

# NFPA 1963

## Standard for Fire Hose Connections

### 1998 Edition



National Fire Protection Association, 1 Batterymarch Park, PO Box 9101, Quincy, MA 02269-9101  
An International Codes and Standards Organization

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## NFPA 1963

### Standard for Fire Hose Connections

#### 1998 Edition

This edition of NFPA 1963, *Standard for Fire Hose Connections*, was prepared by the Technical Committee on Fire Hose and acted on by the National Fire Protection Association, Inc. at its Annual Meeting held May 18-21, 1998, in Cincinnati, OH. It was issued by the Standards Council on July 16, 1998, with an effective date of August 5, 1998, and supersedes all previous editions.

Changes other than editorial are indicated by a vertical rule in the margin of the pages on which they appear. These lines are included as an aid to the user in identifying changes from the previous edition.

This edition of NFPA 1963 was approved as an American National Standard on August 6, 1998.

#### Origin and Development of NFPA 1963

The development of a standard for screw threads and gaskets for fire hose connections began nearly a century ago. Specifications for hose couplings were drawn up by the NFPA as early as 1898. An NFPA committee appointed in 1905 established a national standard thread for 2 $\frac{1}{2}$ -in. and larger hose connections. Work on smaller hose threads was started in 1916, and the standard was adopted in 1922. The standard for suction hose coupling threads was adopted in 1955. The present standard covers the 10 standard sizes of threaded connections from  $\frac{3}{4}$  in. (19 mm) to 6 in. (150 mm).

Editions published in 1956, 1967, and 1968 incorporated changes adopted by the NFPA. See Appendix B for a detailed history of fire hose coupling thread standardization in the United States.

The standard was extensively revised to bring the document into conformance with NFPA's *Manual of Style* in 1974. In 1979, the committee undertook a partial revision of the standard and included metric conversion figures where applicable. At this time the number designation of this document was changed from NFPA 194 to NFPA 1963. The document was editorially revised for the 1985 edition.

The 1993 edition of NFPA 1963 was a total reorganization and expansion of the standard. The material on screw threads was consolidated into a single chapter. A new chapter was added to cover general requirements for couplings and adapters. Another new chapter was added to cover nonthreaded connections in the 4-in. and 5-in. sizes. New material was added to the chapter on gaskets to cover the gaskets used with nonthreaded connections. Sections dealing with the threads on fire department pump discharges and intakes, portable pumps, and sprinkler and standpipe systems were deleted as these requirements are covered in other NFPA standards. The title of the document was changed from *Standard for Screw Threads and Gaskets for Fire Hose Connections* to *Standard for Fire Hose Connections* to reflect the broader scope of the document.

In this edition, the requirements for locks on caps used with nonthreaded couplings have been removed, and some editorial revisions have been made to the document.

### Technical Committee on Fire Hose

**John W. Stacey**, Bellevue Fire Dept., NE [E]  
Rep. Int'l Assn. of Fire Chiefs

**Frank T. Blackburn**, PWSS Co. Ltd, CA [SE]

**Peter C. Bol**, Snap-Tite Hose, Inc., PA [M]

**Robert Ely**, San Diego, CA [SE]

**Thomas G. Farruggia**, Illinois Fire Extinguisher Co. Inc., IL [IM]

Rep. Nat'l Assn. of Fire Equipment Distributors Inc.

**Philip W. Johnson**, Factory Mutual Research Corp., RI [I]

**Paul Robert Kaveler**, Union Electric Co., MO [U]

Rep. Edison Electric Inst.

**Gregory Kozey**, Kochek Co., Inc., CT [M]

**Allen Leach**, Jaffrey Fire Protection Co., NH [M]

**Larry Linton**, Washington Twp Volunteer Fire Dept., IN [L]

**William E. Patterson**, Angus Fire — AFAC, NC [M]

Rep. Fire Equipment Mfrs., Assoc.

**William J. Patterson**, Federal Emergency Mgmt. Agency, CA [SE]

**David J. Pritchard**, Apex, NC [SE]

**Mark Saner**, Akron Brass, OH [M]

**Sherman Stark**, North American Fire Hose, CO [M]

**Ralph D. Taylor**, USDA Forest Service, CA [U]

**Leon M. Walker**, Underwriters Laboratories Inc., IL [RT]

**Halbert C. Weill, Jr.**, Hazards, Inc., NC [SE]

### Alternate

**George E. Laverick**, Underwriters Laboratories Inc., IL [RT]

(Alt. to L. M. Walker)

**David A. Lord**, Niedner Ltd., PQ, Canada [M]  
(Alt. to W. E. Patterson)

**Carl E. Peterson**, NFPA Staff Liaison

*This list represents the membership at the time the Committee was balloted on the text of this edition. Since that time, changes in the membership may have occurred. A key to classifications is found at the back of this document.*

**NOTE:** Membership on a committee shall not in and of itself constitute an endorsement of the Association or any document developed by the committee on which the member serves.

**Committee Scope:** This Committee shall have primary responsibility for documents on the size and design of fire hose connections, and the performance, maintenance, and selection of all types of fire hose, couplings, nozzles, and accessory equipment.

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**Standard for**  
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**NOTICE:** An asterisk (\*) following the number or letter designating a paragraph indicates that explanatory material on the paragraph can be found in Appendix A.

