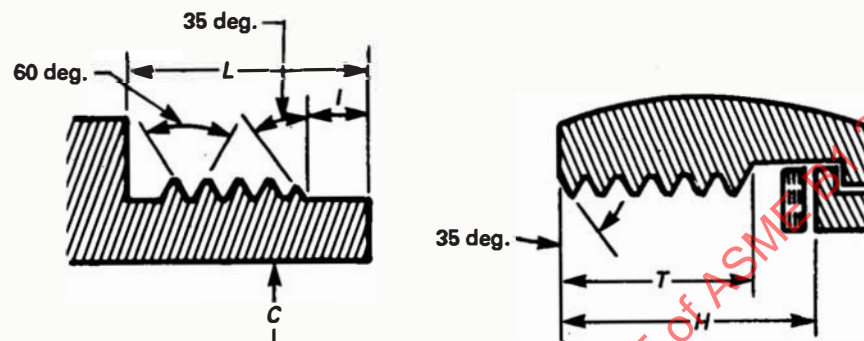
TABLE 3 PRODUCT INTERNAL THREAD LIMITS OF SIZE AND TOLERANCES FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR COUPLING SWIVELS

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation	Service	Pitch	Basic Height of Thread	Coupling (Internal) Thread							Major Diam- eter [Note (1)]
						Minor Diameter			Pitch Diameter			Min.	
						Min	Max	Tol.	Min	Max	Tol.		
1	2	3	4	5	6	7	8	9	10	11	12	13	
1/2, 5/8, 3/4	11.5	3/4-11.5NH	Garden hose	0.08696	0.05648	0.9595	0.9765	0.0170	1.0160	1.0245	0.0085	1.0725	
1/2, 5/8, 3/4	11.5	3/4-11.5NHR	Garden hose formed thread	0.08696	0.05648	0.9720	0.9930	0.0210	1.0160	1.0280	0.0120	1.0680	
1/2	14	1/2-14NPSH	Steam, air, water, and all other hose connections to be made up with standard pipe threads.	0.07143	0.04639	0.7395	0.7535	0.0140	0.7859	0.7929	0.0070	0.8323	
3/4	14	3/4-14NPSH		0.07143	0.04639	0.9500	0.9640	0.0140	0.9964	1.0034	0.0070	1.0428	
1	11.5	1-11.5NPSH		0.08696	0.05648	1.1921	1.2091	0.0170	1.2486	1.2571	0.0085	1.3051	
1 1/4	11.5	1 1/4-11.5NPSH		0.08696	0.05648	1.5369	1.5539	0.0170	1.5934	1.6019	0.0085	1.6499	
1 1/2	11.5	1 1/2-11.5NPSH		0.08696	0.05648	1.7758	1.7928	0.0170	1.8323	1.8408	0.0085	1.8888	
2	11.5	2-11.5NPSH		0.08696	0.05648	2.2498	2.2668	0.0170	2.3063	2.3148	0.0085	2.3628	
2 1/2	8	2 1/2-8NPSH		0.12500	0.08119	2.6930	2.7152	0.0222	2.7742	2.7853	0.0111	2.8554	
3	8	3-8NPSH		0.12500	0.08119	3.3193	3.3415	0.0222	3.4005	3.4116	0.0111	3.4817	
3 1/2	8	3 1/2-8NPSH	0.12500	0.08119	3.8196	3.8418	0.0222	3.9008	3.9119	0.0111	3.9820		
4	8	4-8NPSH	0.12500	0.08119	4.3179	4.3401	0.0222	4.3991	4.4102	0.0111	4.4803		
4	6	4-6NH(SPL)	Marine applications	0.16667	0.10825	4.7117	4.7477	0.0360	4.8200	4.8380	0.0180	4.9283	
[Note (2)]													

NOTES:

- (1) Dimensions for the minimum major diameter of the coupling correspond to the basic flat ($\frac{1}{8} \times P$), and the profile at the major diameter produced by a worn tool must not fall below the basic outline. For reference only the maximum major diameter of the coupling shall be that corresponding to a flat at the major diameter of the maximum coupling equal to $\frac{1}{24} \times P$ and may be determined by adding $1\frac{1}{2} \times h$ (or $0.7939P$) to the maximum pitch diameter of the coupling.
- (2) Data on the 4-6NH(SPL) thread are included since this thread is used extensively aboard ship by the Navy Department.

