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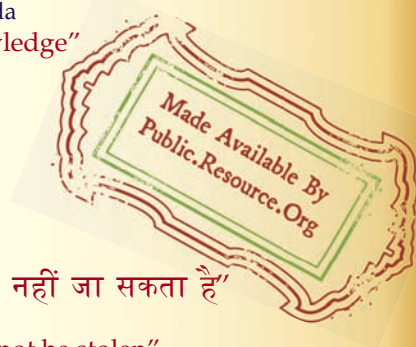
IS 554 (1999): Pipe Threads Where Pressure-Tight Joints are Made on the Threads - Dimensions, Tolerances and Designation [PGD 20: Engineering Standards]



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भारतीय मानक

पाइप की चूड़ियां जहां चूड़ियों पर दाबरुद्ध जोड़ बनाये
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(चौथा पुनरीक्षण)

Indian Standard

PIPE THREADS WHERE PRESSURE-TIGHT JOINTS
ARE MADE ON THE THREADS — DIMENSIONS,
TOLERANCES AND DESIGNATION
(*Fourth Revision*)

ICS 21.040.30

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

NATIONAL FOREWORD

This Indian Standard (Fourth Revision) which is identical with ISO 7-1 : 1994 'Pipe threads where pressure-tight joints are made on the threads — Part 1 : Dimensions, tolerances and designation', issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Engineering Standards Sectional Committee and approval of the Light Mechanical Engineering Division Council.

This standard was originally issued in 1955 and subsequently revised in 1964 and 1985. The third revision was harmonized with ISO Standard by adopting ISO 7-1:1982. This fourth revision has been taken up to align it with the latest version of ISO 7-1 which has been technically revised in 1994.

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. In the adopted standard certain conventions are not identical to those used in Indian Standards; attention is especially drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker while in Indian Standards, the current practice is to use a full point (.) as the decimal marker.

In this adopted standard, reference appears to one International Standards for which Indian Standard also exists. The corresponding Indian Standard which is to be substituted in its place are listed below along with its degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 7-2 : 1982	IS 8999 : 1979 Gauging practice for pipe threads where pressure-tight joints are required on the threads (<i>first revision</i>) (<i>under preparation</i>)	Related

ADDITIONAL INFORMATION

The verification of threads covered in this standard shall be done in accordance with IS 8999 : 1979 till the publication of its first revision.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

PIPE THREADS WHERE PRESSURE-TIGHT JOINTS
ARE MADE ON THE THREADS — DIMENSIONS,
TOLERANCES AND DESIGNATION
(*Fourth Revision*)

1 Scope

This part of ISO 7 specifies the requirements for thread form, dimensions, tolerances and designation for jointing pipe threads, sizes 1/16 to 6 inclusive, for joints made pressure-tight by the mating of the threads. These threads are taper external, parallel internal or taper internal and are intended for use with pipes suitable for threading and for valves, fittings or other pipeline equipment interconnected by threaded joints.

An appropriate jointing medium should be used on the thread to ensure pressure-tight joints.

NOTES

- 1 Parallel external pipe threads are not suitable as jointing threads.
- 2 For pipe threads where pressure-tight joints are not made on the threads, see ISO 228-1.
- 3 ISO 7-2 gives details of methods of verification of jointing thread dimensions and form and recommended gauging systems.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this part of ISO 7. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this part of ISO 7 are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO

maintain registers of currently valid International Standards.

ISO 7-2:1982, *Pipe threads where pressure-tight joints are made on the threads — Part 2: Verification by means of limit gauges.*

3 Definitions

For the purposes of this part of ISO 7, the following definitions apply (see also figures 3 and 5).

3.1 gauge diameter: Major diameter of the thread, whether external or internal.

3.2 major cone: Imaginary cone which just touches the crests of a taper external thread or the roots of a taper internal thread.

3.3 gauge plane: Plane, perpendicular to the axis of the taper thread, at which the major cone has the gauge diameter.

NOTE 4 For external threads the gauge plane is located at a distance equal to the nominal gauge length from the small end of the thread. For internal threads the gauge plane is located at a distance of half-pitch behind the face of the threaded part. This is in order to give consideration to the start of the thread that has been removed by chamfering.

3.4 gauge length: On an external thread, the distance from the gauge plane to the small end of the thread.

3.5 reference plane: Visible surface of each of the internally and externally threaded parts, which facili-

tates the reading of the gauge when the thread is inspected.

