



NV - 60° "V" Thread

NPT - National Pipe Thread

Buttress - 5B75  
5B1  
8B75

TPI = Threads Per Inch

**TPI for ACME Threading:**  
Number of threads per inch followed by letter "P"

**TPI for Stub ACME Threading:**  
Number of threads per inch followed by letters "P" and the word STUB.

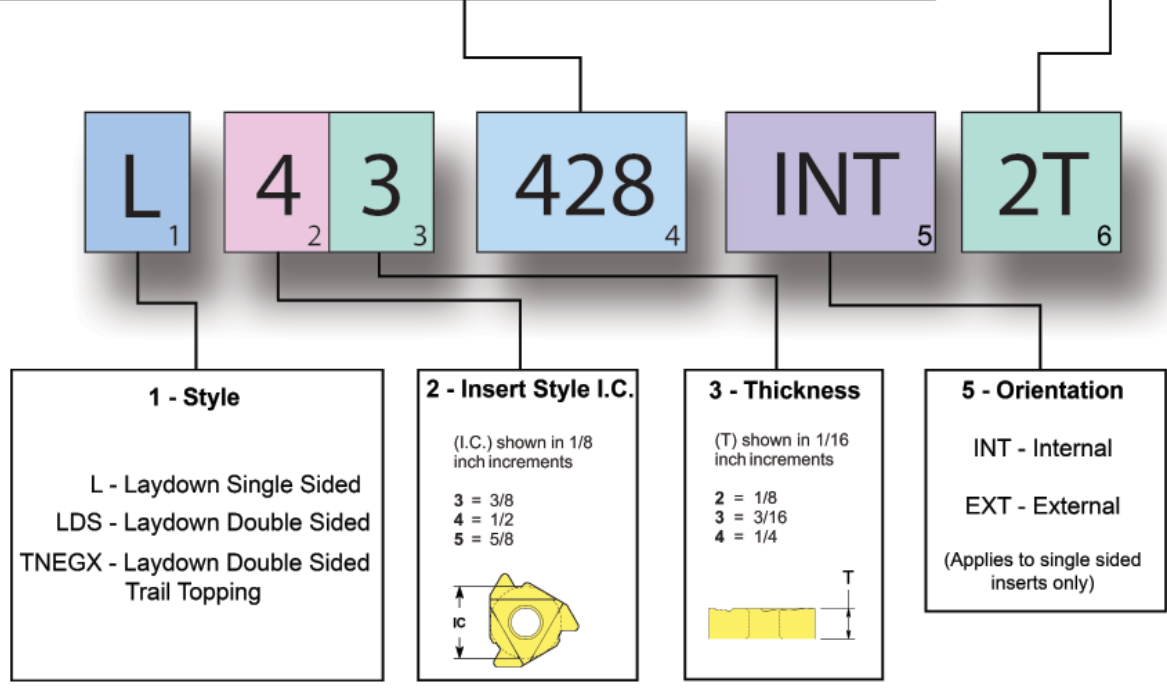
**4 - Thread Form**

API - 428 (3824)  
425 (2524)  
438 (3834)  
435 (2534)  
530 (2035)  
PAC  
8RD  
10RD  
V0.055

2T - 2 Tooth

3T - 3 Tooth

**6 - Multitooth**

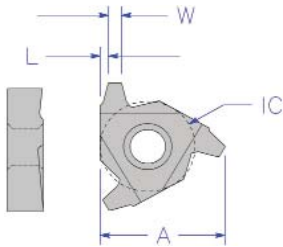


Laydown 7°

Threading Grade Descriptions			
Grade	Description	Uses	Stock
200	Uncoated tough submicron - wear resistant	Non-ferrous, stainless steel alloys, aluminum & composites at slower speeds	Item specific
210	TiN coated tough submicron - wear resistant	Non-ferrous, stainless steel alloys, aluminum & composites at medium speeds	<b>Standard</b>
221	AlTiN coated tough submicron chip resistant	Ductile iron, stainless steel, nickel-based & high-temp alloys at high speeds	Item specific
231	TiAlN coated tough submicron chip resistant	Non-ferrous, stainless steel, nickel-based & high-temp alloys at medium speeds	<b>Standard</b>
232	TiAlN coated tough submicron - chip, wear & heat resistant	Non-ferrous, stainless steel, nickel-based & high-temp alloys at medium speeds	Item specific
613	TiN coated premium substrate for threading	4140 and similar steels at slow to medium speeds	<b>Standard</b>
623	AlTiN coated premium substrate for threading	All steels at high speeds - maximum heat protection	Item specific
633	TiAlN coated premium substrate for threading	All steels at high speeds - medium heat protection	Item specific

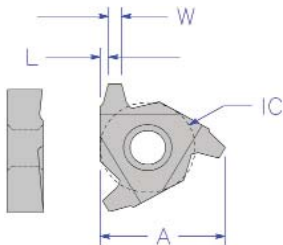