TABLE 4 LENGTHS OF THREADS FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR



Nominal Size of Hose	Thread per Inch, tpi	Thread Designation	Service	Inside Diameter of Nipple, C	Approximate Outside Diameter of External Thread	Length of Nipple, L	Length of Pilot, I	Depth of Coupling, H	Thread Length for Coupling, T	Approximate Number of Threads in Length, T
1	2	3	4	5	6	7	8	9	10	11
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NH	Garden hose	$\frac{25}{32}$	$1\frac{1}{16}$	$\frac{9}{16}$	$\frac{1}{8}$	$\frac{17}{32}$	$\frac{3}{8}$	$4\frac{1}{4}$
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5NHR	Garden hose formed thread	$\frac{25}{32}$	$1\frac{1}{16}$	$\frac{9}{16}$	$\frac{1}{8}$	$\frac{17}{32}$	$\frac{3}{8}$	$4\frac{1}{4}$
$\frac{1}{2}$	14	$\frac{1}{2}$ -14NPSH	Steam, air, water, and all other hose connections to be made up with standard pipe threads.	$\frac{17}{32}$	$1\frac{3}{16}$	$\frac{1}{2}$	$\frac{1}{8}$	$\frac{15}{32}$	$\frac{5}{16}$	$4\frac{1}{4}$
$\frac{3}{4}$	14	$\frac{3}{4}$ -14NPSH		$\frac{25}{32}$	$1\frac{1}{32}$	$\frac{9}{16}$	$\frac{1}{8}$	$\frac{17}{32}$	$\frac{3}{8}$	$5\frac{1}{4}$
1	11.5	1-11.5NPSH		$1\frac{1}{32}$	$1\frac{9}{32}$	$\frac{9}{16}$	$\frac{5}{32}$	$\frac{17}{32}$	$\frac{3}{8}$	$4\frac{1}{4}$
$1\frac{1}{4}$	11.5	$1\frac{1}{4}$ -11.5NPSH		$1\frac{9}{32}$	$1\frac{5}{8}$	$\frac{5}{8}$	$\frac{5}{32}$	$\frac{19}{32}$	$\frac{15}{32}$	$5\frac{1}{2}$
$1\frac{1}{2}$	11.5	$1\frac{1}{2}$ -11.5NPSH		$1\frac{17}{32}$	$1\frac{7}{8}$	$\frac{5}{8}$	$\frac{5}{32}$	$\frac{19}{32}$	$\frac{15}{32}$	$5\frac{1}{2}$
2	11.5	2-11.5NPSH		$2\frac{1}{32}$	$2\frac{11}{32}$	$\frac{3}{4}$	$\frac{3}{16}$	$\frac{23}{32}$	$\frac{19}{32}$	$6\frac{3}{4}$
$2\frac{1}{2}$	8	$2\frac{1}{2}$ -8NPSH	Marine applications	$2\frac{17}{32}$	$2\frac{27}{32}$	1	$\frac{1}{4}$	$\frac{15}{16}$	$\frac{11}{16}$	$5\frac{1}{2}$
3	8	3-8NPSH		$3\frac{1}{32}$	$3\frac{15}{32}$	$1\frac{1}{8}$	$\frac{1}{4}$	$1\frac{1}{16}$	$\frac{13}{16}$	$6\frac{1}{2}$
$3\frac{1}{2}$	8	$3\frac{1}{2}$ -8NPSH		$3\frac{17}{32}$	$3\frac{31}{32}$	$1\frac{1}{8}$	$\frac{1}{4}$	$1\frac{1}{16}$	$\frac{13}{16}$	$6\frac{1}{2}$
4	8	4-8NPSH		$4\frac{1}{32}$	$4\frac{15}{32}$	$1\frac{1}{8}$	$\frac{1}{4}$	$1\frac{1}{16}$	$\frac{13}{16}$	$6\frac{1}{2}$
4	6	4-6NH(SPL)		4	$4\frac{29}{32}$	$1\frac{1}{8}$	$\frac{5}{16}$	$1\frac{1}{16}$	$\frac{3}{4}$	$4\frac{1}{2}$

TABLE 5 VARIATIONS IN LEAD AND HALF-ANGLE CONSUMING ONE-HALF OF PITCH DIAMETER TOLERANCES FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH AND NHR