For internal threads it is the face of the internally threaded part, for external threads it is the small end of the externally threaded part.

3.6 complete thread: That part of the thread which is fully formed at both crest and root.

NOTE 5 When there is a chamfer at the start of the thread not exceeding one pitch in length, this is included in the length of complete thread.

3.7 incomplete thread: That part of the thread which is fully formed at the root, but truncated at the crest by its intersection with the cylindrical surface of the product.

3.8 washout thread; vanish thread: That part of the thread which is not fully formed at the root.

NOTE 6 The washout thread is produced by the bevel at the start of the threading tool.

3.9 useful thread: Complete thread plus incomplete thread, excluding the washout thread.

3.10 fitting allowance: Length of useful thread beyond the gauge plane of an external thread required to provide for assembly with an internal thread at the upper limit of the tolerance.

NOTE 7 Internally threaded parts will have a sufficient length to accommodate the fitting allowance, except when they have a free run-out. See 7.2.2.

3.11 wrenching allowance: Length of useful thread which is provided to accommodate the relative movement between the end of the externally threaded part and the internally threaded part required for wrenching beyond the position of handtight engagement.

4 Symbols

- Rp Parallel internal pipe thread where pressure-tight joints are made on the threads
- Rc Taper internal pipe thread where pressure-tight joints are made on the threads
- R Taper external pipe thread where pressure-tight joints are made on the threads

- P Pitch
- H Height of the triangle of the thread profile perpendicular to the thread axis
- h $= 0,640\ 327\ P$; height of the thread profile between rounded crests and roots perpendicular to the thread axis
- r Radius of rounded crests and roots
- D Major diameter of the internal thread at the gauge plane (gauge diameter — see 3.1)
- D_1 $D - 1,280\ 654\ P$; minor diameter of the internal thread at the gauge plane
- D_2 $D - 0,640\ 327\ P$; pitch diameter of the internal thread at the gauge plane
- d Major diameter of the external thread at the gauge plane (gauge diameter — see 3.1)
- d_1 $= d - 1,280\ 654\ P$; minor diameter of the external thread at the gauge plane
- d_2 $= d - 0,640\ 327\ P$; pitch diameter of the external thread at the gauge plane
- T_1 Tolerance on the gauge length of an external thread
- T_2 Tolerance for the position of the gauge plane on an internal thread

5 Dimensions

Pipe thread dimensions, in millimetres, are given in table 1.

6 Designation

The designation of threads according to this part of ISO 7 shall consist of the following elements in the sequence given:

6.1 The description block shall be:

Pipe thread

6.2 The International Standard number block shall be:

ISO 7

Table 1 — Thread dimensions

Dimensions in millimetres

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
Designation of thread size	Number of threads in 25,4 mm	Pitch	Height of thread	Diameters at gauge plane			Gauge length (external thread)										Length of useful external thread not less than	Fitting allowance	Diametral tolerance ¹⁾ on parallel internal threads	
				Major (gauge diameter)	Pitch	Minor	Nominal	Tolerance $\pm T_1/2$		max.	min.	Tolerance $\pm T_2/2$		Turns of thread	For nominal gauge length	For maximum gauge length				For minimum gauge length
								2)	Turns of thread			2)	Turns of thread							
1/16	28	0.907	0.581	7.723	7.142	6.561	4	0.9	1	4.9	3.1	1.1	11/4	6.5	7.4	5.6	2.5	23/4	± 0.071	
1/8	28	0.907	0.581	9.728	9.147	8.566	4	0.9	1	4.9	3.1	1.1	11/4	6.5	7.4	5.6	2.5	23/4	± 0.071	
1/4	19	1.337	0.856	13.157	12.301	11.445	6	1.3	1	7.3	4.7	1.7	11/4	9.7	11	8.4	3.7	23/4	± 0.104	
3/8	19	1.337	0.856	16.662	15.806	14.950	6.4	1.3	1	7.7	5.1	1.7	11/4	10.1	11.4	8.8	3.7	23/4	± 0.104	
1/2	14	1.814	1.162	20.955	19.793	18.631	8.2	1.8	1	10.0	6.4	2.3	11/4	13.2	15	11.4	5.0	23/4	± 0.142	
3/4	14	1.814	1.162	26.441	25.279	24.117	9.5	1.8	1	11.3	7.7	2.3	11/4	14.5	16.3	12.7	5.0	23/4	± 0.142	
1	11	2.309	1.479	33.249	31.770	30.291	10.4	2.3	1	12.7	8.1	2.9	11/4	16.8	19.1	14.5	6.4	23/4	± 0.180	
1 1/4	11	2.309	1.479	41.910	40.431	38.952	12.7	2.3	1	15.0	10.4	2.9	11/4	19.1	21.4	16.8	6.4	23/4	± 0.180	
1 1/2	11	2.309	1.479	47.803	46.324	44.845	12.7	2.3	1	15.0	10.4	2.9	11/4	19.1	21.4	16.8	6.4	23/4	± 0.180	
2	11	2.309	1.479	59.614	58.135	56.656	15.9	2.3	1	18.2	13.6	2.9	11/4	23.4	25.7	21.1	7.5	3 1/4	± 0.180	
2 1/2	11	2.309	1.479	75.184	73.705	72.226	17.5	3.5	1 1/2	21.0	14.0	3.5	1 1/2	26.7	30.2	23.2	9.2	4	± 0.216	
3	11	2.309	1.479	87.884	86.405	84.926	20.6	3.5	1 1/2	24.1	17.1	3.5	1 1/2	29.8	33.3	26.3	9.2	4	± 0.216	
4	11	2.309	1.479	113.030	111.551	110.072	25.4	3.5	1 1/2	28.9	21.9	3.5	1 1/2	35.8	39.3	32.3	10.4	4 1/2	± 0.216	
5	11	2.309	1.479	138.430	136.951	135.472	28.6	3.5	1 1/2	32.1	25.1	3.5	1 1/2	40.1	43.6	36.6	11.5	5	± 0.216	
6	11	2.309	1.479	163.830	162.351	160.872	28.6	3.5	1 1/2	32.1	25.1	3.5	1 1/2	40.1	43.6	36.6	11.5	5	± 0.216	
NOTE — The main dimensions were converted into millimetres on the basis of 1 inch = 25.4 mm, beginning with the number of threads per inch, which determines the pitch <i>P</i> , the formula <i>h</i> (the height of thread) = 0.640 327 <i>P</i> and the major diameter at the gauge plane. Pitch diameter and minor diameter were then compiled by subtracting once or twice respectively the height of thread <i>h</i> from the major diameter.																				
The nominal gauge length, the tolerances and the fitting allowance were directly computed. The remaining lengths given in table 1 were obtained by subtracting or adding the tolerances or fitting allowance respectively to the nominal gauge length. Tolerances and fitting allowance are expressed in millimetres and in number of turns of thread.																				
1) For parallel internally threaded parts the diametral tolerances are derived from the tolerances in column 14 by multiplying with the corresponding pitch in column 3 and with 1/16, the amount of taper.																				
2) Informative tolerances, in millimetres, are obtained from the mandatory values in turns of thread by multiplying with the corresponding pitch in column 3 and rounding to the nearest 0.1 mm.																				

6.3 The individual item block shall be composed of:

- a) letter symbol(s) for type of pipe thread
 - the letter R followed by the letter p for parallel internal threads;
 - the letter R followed by the letter c for taper (conical) internal threads;
 - the letter R for external threads;
- b) the thread size, from column 1 of table 1.

EXAMPLES

The complete designation for a right-hand thread size 1 1/2:

Internal thread	parallel	Pipe thread ISO 7 - Rp 1 1/2
	taper	Pipe thread ISO 7 - Rc 1 1/2
External thread	always taper	Pipe thread ISO 7 - R 1 1/2

6.4 For left-hand threads, the letters LH shall be added to the designation. Right-hand threads require no special designation.

7 Thread design

7.1 Thread forms

7.1.1 Parallel thread

The basic form of the parallel pipe thread shall be as shown in figure 1. The angle between the flanks, measured in an axial plane section, is 55°. The thread profiles are rounded equally at crests and roots by circular arcs blending tangentially with the flanks.

7.1.2 Taper thread

The basic form of the taper pipe thread shall be as shown in figure 2. The taper is 1 to 16, measured on the diameter. The angle between the flanks, measured in an axial plane section, is 55°, the flanks making equal angles with the axis.

The thread profiles are rounded off equally at crests and roots by circular arcs blending tangentially with

the flanks in such a manner as to give the same thread height *h* as for parallel threads.