Information on referenced publications can be found in Chapter 7 and Appendix C.

## Chapter 1 Administration

**1-1\* Scope.** This standard gives the performance requirements for new fire hose couplings and adapters with nominal sizes from  $\frac{3}{4}$  in. (19 mm) through 6 in. (150 mm) and the specifications for the mating surfaces.

**1-2 Purpose.** The purpose of this standard is to provide a uniform standard for safe couplings and adapters for the users of fire hose connections.

### 1-3 Definitions.

**Adapter.** Any device that allows fire hose couplings to be safely interconnected with couplings of different sizes, threads, or mating surfaces, or that allows fire hose couplings to be safely connected to other appliances.

**Approved.\*** Acceptable to the authority having jurisdiction.

**Authority Having Jurisdiction.\*** The organization, office, or individual responsible for approving equipment, an installation, or a procedure.

**Blunt Start.** The removal of the incomplete thread at the end of the thread. This is a feature of threaded parts that are repeatedly assembled by hand. Also known as the "Higbee cut."

**Bowl Gasket.** See Tail Gasket.

**Coupling Assembly.** A complete coupling including its gaskets and the expansion rings or collar pieces used in attaching the coupling to the hose.

**Couplings.** One set or pair of connection devices attached to a fire hose that allow the hose to be interconnected to additional lengths of hose or adapters and other fire-fighting appliances.

**Face Gasket.** The water pressure seal at the mating surfaces of nonthreaded couplings or adapters.

**Hard Suction Hose.** A hose used for drafting water from static supplies (lakes, rivers, wells, and so forth). It can also be used for supplying pumps on fire apparatus from hydrants if designed for that purpose. The hose contains a semirigid or rigid reinforcement designed to prevent collapse of the hose under vacuum.

**Large Stream Device.** Any device that discharges water at a flow rate greater than 400 gpm (1514 L/min).

**NH.** An American National Fire Hose Connection Screw Thread. (See Section 3-2.)

**Nonthreaded Coupling or Adapter.** A coupling or adapter in which the mating is achieved with locks or cams but without the use of screw threads.

**Primary Inlet.** The inlet where an appliance connects to a hose.

**Screw Thread Coupling or Adapter.** A coupling or adapter in which the mating is achieved with the use of threads.

**Shall.** Indicates a mandatory requirement.

**Should.** Indicates a recommendation or that which is advised but not required.

**Spray Nozzle.** A nozzle with an adjustable pattern and with a control device that shuts off the flow.

**Straight Tip Nozzle.** A smooth-bore nozzle for producing a solid stream.

**Tail Gasket.** A gasket in the bowl of a coupling used to provide a watertight seal between the coupling and the hose in an expansion ring-type coupling.

**Thread Gasket.** A gasket used in a female threaded connection to provide a watertight seal between the male and female threaded connections.

**1-4 General Requirements.** The requirements of this standard shall apply to the following devices in the sizes defined in Section 1-1.

- (a) Fire hose couplings
- (b) Booster hose couplings
- (c) Hard suction hose couplings
- (d) Pump intake connections on fire apparatus
- (e) Pump discharge connections on fire apparatus
- (f) Sprinkler connections
- (g) Standpipe connections
- (h) Hose connections on fire hydrants
- (i) Adapters
- (j) Reducers
- (k) Caps
- (l) Plugs
- (m) Connections on all other hose fittings and appliances that attach to fire pumps, hose, or hydrants

## Chapter 2 General Coupling and Adapter Requirements

**2-1\* Workmanship.** The coupling assembly or adapter shall be made and finished in a workmanship-like manner throughout. All edges shall be chamfered and free from burrs. Hose bowl or tailpiece lips shall be rounded to prevent damage to the hose.

**2-2 Materials.** Materials used shall be free of defects that would adversely affect the performance or maintenance of individual components or of the overall assembly.

**2-3 Minimum Waterway.** The design of the shank-type and nonthreaded expansion ring coupling shall be such that the coupling shall not restrict the waterway by more than  $\frac{1}{4}$  in. (6.4 mm) on couplings of nominal size  $2\frac{1}{2}$  in. (65 mm) or less and not more than  $\frac{1}{2}$  in. (12.7 mm) on couplings of nominal size greater than  $2\frac{1}{2}$  in. (65 mm). Gaskets shall not protrude into the waterway.

**2-3.1** The waterway of size-increasing-style couplings shall be no smaller than the nominal size of the hose to which it is attached.

*Exception: Shank-type couplings.*

**2-3.2** The waterway of size-reducing-style couplings shall be no smaller than the nominal size of the attachment face.

*Exception: Shank-type couplings.*

**2-4 Gasket Groove.** All sizes of internal NH threaded couplings, connections, or adapters shall have a standard gasket groove diameter as shown in Table 3-4.2, column K. [See also Figure 3-3.2, dimension K.]

**2-5 Testing.** Tests required by this standard shall be conducted by the manufacturer or by an approved testing facility designated by the manufacturer. All tests shall be conducted on standard commercially available product. Any test that requires the use of hose shall use hose with the highest service test pressure commercially available to which the coupling can be attached.