**LAYDOWN ACME THREADING**



DESCRIPTION	EDP	PITCH	WIDTH	IC	A	L
L32 16P ACME EXT	34602	16	.0206	.375	.491	.036
L32 14P ACME EXT	34622	14	.0239	.375	.491	.036
L32 12P ACME EXT	34642	12	.0283	.375	.491	.036
L32 10P ACME EXT	34662	10	.0319	.375	.491	.036
L32 8P ACME EXT	34682	8	.0411	.375	.491	.036
L43 6P ACME EXT	34712	6	.0566	.500	.657	.043
L43 5P ACME EXT	34732	5	.0689	.500	.657	.043
L54 4P ACME EXT	34762	4	.0875	.625	.833	.050
L32 16P ACME INT	34611	16	.0206	.375	.491	.036
L32 14P ACME INT	34631	14	.0239	.375	.491	.036
L32 12P ACME INT	34651	12	.0283	.375	.491	.036
L32 10P ACME INT	34671	10	.0319	.375	.491	.036
L32 8P ACME INT	34691	8	.0411	.375	.491	.036
L43 6P ACME INT	34721	6	.0566	.500	.657	.043
L43 5P ACME INT	34741	5	.0689	.500	.657	.043
L54 4P ACME INT	34771	4	.0875	.625	.833	.050

**LAYDOWN STUB ACME THREADING**

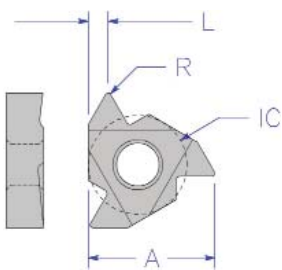


DESCRIPTION	EDP	PITCH	WIDTH	IC	A	L
L32 16P STUB EXT	34802	16	.0238	.375	.491	.036
L32 14P STUB EXT	34822	14	.0276	.375	.491	.036
L32 12P STUB EXT	34842	12	.0326	.375	.491	.036
L32 10P STUB EXT	34862	10	.0370	.375	.491	.036
L32 8P STUB EXT	34882	8	.0476	.375	.491	.036
L43 6P STUB EXT	34912	6	.0652	.500	.657	.043
L43 5P STUB EXT	34932	5	.0793	.500	.657	.043
L54 4P STUB EXT	34962	4	.1004	.625	.833	.050
L32 16P STUB INT	34811	16	.0238	.375	.491	.036
L32 14P STUB INT	34831	14	.0276	.375	.491	.036
L32 12P STUB INT	34851	12	.0326	.375	.491	.036
L32 10P STUB INT	34871	10	.0370	.375	.491	.036
L32 8P STUB INT	34891	8	.0476	.375	.491	.036
L43 6P STUB INT	34921	6	.0652	.500	.657	.043
L43 5P STUB INT	34941	5	.0793	.500	.657	.043
L54 4P STUB INT	34971	4	.1004	.625	.833	.050

Laydown holders and bars on pages 110-114.