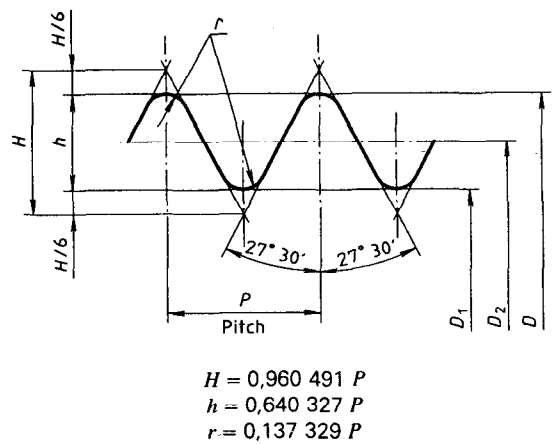


Figure 1 — Parallel thread

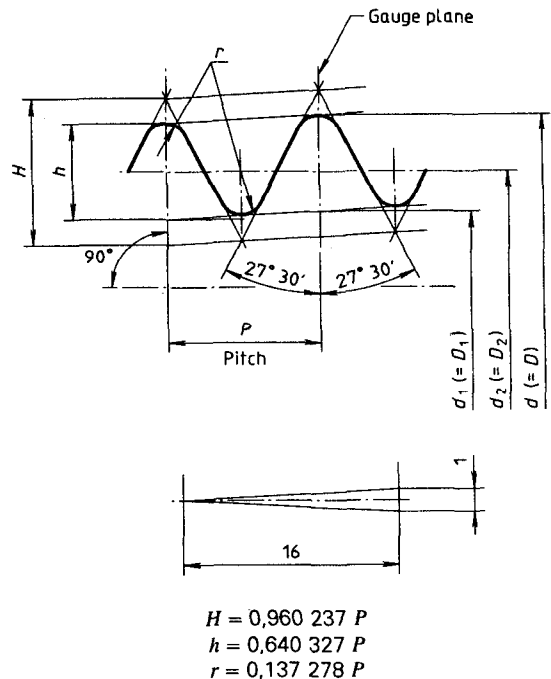


Figure 2 — Taper thread

7.1.3 Direction of thread helix

Unless otherwise specified, the ISO 7-1 thread shall be a right-hand thread. (See also 6.4.)

7.2 Thread lengths

7.2.1 External thread

The terms relating to the external taper pipe thread are given in figure 3.

The length of the useful thread, allowable in practice, is the sum of the lengths of the complete and incomplete threads, excluding the washout thread. The minimum length of the useful thread must be not less than the minimum gauge length plus the fitting allowance.

7.2.2 Internal thread

The design of internally threaded parts shall be such that they can receive external threads up to the lengths given in column 16 of table 1. The minimum lengths $L_{\min}$ of useful thread in the case of internal

threads with free run-out shall be not less than 80 % of the values given in column 17 of table 1. (See figure 4.)

8 Gauging

For the verification of pipe threads, the plug and ring gauges used shall conform to ISO 7-2. The gauging always relates to a reference plane of the threaded part to be verified (see figure 5).

9 Combination with fastening thread

The combination of an external parallel thread G, tolerance class A or B in accordance with ISO 228-1, with an internal parallel thread Rp in accordance with ISO 7-1 needs special consideration.

When it is necessary to have this combination, the positive or negative tolerance of the internal thread to ISO 7-1 shall be considered in the relevant product standards, where external parallel threads G are used.

Such a combination of threads may not necessarily achieve a leak-tight joint.

