Pipe Fittings and Port Adapters

This Section contains adapters with thread types including: NPT, NPTF, BSPT, BSPP, SAE UN/UNF, and Metric. All the threads in this section are made to industry specifications with conformance shown in Table F1.

Design and Construction

Shaped products (elbows, tees and crosses) are hot forged and machined, while straights are manufactured from cold drawn barstock. Where applicable, these products are made in conformance with the design criteria of the Society of Automotive Engineers Standards, SAE J514, J530.

Parker Fluid Connector products made from steel and brass, for the most part, have NPTF threads. Stainless steel products may have NPT or slightly modified NPT threads to minimize the chance of galling on assembly.

Standard Material Specifications: The standard materials used in the manufacture of Industrial Pipe and Adapter fittings are shown in Table U1 on page U2.

Note: Upon request, pipe fittings, adapters and plugs could be furnished in materials other than those shown in the material specifications chart.

Finish - Zinc plating with silver chromate (zinc chromium 6 free) is used on all standard steel products. Stainless steel fittings are passivated.

How Port Connections Work

Tapered ("Pipe") Threads

There are three types of tapered threads commonly used in industrial applications.

- NPT/NPTF
- BSPT
- Metric Taper

All three thread styles noted above use the same basic metal-to-metal sealing design for achieving a seal. Although very similar, there are differences in the thread dimensions, pitch, and flank angle that do not allow interchangeability.

NPT / NPTF Threads

NPT threads, when assembled without a sealant, leave a spiral leak path at the crest-root junction as shown in Fig. F1. To seal pressurized fluid, NPT threads require a suitable sealant. NPTF threads (Dryseal), on the other hand, when assembled, do not leave the spiral leak path. This is because they have controlled truncation at the crest and root, ensuring metal-to-metal crest-root contact prior to, or just as the male-female thread flanks make contact as seen in Fig. F2. Upon further tightening, the thread crests are flattened out until the flanks also make metal-to-metal contact as seen in Fig. F3. Thus, theoretically at least, there is no passage left for the fluid to leak, provided all surfaces are flawless and dimensions exact. **In reality, this is not the case and a sealant/lubricant is necessary to achieve a leak free joint, even with NPTF threads.** The sealant/lubricant fills all imperfections in the surfaces affecting the seal and also provides lubrication to ease assembly and minimize galling.

Assembly and Installation

Please refer to Section S for the assembly and installation instructions for Pipe Fittings and Port Adapters.

Thread	Standard
NPT	ANSI B1.20.1, FED-STD-H28/7
NPTF	SAE J476, ANSI B1.20.3, FED-STD-H28/8
BSPT	BS 21, ISO 7/1
BSPP	BS 2779, ISO 228/1
Metric	ISO 261, ANSI B1.13M, FED-STD-H28/21
UN/UNF*	ANSI B1.1, FED-STD-H28/2

*Class 2A or 2B

Table F1 — Thread Conformance Standards

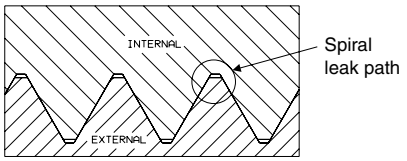

Fig. F1 — NPT: Wrench Tight, No Crest-Root Contact, Flank Contact Only

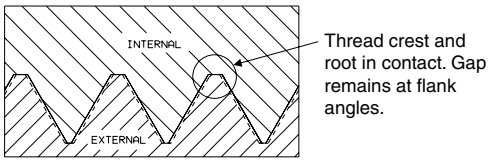

Fig. F2 — NPTF: Hand Tight, Crest to Root Contact

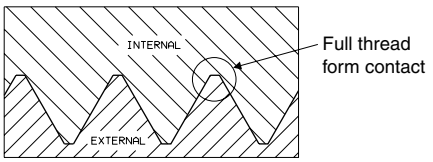

Fig. F3 — NPTF: Wrench Tight, Crest to Root and Flank Contact

Dimensions and pressures for reference only, subject to change.

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Application Guidelines for Tapered Threads

Straight Connectors with NPT/NTPF 3/4-14 and Smaller

Straight connectors with 3/4-14 NPT/NPTF and smaller male pipe threads have very high pressure holding capability and seal reliability when used in applications without “make and break” (such as maintenance) requirements.

They are also well suited for low cycle non-pulsating (static) applications with pressures in excess of 6,000 psi.