**LAYDOWN 60° THREADING**

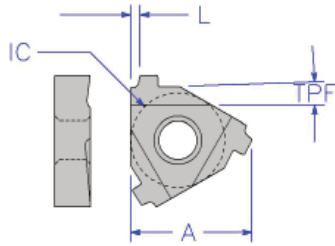


DESCRIPTION	EDP	PITCH	R	IC	A	L
L32 NV .003R EXT	36202	8-36	.003	.375	.492	.060
L43 NV .004R EXT	36232	8-32	.004	.500	.665	.075
L43 NV .006R EXT	36252	6-24	.006	.500	.665	.075
L43 NV .008R EXT	36272	18	.008	.500	.665	.075
L43 NV .010R EXT	36292	14	.010	.500	.665	.075
L43 NV .012R EXT	36312	12	.012	.500	.665	.075
L43 NV .014R EXT	36332	10	.014	.500	.665	.075
L53 NV .006R EXT	36362	4-24	.006	.625	.827	.100
L53 NV .020R EXT	36382	7	.020	.625	.827	.100
L53 NV .025R EXT	36402	6	.025	.625	.813	.115
L53 NV .038R EXT	36422	4	.038	.625	.813	.115
L32 NV .003R INT	36211	8-36	.003	.375	.492	.060
L43 NV .004R INT	36241	6-20	.004	.500	.665	.075
L43 NV .006R INT	36261	6-14	.006	.500	.665	.075
L43 NV .008R INT	36281	9	.008	.500	.665	.075
L43 NV .010R INT	36301	7	.010	.500	.665	.075
L43 NV .012R INT	36321	6	.012	.500	.665	.075
L43 NV .014R INT	36341	5	.014	.500	.665	.075
L53 NV .006R INT	36371	4-14	.006	.625	.827	.100
L53 NV .020R INT	36391	3-4	.020	.625	.827	.100
L53 NV .025R INT	36411	3-4	.025	.625	.813	.115
L53 NV .038R INT	36431	4	.038	.625	.813	.115

Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API BUTTRESS**

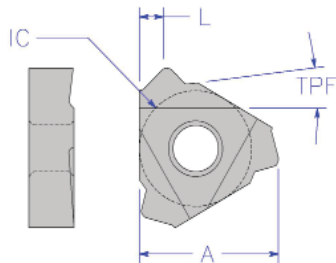


DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L32 8B75 EXT	36502	8	0.75	.375	.458	.069
L43 8B75 EXT	36532	8	0.75	.500	.649	.069
L43 5B75EXT	36552	5	0.75	.500	.645	.048
L43 5B1 EXT	36572	5	1	.500	.645	.048
L53 5B75 EXT	36602	5	0.75	.625	.821	.052
L53 5B1 EXT	36622	5	1	.625	.821	.052
L54 5B75 EXT	36652	5	0.75	.625	.821	.052
L54 5B1 EXT	36672	5	1	.625	.821	.052
L32 8B75 INT	36511	8	0.75	.375	.458	.069
L43 8B75 INT	36541	8	0.75	.500	.649	.069
L43 5B75INT	36561	5	0.75	.500	.645	.048
L43 5B1 INT	36581	5	1	.500	.645	.048
L53 5B75 INT	36611	5	0.75	.625	.821	.052
L53 5B1 INT	36631	5	1	.625	.821	.052
L54 5B75 INT	36661	5	0.75	.625	.821	.052
L54 5B1 INT	36681	5	1	.625	.821	.052

Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API HUGHES THREADING**

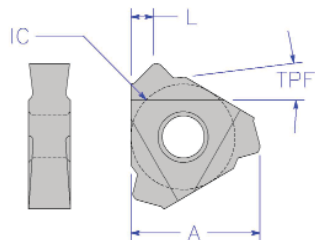


DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L53 H902 EXT	84692	3.5	2	.625	.775	.134
L53 H903 EXT	76422	3.5	3	.625	.775	.134
L53 H90S EXT	76412	3	1.25	.625	.765	.114
L54 H902 EXT	36772	3.5	2	.625	.775	.134
L54 H903 EXT	36792	3.5	3	.625	.775	.134
L54 H90S EXT	36812	3	1.25	.625	.765	.114
L53 H902 INT	78321	3.5	2	.625	.775	.134
L53 H903 INT	76421	3.5	3	.625	.775	.134
L53 H90S INT	76411	3	1.25	.625	.765	.114
L54 H902 INT	36781	3.5	2	.625	.775	.134
L54 H903 INT	36801	3.5	3	.625	.775	.134
L54 H90S INT	36821	3	1.25	.625	.765	.114

Laydown holders and bars on pages 110-114.