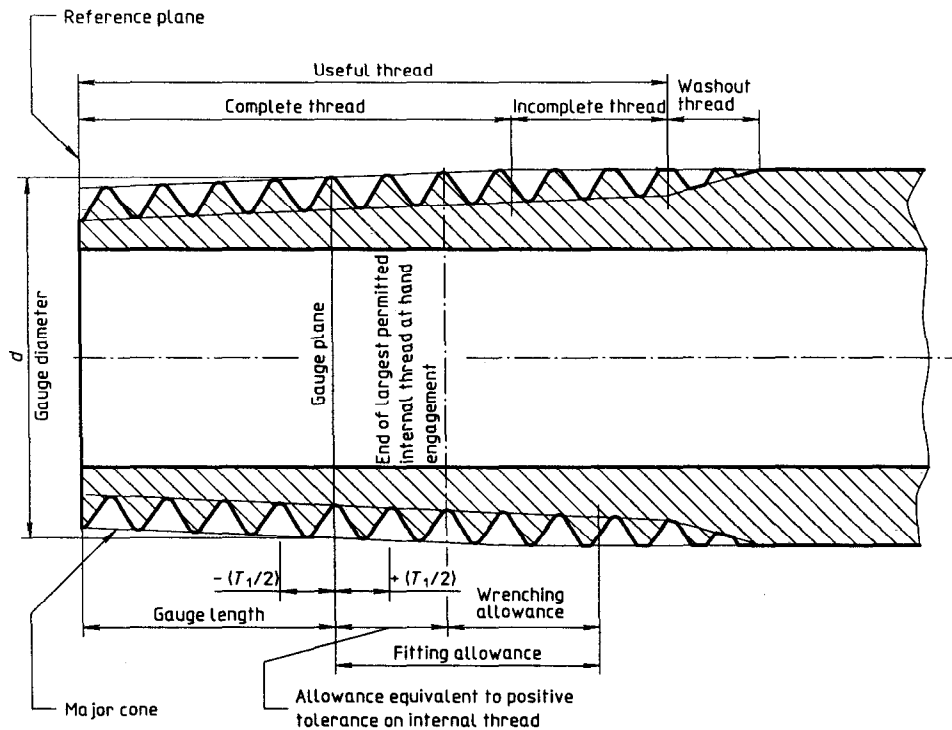


Figure 3 — Terms relating to external threads



Figure 4 — Internal threads with free run-out

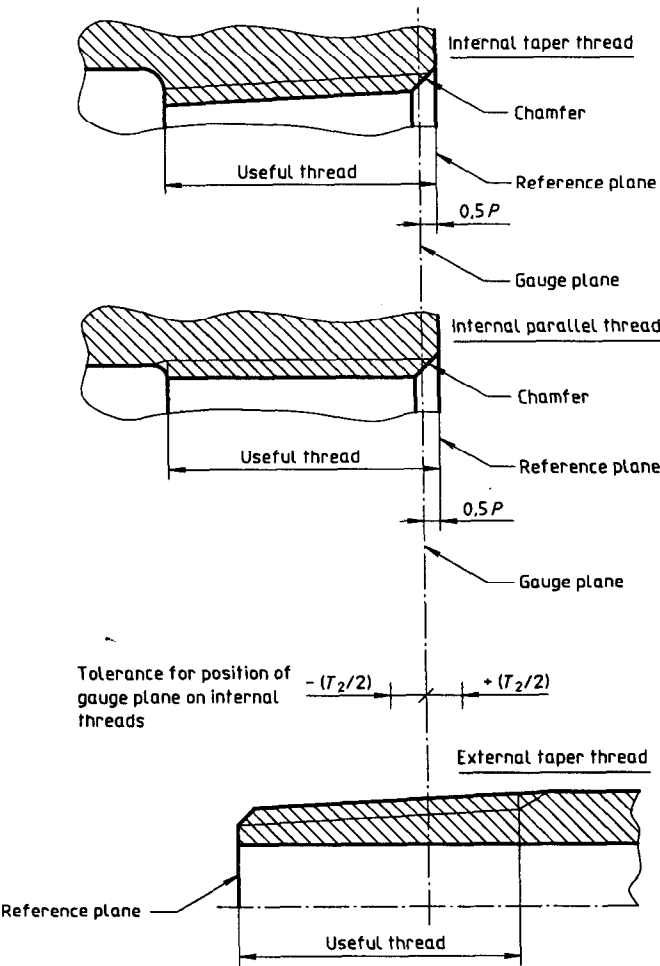


Figure 5 — Illustration of internal and external pipe threads (position of gauge plane, reference plane useful thread)

Annex A

(informative)

Bibliography

- [1] ISO 228-1:1994, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation.*

Bureau of Indian Standards

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Review of Indian Standards

Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Handbook' and 'Standards Monthly Additions'.

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones: 323 01 31, 323 33 75, 323 94 02

Telegrams: Manaksanstha
(Common to all offices)

Regional Offices:

	Telephone
Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	323 76 17, 323 38 41
Eastern : 1/14 C.I.T. Scheme VII M, V.I.P. Road, Maniktola CALCUTTA 700054	{ 337 84 99, 337 85 61 337 86 26, 337 91 20
Northern : SCO 335-336, Sector 34-A, CHANDIGARH 160022	{ 60 38 43 60 20 25
Southern : C.I.T. Campus, IV Cross Road, CHENNAI 600113	{ 235 02 16, 235 04 42 235 15 19, 235 23 15
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