## 2-6 Internal Strength.

**2-6.1** The coupling or adapter shall be capable of withstanding a hydrostatic pressure equal to the service test pressure without leakage, two times service test pressure with no leakage more severe than 12 drops per minute ( $1\frac{1}{2}$  ml per minute), and three times the service test pressure plus 100 psi (690 kPa) without separation. It shall be tested in accordance with 2-6.2 to prove compliance.

**2-6.2** The coupling or adapter shall be plugged and adapted on one end to accept a pump connection from a hydrostatic test table. The other end shall be plugged or adapted to accept a petcock to remove air. The coupling or adapter shall be filled with water until all air has been exhausted and the petcock closed. Pressure shall be applied until the test pressure is reached. The test pressure shall be held for at least 15 seconds but not more than 60 seconds.

## 2-7 Tensile Strength.

**2-7.1** Couplings shall have a tensile strength of at least 1200 lb per in. (210 N/mm) of diameter. They shall be tested in accordance with 2-7.2 to prove compliance.

**2-7.2** A pair of couplings shall be attached to a section of hose. The couplings shall be connected together and the hose installed in a tension testing machine such that the tension will be on the couplings. A tensile load shall be applied at a rate of not more than 2 in. (51 mm) per minute up to 1200 lb per in. (210 N/mm) of nominal hose diameter.

After the tensile strength test, the couplings shall be subjected to a test pressure equal to the service test pressure of the hose to which they are attached. Any leakage or deformation shall constitute failure of this test.

## 2-8 Connect/Disconnect Capability.

**2-8.1** Couplings shall be capable of being connected and disconnected at least 3000 times without leakage or failure. They shall be tested in accordance with 2-8.2 to prove compliance.

**2-8.2** Tests shall be conducted on standard commercial product without lubrication. Hose couplings shall be completely connected and disconnected to each other at least 3000 times. At the completion of this portion of the test, the couplings shall be attached to hose such that tested couplings can be

connected together. The tested couplings when connected together shall withstand the service test pressure of the hose without leakage or failure.

## 2-9 Rough Usage.

**2-9.1** Couplings shall be capable of being dropped up to 6 ft (1.8 m) without deformation or damage that impairs operation. They shall be tested in accordance with 2-9.2 to prove compliance.

**2-9.2** Couplings shall be installed on approximately 10-ft (3-m) lengths of fire hose. The couplings shall be coupled together, forming a loop in the hose. The coupling assembly shall then be dropped onto a concrete surface from a height of 6 ft (1.8 m) so as to land as squarely as possible on the swivel ring. This shall be repeated three times. The couplings shall operate freely and shall show no signs of deformation when inspected inside and outside. Samples showing distortion or binding of the swivel mechanism shall be judged acceptable if the mechanism can be corrected to turn freely and evenly when straightened by the use of a hammer. Samples developing cracks or broken sections either before or after attempts to straighten damaged portions shall be deemed as having failed the test. The coupling/hose assembly shall withstand the service test pressure of the hose without leakage or failure.

## 2-10 Coupling Retention.

**2-10.1** Couplings shall remain on the hose without movement up to the rated burst pressure of the hose. They shall be tested in accordance with 2-10.2 to prove compliance.

**2-10.2** The couplings shall be attached to a 3-ft (1-m) length of hose. The hose and coupling as an assembly shall be pressurized to the service pressure of the hose for 1 minute, and then the pressure shall be released. The position of the coupling with relation to the hose shall be marked. The pressure in the hose/coupling assembly shall then be raised at a rate of 300 psi to 1000 psi (2068 kPa to 6895 kPa) per minute until the rated burst pressure of the hose is reached. The pressure shall be held for a minimum of 15 seconds but not longer than 60 seconds. The hose shall show no signs of movement from the coupling.

## 2-11 Vacuum Tightness.

**2-11.1** When couplings are used on hard suction hose, they shall be capable of holding a vacuum of 22 in. Hg (74.2 kPa) for 5 minutes. They shall be tested in accordance with 2-11.2 to prove compliance.

**2-11.2** The coupling shall be attached to a suitable section of hard suction hose. A blank cap shall be attached to the coupling on one end, and a vacuum pump shall be attached to the other end. A vacuum of 22 in. Hg (74.2 kPa) shall be developed within the assembly, and the assembly shall hold the vacuum for 5 minutes without any loss of vacuum.

## 2-12 Corrosion Resistance.

**2-12.1** Couplings having parts other than high-strength yellow brass No. 8A as defined in ASTM B 30, *Standard Specification for Copper-Brass Alloys in Ingot Form*, or ASTM B 584, *Standard Specification for Copper Alloy Sand Castings for General Applications*, shall be capable of being coupled and uncoupled using accepted standard practices and shall not show any evidence of galvanic corrosion between dissimilar metals after testing in accordance with 2-12.2.



**2-12.2** Coupling assemblies including expansion rings and gaskets shall be supported vertically in a fog chamber and exposed to salt spray (fog) as specified by ASTM B 117, *Standard Practice for Operating Salt Spray (Fog) Apparatus*, for a period of 120 hours.

**2-13 Nonmetallic Materials.** Any nonmetallic material used in couplings except for the gaskets shall be certified by the manufacturer of the nonmetallic material as fit for the service intended.