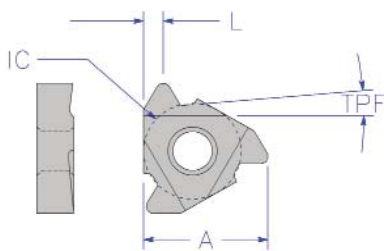


LAYDOWN API HUGHES THREADING	DESCRIPTION	EDP	PITCH	TPF	IC	A	L
	LDS 54 H902	51840	3.5	2	.625	.775	.134
	LDS 54 H903	47730	3.5	3	.625	.775	.134
	LDS 54 H90S	36870	3	1.25	.625	.765	.114



Laydown holders and bars on pages 110-114.

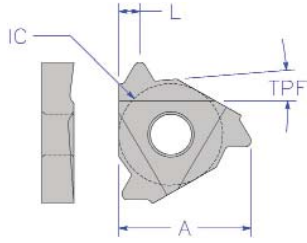
LAYDOWN API ROTARY THREADING	DESCRIPTION	EDP	PITCH	TPF	IC	A	L
	L43 425 EXT	83792	4	2	.500	.635	.110
	L43 428 EXT	83782	4	2	.500	.635	.110
	L43 435 EXT	83812	4	3	.500	.635	.110
	L43 438 EXT	83822	4	3	.500	.635	.110
	L43 530 EXT	83802	5	3	.500	.635	.100
	L43 PAC EXT	37002	4	1.5	.500	.624	.080
	L43 425 INT	83791	4	2	.500	.635	.110
	L43 428 INT	83781	4	2	.500	.635	.110
	L43 435 INT	83811	4	3	.500	.635	.110
	L43 438 INT	83821	4	3	.500	.635	.110
	L43 530 INT	83801	5	3	.500	.635	.100
	L43 PAC INT	37011	4	1.5	.500	.624	.080



Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API ROTARY THREADING**

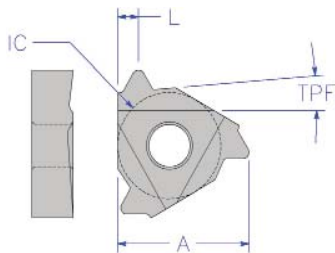


DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L53 425 EXT	70212	4	2	.625	.795	.125
L53 428 EXT	70192	4	2	.625	.795	.125
L53 435 EXT	70222	4	3	.625	.795	.125
L53 438 EXT	70202	4	3	.625	.795	.125
L53 530 EXT	70232	5	3	.625	.795	.125
L53 PAC EXT	37022	4	1.5	.625	.809	.085
L53 425 INT	70211	4	2	.625	.795	.125
L53 428 INT	70191	4	2	.625	.795	.125
L53 435 INT	70221	4	3	.625	.795	.125
L53 438 INT	70201	4	3	.625	.795	.125
L53 530 INT	70231	5	3	.625	.795	.125
L53 PAC INT	37031	4	1.5	.625	.809	.085

Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API ROTARY THREADING**



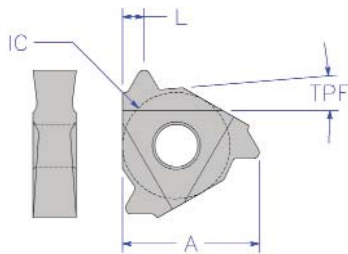
DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L54 425 EXT	70162	4	2	.625	.795	.125
L54 428 EXT	70142	4	2	.625	.795	.125
L54 435 EXT	70172	4	3	.625	.795	.125
L54 438 EXT	70152	4	3	.625	.795	.125
L54 530 EXT	70182	5	3	.625	.795	.125
L54 PAC EXT	37042	4	1.5	.625	.809	.085
L54 425 INT	70161	4	2	.625	.795	.125
L54 428 INT	70141	4	2	.625	.795	.125
L54 435 INT	70171	4	3	.625	.795	.125
L54 438 INT	70151	4	3	.625	.795	.125
L54 530 INT	70181	5	3	.625	.795	.125
L54 PAC INT	37051	4	1.5	.625	.809	.085

Laydown holders and bars on pages 110-114.