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation	Pitch Diameter Tolerance [Note (1)]	Lead Variation Consuming One-Half of Pitch Diameter Tolerance [Notes (1) and (2)]	Half-Angle Variation Consuming One-Half of Pitch Diameter Tolerance [Notes (2) and (3)]
1	2	3	4	5	6
					deg. min
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5 NH	0.0085	0.0025	1 52
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5 NHR (external)	0.0170	0.0049	3 44
$\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$	11.5	$\frac{3}{4}$ -11.5 NHR (internal)	0.0120	0.0035	2 38
$\frac{1}{2}$	14	$\frac{1}{2}$ -14 NPSH	0.0070	0.0020	1 52
$\frac{3}{4}$	14	$\frac{3}{4}$ -14 NPSH	0.0070	0.0020	1 52
1	11.5	1-11.5 NPSH	0.0085	0.0025	1 52
$1\frac{1}{4}$	11.5	$1\frac{1}{4}$ -11.5 NPSH	0.0085	0.0025	1 52
$1\frac{1}{2}$	11.5	$1\frac{1}{2}$ -11.5 NPSH	0.0085	0.0025	1 52
2	11.5	2-11.5 NPSH	0.0085	0.0025	1 52
$2\frac{1}{2}$	8	$2\frac{1}{2}$ -8 NPSH	0.0111	0.0032	1 42
3	8	3-8 NPSH	0.0111	0.0032	1 42
$3\frac{1}{2}$	8	$3\frac{1}{2}$ -8 NPSH	0.0111	0.0032	1 42
4	8	4-8 NPSH	0.0111	0.0032	1 42
4 [Note (3)]	6	4-6 NH (SPL)	0.0180	0.0052	2 4

NOTES:

- (1) The tolerances specified for pitch diameter include all variation of pitch diameter, lead, and angle. The full tolerance cannot, therefore, be used on pitch diameter unless the lead and angle of the thread are perfect. The last two columns give, for information, the variations in lead and angle, each of which can be compensated for by half the pitch-diameter tolerance given in column 4. If lead and angle variations both exist to the amount tabulated, the pitch diameter of a nipple, for example, must be reduced by the full tolerances or it will not enter the GO gage.
- (2) Between any two threads not farther apart than the length of engagement.
- (3) Values are based upon diameter equivalents of half-angle variations equal to $1.5P \tan \Delta\alpha$ where P is the thread pitch and $\Delta\alpha$ is half-angle variation. This relationship is an approximation where half-angle variations of the flanks are equal.

TABLE 6 GAGE LIMITS OF SIZE OF RING GAGES FOR EXTERNAL (NIPPLE) THREADS FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation		X Thread Ring Gages				Z Plain Ring Gages	
				GO		NOT GO (LO)		Major Diameter	
				Pitch Diameter	Minor Diameter [Note (1)]	Pitch Diameter	Minor Diameter	GO	NOT GO
Gage Tolerance →				-	-	+	+	-	+
1	2	3	4	5	6	7	8	9	10
1/2, 5/8, 3/4	11.5	3/4-11.5 NH	max. min.	1.0060 1.0057	0.9595 0.9589	0.9978 0.9975	0.9793 0.9787	1.06250 1.06238	1.04562 1.04550
1/2, 5/8, 3/4	11.5	3/4-11.5 NHR	max. min.	1.0100 1.0097	0.9720 0.9726	0.9933 0.9930	0.9748 0.9742	1.05200 1.05188	1.03512 1.03500
1/2	14	1/2-14 NPSH	max. min.	0.7784 0.7781	0.7395 0.7389	0.7717 0.7714	0.7565 0.7559	0.82480 0.82470	0.81090 0.81080
3/4	14	3/4-14 NPSH	max. min.	0.9889 0.9886	0.9500 0.9494	0.9822 0.9819	0.9670 0.9664	1.03530 1.03518	1.02142 1.02130
1	11.5	1-11.5 NPSH	max. min.	1.2386 1.2383	1.1921 1.1915	1.2304 1.2301	1.2119 1.2113	1.29510 1.29498	1.27822 1.27810
1 1/4	11.5	1 1/4-11.5 NPSH	max. min.	1.5834 1.5830	1.5369 1.5363	1.5753 1.5749	1.5567 1.5561	1.63990 1.63974	1.62306 1.62290
1 1/2	11.5	1 1/2-11.5 NPSH	max. min.	1.8223 1.8219	1.7758 1.7752	1.8142 1.8138	1.7956 1.7950	1.87880 1.87864	1.86196 1.86180
2	11.5	2-11.5 NPSH	max. min.	2.2963 2.2959	2.2498 2.2492	2.2882 2.2878	2.2696 2.2690	2.35280 2.35264	2.33596 2.33580
2 1/2	8	2 1/2-8 NPSH	max. min.	2.7622 2.7617	2.6930 2.6923	2.7516 2.7511	2.7247 2.7240	2.84340 2.84320	2.82140 2.82120
3	8	3-8 NPSH	max. min.	3.3885 3.3880	3.3193 3.3186	3.3779 3.3774	3.3510 3.3503	3.46970 3.46950	3.44770 3.44750
3 1/2	8	3 1/2-8 NPSH	max. min.	3.8888 3.8883	3.8196 3.8189	3.8782 3.8777	3.8513 3.8506	3.97000 3.96980	3.94800 3.94780
4	8	4-8 NPSH	max. min.	4.3871 4.3865	4.3179 4.3168	4.3766 4.3760	4.3500 4.3489	4.46830 4.46810	4.44630 4.44610
4 [Note (1)]	6	4-6 NH(SPL)	max. min.	4.7999 4.7993	4.7117 4.7109	4.7825 4.7819	4.7464 4.7458	4.90820 4.90795	4.87245 4.87220