#### 2-14 High-Temperature Performance.

**2-14.1** Temperatures up to 275°F (135°C) shall not affect the ease with which a coupling assembly is coupled or uncoupled. Couplings shall be tested in accordance with 2-14.2 to prove compliance.

**2-14.2** Dry couplings with gaskets installed shall be conditioned in an oven at 275°F (135°C) for 4 hours. Immediately upon removal it shall be possible to connect and disconnect the couplings within the original torque range.

#### 2-15 Low-Temperature Performance.

**2-15.1** Temperatures down to -25°F ± 2°F (-32°C ± 1°C) shall not affect the performance of the coupling assembly. Couplings shall be tested in accordance with 2-15.2 to prove compliance.

**2-15.2** With the gasket(s) installed, a coupling assembly shall be subjected to an environment of 0°F ± 1°F (-18°C ± 1°C) for a period of 24 hours and subsequently to an environment of -25°F ± 2°F (-32°C ± 1°C) for a period of 2 hours. Following this exposure, the coupling shall be dropped from a height of 10 ft (3 m) onto its longitudinal axis. It shall then be possible to couple and uncouple the coupling assembly by the application of a torque no greater than required before the test.

**2-16 Gasket Performance.** The gasket material used with any coupling or adapter shall meet the test requirements of 2-16.1 through 2-16.3.

**2-16.1 Low Temperature Test.** Gaskets shall be subjected to an environment of 0°F ± 1°F (-18°C ± 1°C) for a period of 24 hours and subsequently to an environment of -25°F ± 2°F (-32°C ± 1°C) for a period of 2 hours. Immediately upon removal from the test chamber, the gasket shall not crack when squeezed from any two opposite points into a figure 8 configuration.

**2-16.2 Accelerated Aging Test.** Samples of the gasket material shall be prepared in accordance with the procedures described in ASTM D 3183, *Standard Practice for Rubber — Preparation of Pieces for Test Purposes from Products*. The samples of the gaskets shall then be subjected to oven aging at 212°F ± 3°F (100°C ± 2°C) for 70 hours in accordance with ASTM D 573, *Standard Test Method for Rubber Deterioration in an Air Oven*. The samples shall then be tested for tensile strength and ultimate elongation, and the tensile strength shall be not less than 80 percent, and the ultimate elongation shall be not less than 50 percent of the corresponding properties of samples that have not been so treated.

**2-16.3 Compression Set Test.** A sample of gasket material shall be compressed as defined in ASTM D 395, *Standard Test Methods for Rubber Property — Compression Set (Method B)*, and subjected to heat treatment at 158°F ± 1°F (70°C ± 1°C) for a period of 24 hours. The compression set of the sample of gas-

ket material so tested shall not exceed 15 percent of the original thickness.

## Chapter 3 Screw Threads for Couplings and Adapters

### 3-1 Basic Form of Thread.

**3-1.1** Basic thread form as specified in Figure 3-3.1 shall have an included angle of 60 degrees and truncated top and bottom.

**3-1.2** The basic angle of the thread between the sides of the thread measured in an axial plane shall be 60 degrees. The line bisecting this 60-degree angle shall be perpendicular to the axis of the screw thread.

**3-1.3** The flat at the root and crest of the basic thread as specified in Figure 3-3.1 shall be  $\frac{1}{8}$  times the pitch or 0.125 times the pitch ( $p$ ).

**3-1.4** The height of the basic thread shall be

$$h = 0.649519 \times p$$

or

$$h = \frac{0.649519}{n}$$

where:

$p$  = pitch in inches

or

$$p = \frac{1}{n}$$

$n$  = number of threads per inch

$h$  = basic thread height in inches

### 3-1.5 Blunt Start.

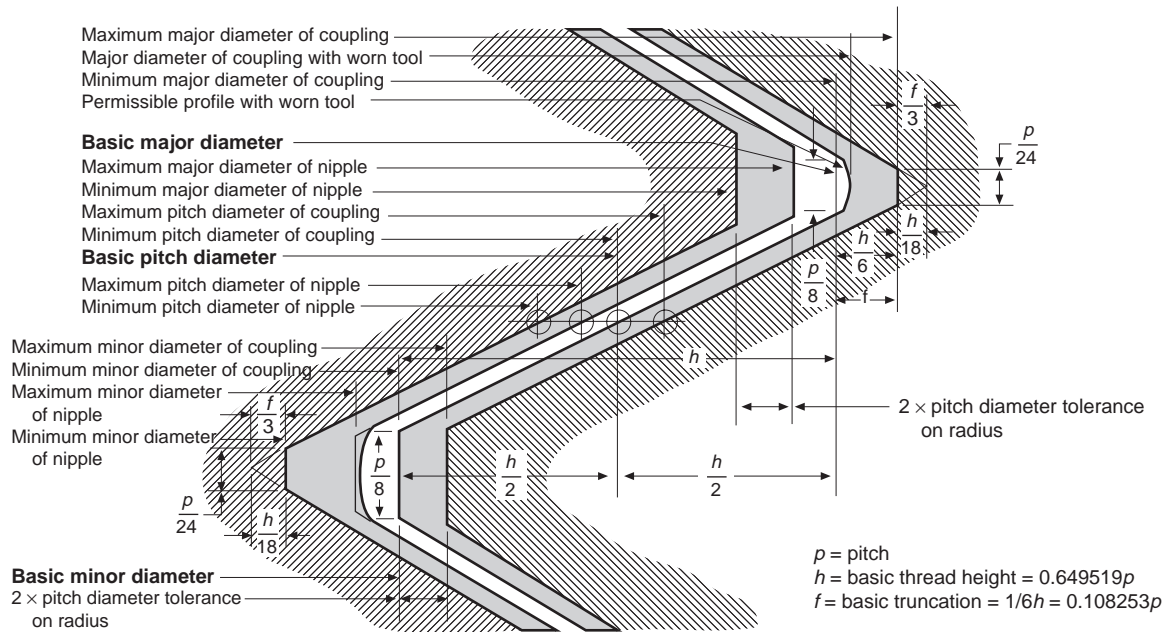
**3-1.5.1** The outer ends of all external and internal threads shall be terminated by the blunt start or Higbee cut, as shown in Figure 3-3.2, on full thread to avoid crossing and mutilation of thread.