Straight Connectors with NPT/NPTF above 3/4 -14 and All Shaped Connectors with NPT/NPTF Threads

It is difficult to always tighten shapes with pipe threads to an optimum tightness level because of orientation requirements. Also, all connectors in this category with pipe threads have low reliability for leak free operation in dynamic applications. Therefore, they are not preferred where a leak free joint is required.

All NPTF Connectors

While a pipe thread connection can be disassembled and re-assembled in low-pressure systems, it is not intended to be a frequently assembled and disassembled connection. (When connectors are known to be disassembled and re-assembled repeatedly, pipe connections are not preferred for high-pressure systems.)

For the above applications, a port connection with an elastomeric seal, such as SAE straight thread port (SAE J1926/ISO11926), SAE four bolt split flange (SAE J518/ISO 6162), and ISO 6149 is recommended. For applications where elastomeric seals can’t be used, consult the manufacturer.

As noted, BSPT and metric taper are designed and perform similarly. Follow the NPT/NPTF guidelines for their application.

In general, tapered thread connections have the following limitations which should be considered when specifying port connections:

- Poor dynamic sealing characteristics
- Possible expansion, and even cracking, of the port
- Orientation is a concern in shaped connectors
- Larger threads are more prone to leakage because of more potential leak points
- System contamination due to thread sealant
- Prone to galling, especially in stainless steel
- Limited remakeability

Parallel Thread Adapters

Straight, or parallel, thread ports in various forms are becoming more popular in hydraulic systems because they are more reliable and easier to service.

Three types of threads are used for parallel thread ports:

- UN/UNF (SAE straight thread)
- BSPP (British Standard Pipe, Parallel)
- Metric parallel

Because parallel threads only serve one function (i.e. holding the fitting in place), some other means of sealing is always present, such as an elastomeric O-ring or a metal seal. There are many variations of sealing methods, and in some cases, they are interchangeable among the different thread forms and may appear to be similar.

UN / UNF Threads

SAE J1926 uses **UN/UNF** threads and is often referred to as SAE Straight Thread. The female port is often referred to as ORB or O-ring boss. This port style, shown in Fig. F4, is widely used in North America.

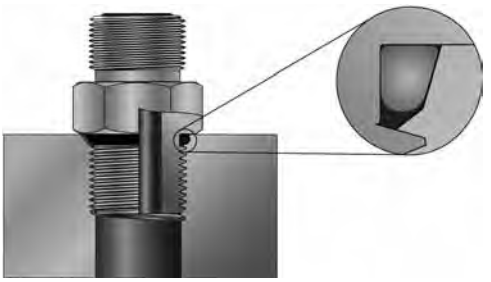

Fig. F4 — Typical O-Ring Boss Port

BSPP

In Europe, Japan and many other former Commonwealth nations, the British Standard Pipe thread form, BSP, is still used extensively to connect pipes and components in hydraulic systems. The BSP thread is offered in a straight (parallel) form known as BSPP and a tapered form known as BSPT. These threads feature a 55° flank angle. Fittings in this section with male BSPP threads use a primary sealing method of an O-ring and retaining ring, as shown in Fig. F5.

Fig. F5 — O-Ring with Retaining Ring

Additional sealing methods such as a cutting face or an EOlastic seal, as shown in Fig. G6, are also available on other fittings within the catalog. These BSPP fittings are all designed to thread into a female BSPP port (ISO 1179), however, the seal is created with one of the aforementioned sealing methods, not with the threads. It is also important to note that with these BSPP threaded connections, the seal occurs on the port surface, or spotface, not in an O-ring gland or chamfer as SAE and ISO-6149 straight thread do. A detail of the BSPP port is shown on page T36.

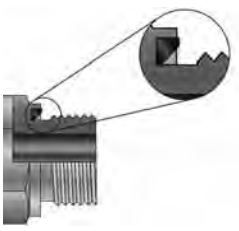

Fig. F6 — O-Ring in Fitting Groove

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Visual Index

Metric Parallel

In Europe, primarily in Germany, the traditional metric parallel thread form is used extensively to connect components in hydraulic systems. This metric thread is designed to thread into and seal in a female Metric parallel port conforming to ISO-9974-1 (DIN-3852, Part 1). Fittings in this section with male metric threads use a primary sealing method of an O-ring and retaining ring (similar to Fig. F5). Additional sealing methods such as a cutting face or an EOlastic seal (similar to Fig. F6) are also available on other fittings within the catalog. Sealing is accommodated with one of the aforementioned sealing methods, not with the threads. It is also important to note that with these male metric threads, the seal occurs on the top face (spotface) of the port, not in an O-ring gland or chamfer as in SAE and ISO-6149 straight threads. A detail of this metric port is shown on page T32.