NOTE:

(1) Gage limit values in this table have been obtained in accordance with ANSI/ASME B1.2 except for the values shown in Col. 6. The max values shown in Col. 6 are values for the min minor diameter of the internal thread.

TABLE 7 GAGE LIMITS OF SIZE OF PLUG GAGES FOR INTERNAL (COUPLING SWIVEL) THREADS FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREAD, NPSH, NH, AND NHR

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation		X Thread Plug Gages				Z Plain Plug Gages	
				GO		NOT GO (HI)		Minor Diameter	
				Major Diameter	Pitch Diameter	Major Diameter	Pitch Diameter	GO	NOT GO
Gage Tolerance →				+	+	−	−	+	−
1	2	3	4	5	6	7	8	9	10
1/2, 5/8, 3/4	11.5	3/4-11.5NH	max. min.	1.0731 1.0725	1.0163 1.0160	1.0622 1.0616	1.0245 1.0242	0.95962 0.95950	0.97650 0.97638
1/2, 5/8, 3/4	11.5	3/4-11.5NHR	max. min.	1.0686 1.0680	1.0163 1.0160	1.0657 1.0651	1.0280 1.0277	0.97212 0.97200	0.99300 0.99288
1/2	14	1/2-14NPSH	max. min.	0.8329 0.8323	0.7862 0.7859	0.8238 0.8232	0.7929 0.7926	0.73960 0.73950	0.75350 0.75340
3/4	14	3/4-14NPSH	max. min.	1.0434 1.0428	0.9967 0.9964	1.0343 1.0337	1.0034 1.0031	0.95012 0.95000	0.96400 0.96388
1	11.5	1-11.5NPSH	max. min.	1.3057 1.3051	1.2489 1.2486	1.2948 1.2942	1.2571 1.2568	1.19222 1.19210	1.20910 1.20898
1 1/4	11.5	1 1/4-11.5NPSH	max. min.	1.6505 1.6499	1.5938 1.5934	1.6396 1.6390	1.6019 1.6015	1.53706 1.53690	1.55390 1.55374
1 1/2	11.5	1 1/2-11.5NPSH	max. min.	1.8894 1.8888	1.8327 1.8323	1.8785 1.8779	1.8408 1.8404	1.77596 1.77580	1.79280 1.79264
2	11.5	2-11.5NPSH	max. min.	2.3634 2.3628	2.3067 2.3063	2.3525 2.3519	2.3148 2.3144	2.24996 2.24980	2.26680 2.26664
2 1/2	8	2 1/2-8NPSH	max. min.	2.8561 2.8554	2.7747 2.7742	2.8394 2.8387	2.7853 2.7848	2.69320 2.69300	2.71520 2.71500
3	8	3-8NPSH	max. min.	3.4824 3.4817	3.4010 3.4005	3.4657 3.4650	3.4116 3.4111	3.31950 3.31930	3.34150 3.34130
3 1/2	8	3 1/2-8NPSH	max. min.	3.9827 3.9820	3.9013 3.9008	3.9660 3.9653	3.9119 3.9114	3.81980 3.81960	3.84180 3.84160
4	8	4-8NPSH	max. min.	4.4814 4.4803	4.3997 4.3991	4.4643 4.4632	4.4102 4.4096	4.31810 4.31790	4.34010 4.33990
4	6	4-6NH(SPL)	max. min.	4.9296 4.9283	4.8206 4.8200	4.9102 4.9089	4.8380 4.8374	4.71195 4.71170	4.74770 4.74745

GENERAL NOTE: Gage limit values in this table have been obtained in accordance with ANSI/ASME B1.2.