**3-1.5.2** The minimum length of the blunt start shall be not less than the radius formed by a cutter with a radius not less than the height of the thread.

**3-1.5.3** The maximum length of the blunt start shall be not greater than 10 degrees of arc.

**3-2\* Thread Series Designation.** Fire hose connection threads that meet the requirements of this chapter shall be identified as "American National Fire Hose Connection Screw Threads" (abbreviated throughout the standard with the thread symbol NH). They shall be designated by specifying in sequence the nominal size of the connection, the number of threads per inch, and the thread symbol "NH" as shown in the following example:

0.75-8 NH	3.5-6 NH
1-8 NH	4-4 NH
1.5-9 NH	4.5-4 NH
2.5-7.5 NH	5-4 NH
3-6 NH	6-4 NH



**Figure 3-3.1 Form of thread of American National Fire Hose Connection Screw Thread (NH).** The left portion shows the external thread (nipple), and the right portion shows the internal thread (coupling). (See Table 3-4.1 for dimensions.)

### 3-3 Dimensions of American National Fire Hose Connection Screw Threads (NH).

**3-3.1** The basic major diameter, basic pitch diameter, and basic minor diameter and tolerances shall be as specified in Figure 3-3.1.

**3-3.2** Nominal dimensions shall be as specified in Figure 3-3.2.

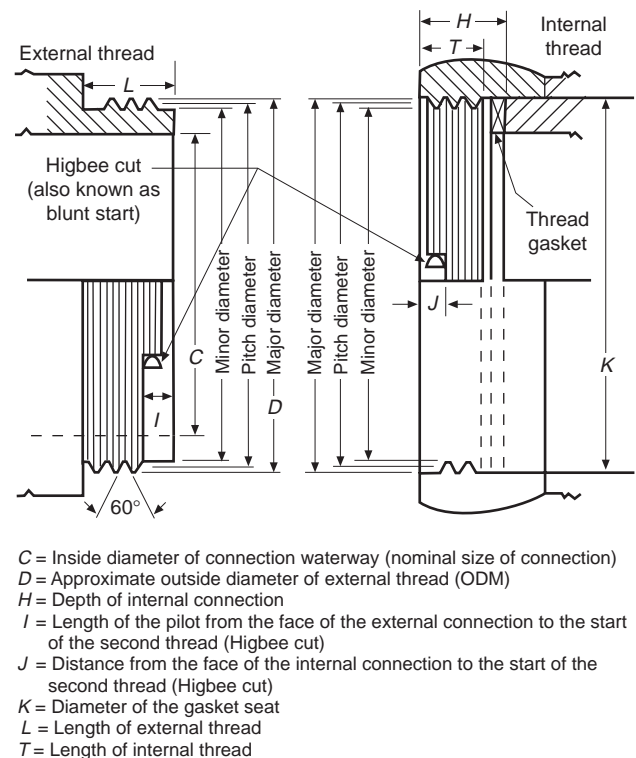
### 3-4 Thread Dimensions.

**3-4.1** The basic dimensions for the threads shall be as specified in Table 3-4.1.

**3-4.2** The nominal dimensions for the threads shall be as specified in Table 3-4.2.

**3-4.3** The limiting dimensions for external threads (nipples) shall be as specified in Table 3-4.3

**3-4.4** The limiting dimensions for internal threads (couplings) shall be as specified in Table 3-4.4.



**Figure 3-3.2 Nominal dimensions of connections.** (See Table 3-4.2 for dimensions.)

Table 3-4.1 Basic Dimensions of NH Threads (See Figure 3-3.1.)