**LAYDOWN API ROTARY THREADING**

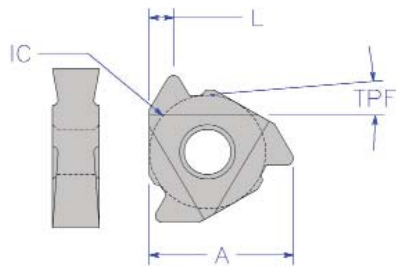
DESCRIPTION	EDP	PITCH	TPF	IC	A	L
LDS 54 425	36120	4	2	.625	.792	.136
LDS 54 428	36100	4	2	.625	.792	.136
LDS 54 435	36130	4	3	.625	.792	.136
LDS 54 438	36110	4	3	.625	.792	.136
LDS 54 530	36140	5	3	.625	.792	.136
LDS 54 PAC	55250	4	1.5	.625	.809	.085



Laydown holders and bars on pages 110-114.

**LAYDOWN API ROTARY THREADING**

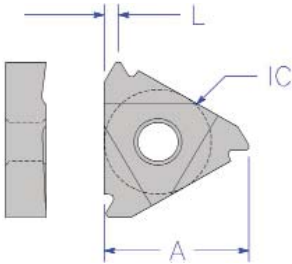
DESCRIPTION	EDP	PITCH	TPF	IC	A	L
TNEGX 54 2524	54390	4	2	.625	.775	.130
TNEGX 54 3824	54370	4	2	.625	.775	.130
TNEGX 54 2534	54400	4	3	.625	.775	.130
TNEGX 54 3834	54380	4	3	.625	.775	.130
TNEGX 54 2035	54410	5	3	.625	.775	.130



Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API ROUND THREADING**

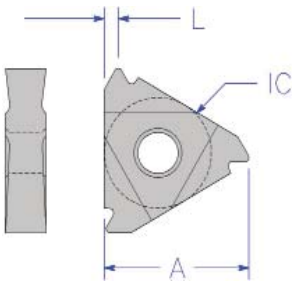


DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L32 8RD EXT	55172	8	0.75	.375	.487	.060
L32 10RD EXT	55352	10	0.75	.375	.487	.060
L43 8RD EXT	42902	8	0.75	.500	.676	.065
L43 10RD EXT	73822	10	0.75	.500	.676	.065
L54 8RD EXT	36902	8	0.75	.625	.843	.060
L54 10RD EXT	36922	10	0.75	.625	.843	.060
L32 8RD INT	55171	8	0.75	.375	.487	.060
L32 10RD INT	55351	10	0.75	.375	.487	.060
L43 8RD INT	42901	8	0.75	.500	.676	.065
L43 10RD INT	73821	10	0.75	.500	.676	.065
L54 8RD INT	36911	8	0.75	.625	.843	.060
L54 10RD INT	36931	10	0.75	.625	.843	.060

Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN API ROUND THREADING**



DESCRIPTION	EDP	PITCH	TPF	IC	A	L
LDS 43 8RD	36950	8	0.75	.500	.676	.065
LDS 43 10RD	36960	10	0.75	.500	.676	.065
LDS 54 8RD	36970	8	0.75	.625	.843	.060
LDS 54 10RD	36980	10	0.75	.625	.843	.060

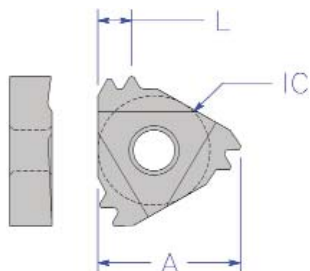
Laydown holders and bars on pages 110-114.