TABLE 8 SETTING PLUG GAGE LIMITS OF SIZE FOR RING GAGES FOR AMERICAN NATIONAL STANDARD HOSE COUPLING THREADS, NPSH, NH, AND NHR¹

Nominal Size of Hose	Threads per Inch, tpi	Thread Designation		X Truncated Setting Plugs [Note (2)]						X Full Form Setting Plugs [Notes (2), (3)]	
				Plug for GO Thread Gage			Plug for NOT GO (LO) Thread Gage			Major Diameter	
				Major Diameter		Pitch Diam- eter	Major Diameter		Pitch Diam- eter	Plug for GO Thread Gage	Plug for NOT GO (LO) Thread Gage
				Trun- cated	Full		Trun- cated	Full			
Gage Tolerance →				-	+	-	-	+	+	+	+
1	2	3	4	5	6	7	8	9	10	11	12
1/2, 5/8, 3/4	11.5	3/4-11.5NH	max. min.	1.0492 1.0486	1.0631 1.0625	1.0060 1.0057	1.0352 1.0346	1.0631 1.0625	0.9978 0.9975	1.0631 1.0625	1.0631 1.0625
1/2, 5/8, 3/4	11.5	3/4-11.5NHR	max. min.	1.0387 1.0381	1.0526 1.0520	1.0100 1.0097	1.0307 1.0301	1.0526 1.0520	0.9933 0.9930	1.0526 1.0520	1.0526 1.0520
1/2	14	1/2-14NPSH	max. min.	0.8133 0.8127	0.8254 0.8248	0.7784 0.7781	0.8023 0.8017	0.8254 0.8248	0.7717 0.7714	0.8254 0.8248	0.8254 0.8248
3/4	14	3/4-14NPSH	max. min.	1.0238 1.0232	1.0359 1.0353	0.9889 0.9886	1.0128 1.0122	1.0359 1.0353	0.9822 0.9819	1.0359 1.0353	1.0359 1.0353
1	11.5	1-11.5NPSH	max. min.	1.2818 1.2812	1.2957 1.2951	1.2386 1.2383	1.2678 1.2672	1.2957 1.2951	1.2304 1.2301	1.2957 1.2951	1.2957 1.2951
1 1/4	11.5	1 1/4-11.5NPSH	max. min.	1.6266 1.6260	1.6405 1.6399	1.5834 1.5830	1.6126 1.6210	1.6405 1.6399	1.5753 1.5749	1.6405 1.6399	1.6405 1.6399
1 1/2	11.5	1 1/2-11.5NPSH	max. min.	1.8655 1.8649	1.8794 1.8788	1.8223 1.8219	1.8515 1.8509	1.8794 1.8788	1.8142 1.8138	1.8794 1.8788	1.8794 1.8788
2	11.5	2-11.5NPSH	max. min.	2.3395 2.3389	2.3534 2.3528	2.2963 2.2959	2.3255 2.3249	2.3534 2.3528	2.2882 2.2878	2.3534 2.3528	2.3534 2.3528
2 1/2	8	2 1/2-8NPSH	max. min.	2.8263 2.8256	2.8440 2.8434	2.7622 2.7617	2.8052 2.8045	2.8441 2.8434	2.7516 2.7511	2.8441 2.8434	2.8441 2.8434
3	8	3-8NPSH	max. min.	3.4526 3.4519	3.4704 2.4697	3.3885 3.3880	3.4315 3.4308	3.4704 3.4697	3.3779 3.3774	3.4704 3.4697	3.4704 3.4697
3 1/2	8	3 1/2-8NPSH	max. min.	3.9529 3.9522	3.9707 3.9700	3.8888 3.8883	3.9318 3.9311	3.9707 3.9700	3.8782 3.8777	3.9707 3.9700	3.9707 3.9700
4	8	4-8NPSH	max. min.	4.4512 4.4501	4.4694 4.4683	4.3871 4.3865	4.4301 4.4290	4.4694 4.4683	4.3766 3.3760	4.4694 4.4683	4.4694 4.4683
4	6	4-6NH(SPL)	max. min.	4.8872 4.8864	4.9090 4.9082	4.7999 4.7993	4.8541 4.8533	4.9090 4.9082	4.7825 4.7819	4.9090 4.9082	4.9090 4.9082

NOTES:

- (1) Gage limit values in this table have been obtained in accordance with ANSI/ASME B1.2.
 (2) Lead, flank angle, and taper are to be held to Class "W" tolerances as specified in ANSI/ASME B1.2.
 (3) Pitch diameter limits for full form (GO) setting plugs are the same as those shown in column 7. Pitch diameter limits for basic-crest NO GO (LO) setting plugs are the same as those shown in column 10.

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