Nominal Size of Connection	Threads <sup>1</sup> per Inch (tpi)	Thread <sup>1</sup> Designation (NH)	Pitch ( <i>p</i> )	Basic Thread Height ( <i>h</i> )	External Thread Dimensions (Nipple)				Minimum Internal Thread Dimensions		
					Allowance	Maximum Major Diameter, <i>D</i> —Col. 6	Maximum Pitch Diameter, Col. 7— <i>h</i>	Maximum Minor Diameter, Col. 7—2 <i>h</i>	Minimum Minor Diameter, <i>D</i> —2 <i>h</i>	Basic Pitch Diameter, <i>D</i> — <i>h</i>	Basic Major Diameter, <i>D</i>
1	2	3	4	5	6	7	8	9	10	11	12
$\frac{3}{4}$	8	0.75-8 NH	0.12500	0.08119	0.0120	1.3750	1.2938	1.2126	1.2246	1.3058	1.3870
1	8	1-8 NH	0.12500	0.08119	0.0120	1.3750	1.2938	1.2126	1.2246	1.3058	1.3870
$1\frac{1}{2}$	9	1.5-9 NH	0.11111	0.07217	0.0120	1.9900	1.9178	1.8457	1.8577	1.9298	2.0020
$2\frac{1}{2}$	7.5	2.5-7.5 NH	0.13333	0.08660	0.0150	3.0686	2.9820	2.8954	2.9104	2.9970	3.0836
3	6	3-6 NH	0.16667	0.10825	0.0150	3.6239	3.5156	3.4073	3.4223	3.5306	3.6389
$3\frac{1}{2}$	6	3.5-6 NH	0.16667	0.10825	0.0200	4.2439	4.1356	4.0273	4.0473	4.1556	4.2639
4	4	4-4 NH	0.25000	0.16238	0.0250	5.0109	4.8485	4.6861	4.7111	4.8735	5.0359
$4\frac{1}{2}$	4	4.5-4 NH	0.25000	0.16238	0.0250	5.7609	5.5985	5.4361	5.4611	5.6235	5.7859
5	4	5-4 NH	0.25000	0.16238	0.0250	6.2600	6.0976	5.9352	5.9602	6.1226	6.2850
6	4	6-4 NH	0.25000	0.16238	0.0250	7.0250	6.8626	6.7002	6.7252	6.8876	7.0500

<sup>1</sup>All other values are given in inches.

Table 3-4.2 Nominal Dimensions of NH Threads (See Figure 3-3.2.)

Nominal Size of Connection Waterway, <i>C</i>	Threads <sup>1</sup> per Inch (tpi), <i>N</i>	Thread <sup>1</sup> Designation (NH)	Approximate Outside Diameter of External Thread, <i>D</i> <sup>2</sup>	Length of External Thread (Min), <i>L</i>	Length of Pilot to Start of Second Thread (External), <i>I</i>	Depth of Internal Connector, <i>H</i>	Diameter of Gasket Seat in Coupling, <i>K</i>	Length of Internal Thread, <i>T</i>	Length of Pilot to Start of Second Thread (Internal), <i>J</i>
$\frac{3}{4}$	8	0.75-8 NH	$\frac{1^3}{8}$	$\frac{5}{8}$	$\frac{5}{32}$	$\frac{19}{32}$	$\frac{17}{16}$	$\frac{13}{32}$	$\frac{5}{32}$
1	8	1-8 NH	$\frac{1^3}{8}$	$\frac{5}{8}$	$\frac{5}{32}$	$\frac{19}{32}$	$\frac{17}{16}$	$\frac{13}{32}$	$\frac{5}{32}$
$1\frac{1}{2}$	9	1.5-9 NH	2	$\frac{5}{8}$	$\frac{5}{32}$	$\frac{19}{32}$	$\frac{2^1}{16}$	$\frac{13}{32}$	$\frac{5}{32}$
$2\frac{1}{2}$	$7\frac{1}{2}$	2.5-7.5 NH	$\frac{3^1}{16}$	1	$\frac{1}{4}$	$\frac{15}{16}$	$\frac{3^3}{16}$	$\frac{11}{16}$	$\frac{3}{16}$
3	6	3-6 NH	$\frac{3^5}{8}$	$\frac{1^1}{8}$	$\frac{5}{16}$	$\frac{1^1}{16}$	$\frac{3^3}{4}$	$\frac{3}{4}$	$\frac{1}{4}$
$3\frac{1}{2}$	6	3.5-6 NH	$\frac{4^1}{4}$	$\frac{1^1}{8}$	$\frac{5}{16}$	$\frac{1^1}{16}$	$\frac{4^3}{8}$	$\frac{3}{4}$	$\frac{1}{4}$
4	4	4-4 NH	5	$\frac{1^1}{4}$	$\frac{7}{16}$	$\frac{1^3}{16}$	$\frac{5^1}{8}$	$\frac{7}{8}$	$\frac{3}{8}$
$4\frac{1}{2}$	4	4.5-4 NH	$\frac{5^3}{4}$	$\frac{1^1}{4}$	$\frac{7}{16}$	$\frac{1^3}{16}$	$\frac{5^7}{8}$	$\frac{7}{8}$	$\frac{3}{8}$
5	4	5-4 NH	$\frac{6^1}{4}$	$\frac{1^3}{8}$	$\frac{7}{16}$	$\frac{1^5}{16}$	$\frac{6^3}{8}$	1	$\frac{3}{8}$
6	4	6-4 NH	$\frac{7^1}{32}$	$\frac{1^3}{8}$	$\frac{7}{16}$	$\frac{1^5}{16}$	$\frac{7^1}{8}$	1	$\frac{3}{8}$

Note: Approximate dimensions are for field identification purposes only. Exact basic manufacturing dimensions and tolerances are given in subsequent tables

<sup>1</sup>All other values are given in inches.