**LAYDOWN MULTI-TOOTH API ROUND THREADING**

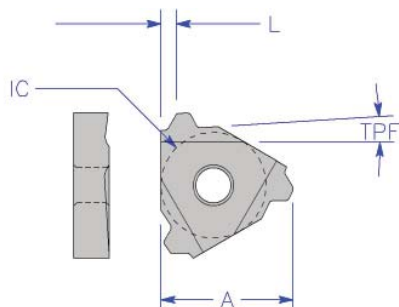
DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L54 2T 8RD EXT	37102	8	0.75	.625	.816	.170
L54 3T 8RD EXT	37122	8	0.75	.625	.740	.300
L54 2T 10RD EXT	37142	10	0.75	.625	.836	.135
L54 3T 10RD EXT	37162	10	0.75	.625	.740	.300
L54 2T 8RD INT	37111	8	0.75	.625	.816	.170
L54 3T 8RD INT	37131	8	0.75	.625	.740	.300
L54 2T 10RD INT	37151	10	0.75	.625	.836	.135
L54 3T 10RD INT	37171	10	0.75	.625	.740	.300



Laydown holders and bars on pages 110-114.

**LAYDOWN V055 THREADING**

DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L32 V0.055 EXT	34542	6	1.5	.375	.472	.055
L43 V0.055 EXT	34562	6	1.5	.500	.660	.055
L32 V0.055 INT	34551	6	1.5	.375	.472	.055
L43 V0.055 INT	34571	6	1.5	.500	.660	.055

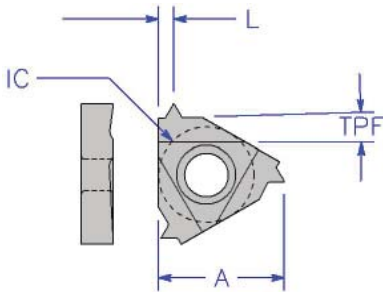


Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN NPT THREADING**

DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L32 18NPT EXT	37202	18	0.75	.375	.523	.031
L32 14NPT EXT	37222	14	0.75	.375	.494	.060
L32 11.5NPT EXT	37242	11.5	0.75	.375	.494	.060
L32 8NPT EXT	37262	8	0.75	.375	.494	.060
L32 18NPT INT	37211	18	0.75	.375	.523	.031
L32 14NPT INT	37231	14	0.75	.375	.494	.060
L32 11.5NPT INT	37251	11.5	0.75	.375	.494	.060
L32 8NPT INT	37271	8	0.75	.375	.494	.060

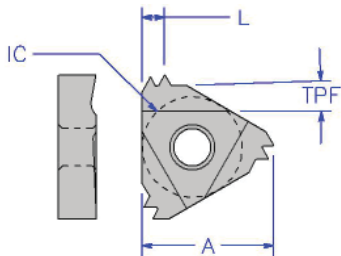


Laydown holders and bars on pages 110-114.

Laydown 7°

**LAYDOWN MULTI-TOOTH NPT THREADING**

DESCRIPTION	EDP	PITCH	TPF	IC	A	L
L43 18NPT 2T EXT	37302	18	0.75	.500	.681	.080
L43 14NPT 2T EXT	37322	14	0.75	.500	.656	.112
L54 11.5NPT 2T EXT	37402	11.5	0.75	.625	.827	.139
L54 11.5NPT 3T EXT	37422	11.5	0.75	.625	.781	.222
L54 8NPT 2T EXT	37442	8	0.75	.625	.788	.189
L43 18NPT 2T INT	37311	18	0.75	.500	.681	.080
L43 14NPT 2T INT	37331	14	0.75	.500	.656	.112
L54 11.5NPT 2T INT	37411	11.5	0.75	.625	.827	.139
L54 11.5NPT 3T INT	37431	11.5	0.75	.625	.781	.222
L54 8NPT 2T INT	37451	8	0.75	.625	.788	.189



Laydown holders and bars on pages 110-114.