To minimize further proliferation of additional port thread styles, the International Standards Organization Technical Committee 131 completed the development of a world standard leak-free port connection. It is recommended that this port, ISO 6149-1, be specified in all new hydraulic fluid power applications. Parker and other fluid connector manufacturers have expanded product offering to incorporate the ISO 6149 male studs as a standard on many tube fitting products. Parker offers the ISO 6149 male stud end, shown in Fig. F7, on several tube fitting products including: Seal-Lok, Triple-Lok, EO, EO-2, Conversion Adapters, Plugs, etc. This port, utilizes metric parallel threads for mechanical holding power and a sealing method similar to the proven SAE Straight Thread O-ring port. A detail of this metric port is shown on page T32.

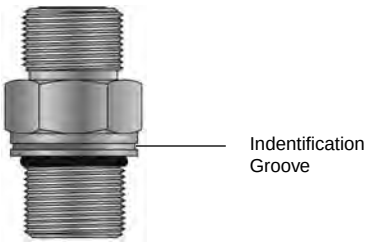

Fig. F7 — ISO 6149 Male

Feature	Advantage	Benefit
Tapered Thread Fittings		
Compact size	Suitable selection for plumbing in limited or tight space in a compact system.	Compact systems are more efficient and reduce the need for excessive routing of costly hose or tube
Widespread acceptability	Available worldwide for OEM and MRO applications	Eases efforts to find component parts and replacement fittings, reducing unnecessary downtime
High static pressure rating	Allows for use in high pressure applications	Increases versatility of fitting
Offered in three standard materials (Steel, Stainless Steel, and Brass)	Allows customer to match media and temperature applications without special fittings and seals.	Reduces component procurement costs and increases fitting availability
Adaptable to ORFS, Flareless Bite-type, Metric Bite-type, 37° flare, etc.	Versatility for end customer and for customer standardization efforts	Standardization reduces procurement costs
High temperature applications	Is not limited by temperature range of elastomeric seal	Increases versatility of fitting
Straight Thread Fittings		
Reliable sealing in dynamics applications	Ideal in systems with high pressure and cycling	Provides reliable, long-term sealing
Unlimited reusability/ remakeability	Extends the service life of the fitting	Reduces maintenance costs and component replacement costs
No thread sealant needed	Eliminates the potential for contaminating and damaging sensitive hydraulic components due to thread sealant	Reduces maintenance costs and component replacement costs
Infinite positioning of shaped adapters	Eliminates potential of damaging adapter and/or component by incorrectly assembling to accomplish correct orientation	Improves assembly time and reduces maintenance costs
Elastomeric seal	Tolerant of minor surface imperfections to provide leak-free connection	Reduces operational and maintenance costs

Dimensions and pressures for reference only, subject to change.

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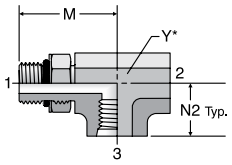
AOG5JG5

Straight Thread Run Tee
SAE-ORB (all three ends)

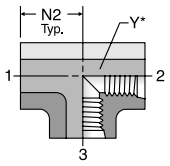


* Y – Across Wrench Flats

TUBE FITTING PART #	END SIZE 1 UN/UNF-2A	END SIZE 2 UN/UNF-2B	END SIZE 3 UN/UNF-2B	M (in.)	N2 (in.)	Y (in.)	Dynamic Pressure (x 1,000 PSI) -S	-SS	-B
4 AOG5JG5	7/16 - 20	7/16 - 20	7/16 - 20	1.23	0.74	3/4	6.0	6.0	3.3
6 AOG5JG5	9/16 - 18	9/16 - 18	9/16 - 18	1.38	0.86	7/8	5.0	5.0	3.3
8 AOG5JG5	3/4 - 16	3/4 - 16	3/4 - 16	1.59	1.03	1 1/16	4.0	4.0	2.6
10 AOG5JG5	7/8 - 14	7/8 - 14	7/8 - 14	1.81	1.18	1 1/16	2.5	2.5	1.6
12 AOG5JG5	1 1/16 - 12	1 1/16 - 12	1 1/16 - 12	2.00	1.39	1 5/16	2.5	2.5	1.6
16 AOG5JG5	1 5/16 - 12	1 5/16 - 12	1 5/16 - 12	2.25	1.52	1 5/8	2.5	2.5	1.6