**Table 3-4.3 Limits of Size and Tolerances of NH External Threads (Nipples)**

Nominal Size of Connection	Threads <sup>1</sup> per Inch (tpi)	Thread <sup>1</sup> Designation (NH)	Pitch ( <i>p</i> )	Basic Thread Height ( <i>h</i> )	External Thread (Nipple)						
					Major Diameter			Pitch Diameter			Minor <sup>2</sup> Diameter
					Maximum	Minimum	Tolerance	Maximum	Minimum	Tolerance	Maximum
1	2	3	4	5	6	7	8	9	10	11	12
$\frac{3}{4}$	8	0.75-8 NH	0.12500	0.08119	1.3750	1.3528	0.0222	1.2938	1.2827	0.0111	1.2126
1	8	1-8 NH	0.12500	0.08119	1.3750	1.3528	0.0222	1.2938	1.2827	0.0111	1.2126
$1\frac{1}{2}$	9	1.5-9 NH	0.11111	0.07217	1.9900	1.9678	0.0222	1.9178	1.9067	0.0111	1.8457
$2\frac{1}{2}$	7.5	2.5-7.5 NH	0.13333	0.08660	3.0686	3.0366	0.0320	2.9820	2.9660	0.0160	2.8954
3	6	3-6 NH	0.16667	0.10825	3.6239	3.5879	0.0360	3.5156	3.4976	0.0180	3.4073
$3\frac{1}{2}$	6	3.5-6 NH	0.16667	0.10825	4.2439	4.2079	0.0360	4.1356	4.1176	0.0180	4.0273
4	4	4-4 NH	0.25000	0.16238	5.0109	4.9609	0.0500	4.8485	4.8235	0.0250	4.6861
$4\frac{1}{2}$	4	4.5-4 NH	0.25000	0.16238	5.7609	5.7109	0.0500	5.5985	5.5735	0.0250	5.4361
5	4	5-4 NH	0.25000	0.16238	6.2600	6.2100	0.0500	6.0976	6.0726	0.0250	5.9352
6	4	6-4 NH	0.25000	0.16238	7.0250	6.9750	0.0500	6.8626	6.8376	0.0250	6.7002

<sup>1</sup>All other values are given in inches.<sup>2</sup>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. The minimum minor diameter of the nipple shall be that corresponding to a flat at the minor diameter of the minimum nipple equal to  $p/24$  and may be determined by subtracting  $11h/9$  (or  $0.7939p$ ) from the minimum pitch diameter of the nipple.**Table 3-4.4 Thread Limits of Size and Tolerances of NH Internal Threads (Couplings)**

Nominal Size of Connection	Threads <sup>1</sup> per Inch (tpi)	Thread <sup>1</sup> Designation (NH)	Pitch ( <i>p</i> )	Basic Thread Height ( <i>h</i> )	Internal Thread (Coupling)						
					Minor Diameter			Pitch Diameter			Major <sup>2</sup> Diameter
					Minimum	Maximum	Tolerance	Minimum	Maximum	Tolerance	Minimum
1	2	3	4	5	6	7	8	9	10	11	12
$\frac{3}{4}$	8	0.75-8 NH	0.12500	0.08119	1.2246	1.2468	0.0222	1.3058	1.3169	0.0111	1.3870
1	8	1-8 NH	0.12500	0.08119	1.2246	1.2468	0.0222	1.3058	1.3169	0.0111	1.3870
$1\frac{1}{2}$	9	1.5-9 NH	0.11111	0.07217	1.8577	1.8799	0.0222	1.9298	1.9409	0.0111	2.0020
$2\frac{1}{2}$	7.5	2.5-7.5 NH	0.13333	0.08660	2.9104	2.9424	0.0320	2.9970	3.0130	0.0160	3.0836
3	6	3-6 NH	0.16667	0.10825	3.4223	3.4583	0.0360	3.5306	3.5486	0.0180	3.6389
$3\frac{1}{2}$	6	3.5-6 NH	0.16667	0.10825	4.0473	4.0833	0.0360	4.1556	4.1736	0.0180	4.2639
4	4	4-4 NH	0.25000	0.16238	4.7111	4.7611	0.0500	4.8735	4.8985	0.0250	5.0359
$4\frac{1}{2}$	4	4.5-4 NH	0.25000	0.16238	5.4611	5.5111	0.0500	5.6235	5.6485	0.0250	5.7859
5	4	5-4 NH	0.25000	0.16238	5.9602	6.0102	0.0500	6.1226	6.1476	0.0250	6.2850
6	4	6-4 NH	0.25000	0.16238	6.7252	6.7752	0.0500	6.8876	6.9126	0.0250	7.0500

<sup>1</sup>All other values are given in inches.<sup>2</sup>Dimensions for the minimum major diameter of the coupling correspond to the basic flat  $p/8$ , and the profile at the major diameter produced by a worn tool must not fall below the basic outline. The maximum major diameter of the coupling shall be that corresponding to a flat at the major diameter of the maximum coupling equal to  $p/24$  and can be determined by adding  $11h/9$  (or  $0.7939p$ ) to the maximum pitch diameter of the coupling.

**3-5 Tolerance.**

**3-5.1** The pitch diameter tolerances for a mating external (nipple) and internal (coupling) thread shall be the same. Pitch diameter tolerances shall include lead and half-angle deviations. Values for deviations in lead and half-angle consuming one-half of the pitch diameter tolerance shall be as specified in Table 3-5.1.

