

TAPER PIPE REAMERS

Size	Projection				Ream Dia. Large End	Gage Width L ₁	Reamed Length L ₁ + L ₃	Tap Drill for Use with Reaming	Tap Drill for Use without Reaming	Hole Depth for Standard Pipe Tap - Inches (minimum)	Hole Depth for SAE PTF Tap - Inches (minimum)
	NPT & NPTF		SAE-SHORT								
	Min.	Max.	Min.	Max.							
1/16 - 27	0.250	0.375	0.222	0.259	0.2515	0.1600	0.2711	15/64	C	0.5625	0.4564
1/8 - 27	0.250	0.375	0.222	0.259	0.3340	0.1615	0.2726	21/64	Q	0.5937	0.4578
1/4 - 18	0.397	0.521	0.333	0.389	0.4472	0.2278	0.3945	27/64	7/16	0.8125	0.6722
3/8 - 18	0.392	0.516	0.333	0.389	0.5826	0.2400	0.4067	9/16	9/16	0.8125	0.6844
1/2 - 14	0.517	0.641	0.429	0.500	0.7213	0.3200	0.5343	11/16	45/64	1.0312	0.8915
3/4 - 14	0.503	0.627	0.429	0.500	0.9317	0.3390	0.5533	57/64	29/32	1.0312	0.9105
1 - 11 1/2	0.584	0.772			1.1691	0.4000	0.6609	1 1/8	1 9/64	1.2500	1.0956
1 1/4 - 11 1/2	0.592	0.780			1.5138	0.4200	0.6809	1 15/32	1 31/64	1.2812	1.1156
1 1/2 - 11 1/2	0.606	0.792			1.7528	0.4200	0.6809	1 45/64	1 23/32	1.3125	1.1156
2 - 11 1/2	0.574	0.760			2.2267	0.4360	0.6909	2 3/16	2 3/16	1.2812	1.1316

Table 1 - Dimensions for taper pipe taps, corresponding reamed holes, and recommended tap drills.