G5G5JG5

Female Straight Thread Tee
SAE-ORB (all three ends)



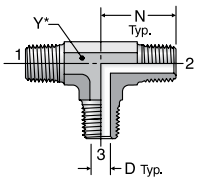
* Y – Across Wrench Flats

TUBE FITTING PART #	END SIZE 1-3 UN/UNF-2B	N2 (in.)	Y (in.)	Dynamic Pressure (x 1,000 PSI) -S	-SS	-B
4 G5G5JG5	7/16 - 20	0.74	3/4	6.0	6.0	3.3
6 G5G5JG5	9/16 - 18	0.86	3/4	5.0	5.0	3.3
8 G5G5JG5	3/4 - 16	1.03	1 1/16	4.0	4.0	2.6
10 G5G5JG5	7/8 - 14	1.18	1 1/16	2.5	2.5	1.6
12 G5G5JG5	1 1/16 - 12	1.39	1 5/16	2.5	2.5	1.6
16 G5G5JG5	1 5/16 - 12	1.52	1 5/8	2.5	2.5	1.6

RRS

Male Pipe Tee
NPTF (all three ends)

SAE 140437

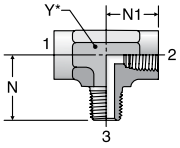


TUBE FITTING PART #	END SIZE 1-3 NPTF	N (in.)	Y (in.)	Dynamic Pressure (x 1,000 PSI) -S	-SS	-B
1/8 RRS	1/8 - 27	0.78	7/16	6.0	6.0	3.9
1/4 RRS	1/4 - 18	1.09	9/16	6.0	6.0	3.9
3/8 RRS	3/8 - 18	1.22	3/4	6.0	6.0	3.9
1/2 RRS	1/2 - 14	1.47	7/8	6.0	6.0	3.9
3/4 RRS	3/4 - 14	1.59	1 1/16	4.0	4.0	2.6

MMS

Male Branch Tee
NPTF (all three ends)

SAE 140425
HPD Base # 212T

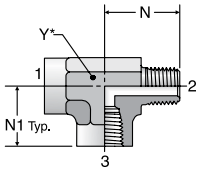


TUBE FITTING PART #	END SIZE 1-3 NPTF	N (in.)	N1 (in.)	Y (in.)	Dynamic Pressure (x 1,000 PSI) -S	-SS	-B
1/8 MMS	1/8 - 27	0.78	0.66	9/16	5.0	5.0	3.2
1/4 MMS	1/4 - 18	1.09	0.88	3/4	5.0	5.0	3.2
3/8 MMS	3/8 - 18	1.22	1.02	7/8	4.5	4.5	3.0
1/2 MMS	1/2 - 14	1.47	1.23	1 1/16	3.0	3.0	1.9
3/4 MMS	3/4 - 14	1.59	1.36	1 5/16	3.0	3.0	1.9
1 MMS	1 - 11 1/2	1.97	1.62	1 5/8	1.8	1.8	1.1

MRO

Male Run Tee
NPTF (all three ends)

SAE 140424
HPD Base # 012T



TUBE FITTING PART #	END SIZE 1-3 NPTF	N (in.)	N1 (in.)	Y (in.)	Dynamic Pressure (x 1,000 PSI) -S	-SS	-B
1/8 MRO	1/8 - 27	0.78	0.66	9/16	5.0	5.0	3.2
1/4 MRO	1/4 - 18	1.09	0.88	3/4	5.0	5.0	3.2
3/8 MRO	3/8 - 18	1.22	1.02	7/8	4.5	4.5	3.0
1/2 MRO	1/2 - 14	1.47	1.23	1 1/16	3.0	3.0	1.9
3/4 MRO	3/4 - 14	1.59	1.36	1 5/16	3.0	3.0	1.9
1 MRO	1 - 11 1/2	1.97	1.63	1 5/8	1.8	1.8	1.1
1 1/4 MRO	1 1/4 - 11 1/2	2.38	1.70	1 7/8	1.5	1.5	1.0
1 1/2 MRO	1 1/2 - 11 1/2	2.64	2.08	2 1/2	1.5	1.5	1.0

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