**3-5.2** The tolerance relationships for the external (nipple) threads shall be as follows:

Major diameter tolerance =  
 $2 \times \text{pitch diameter tolerance}$

Minor diameter tolerance =  
 $\text{pitch diameter tolerance} + 2h/9$ .

**3-5.3** The minimum minor diameter of the external thread (nipple) shall be such as to result in a flat equal to  $1/3$  of the  $p/8$  basic flat ( $p/24$ ) at the root when the pitch diameter of the nipple is at its minimum value. The maximum minor diameter is basic but shall be permitted to be such as results from the use of a worn or rounded threading tool. The maximum minor diameter shall be as specified in Figure 3-3.1 and is the diameter on which the minor diameter tolerance formula shown in 3-5.2 shall be based.

**3-5.4** The tolerance relationships for the internal (coupling) threads shall be as follows:

Minor diameter tolerance =  
 $2 \times \text{pitch diameter tolerance}$

The minimum minor diameter of a coupling is such as to result in a basic flat,  $p/8$ , at the crest when the pitch diameter of the coupling is at its minimum value.

Major diameter tolerance =  
 $\text{pitch diameter tolerance} + 2h/g$ .

**3-6 Gauges and Gauging NH Threads.**

**3-6.1** The limits of size for the gauges to be used in the gauging of fire hose connections shall be as specified in Tables 3-6.1(a), (b), and (c).

**3-6.2** For these gauges, the allowable variation in lead between any two threads not farther apart than the length of engagement shall be  $\pm 0.0004$  in. The allowable variation in half-angle of thread shall be  $\pm 5$  minutes.

**3-6.3\*** Except as otherwise specified herein, the gauges and gauging practices shall conform to ANSI/ASME B 1.2, *Gages and Gaging for Unified Inch Screw Threads*.

**3-6.4\*** Adjustable thread ring gauges shall be set by means of threaded setting plug gauges, the dimensions of which are given in Table 3-6.1(a). Means of setting ring gauges shall be as specified in ANSI/ASME B1.2, *Gages and Gaging for Unified Inch Screw Threads*.

**Table 3-5.1 Deviations in Lead and Half-Angle Consuming One-Half of Pitch Diameter Tolerances for NH Threads**

Nominal Size of Connection	Thread per <sup>1</sup> Inch (tpi)	Thread <sup>1</sup> Designation (NH)	Pitch Diameter <sup>2</sup> Tolerance	Lead Deviation <sup>3</sup> Consuming One- Half of Pitch Diameter Tolerance	Half-Angle Deviation <sup>1</sup> Consuming One-Half of Pitch Diameter Tolerance	
					degree	minute
$3/4$	8	0.75-8 NH	0.0111	0.0032	1	42
1	8	1-8 NH	0.0111	0.0032	1	42
$1\frac{1}{2}$	9	1.5-9 NH	0.0111	0.0032	1	54
$2\frac{1}{2}$	7.5	2.5-7.5 NH	0.0160	0.0046	2	17
3	6	3-6 NH	0.0180	0.0052	2	4
$3\frac{1}{2}$	6	3.5-6 NH	0.0180	0.0052	2	4
4	4	4-4 NH	0.0250	0.0072	1	55
$4\frac{1}{2}$	4	4.5-4 NH	0.0250	0.0072	1	55
5	4	5-4 NH	0.0250	0.0072	1	55
6	4	6-4 NH	0.0250	0.0072	1	55

<sup>1</sup>All other values are in inches.

<sup>2</sup>The tolerances specified for pitch diameter include all deviations 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 deviations in lead and in angle, each of which can be compensated for by half the pitch-diameter tolerance given in Column 4. If lead and angle deviations both exist to the amount tabulated, the pitch diameter of a nipple, for example, must be reduced by the full tolerance or it will not enter the GO gauge.

<sup>3</sup>Between any two threads not farther apart than the length of engagement.

Table 3-6.1(a) Setting Thread Plug Limits of Size for NH Thread Ring Gauges<sup>1</sup>

Nominal Size of Connection	Threads <sup>2</sup> per Inch (tpi)	Thread <sup>2</sup> Designation (NH)		X Truncated Setting Plugs						X Basic-Crest Setting <sup>3</sup> Plugs	
				Plug for GO Thread Gauge			Plug for LO (NOT GO) Thread Gauge			Major Diameter	
				Major Diameter		Pitch Diameter	Major Diameter		Pitch Diameter	Plug for GO Thread Gauge	Plug for LO (NOT GO) Thread Gauge
				Truncated	Full		Truncated	Full			
Gauge Tolerance				—	+	—	—	+	+	+	+
1	2	3	4	5	6	7	8	9	10	11	12
<sup>3</sup> / <sub>4</sub>	8	0.75-8 NH	Max	1.3579	1.3757	1.2938	1.3368	1.3757	1.2831	1.3757	1.3757
			Min	1.3572	1.3750	1.2934	1.3361	1.3750	1.2827	1.3750	1.3750
1	8	1-8 NH	Max	1.3579	1.3757	1.2938	1.3368	1.3757	1.2831	1.3757	1.3757
			Min	1.3572	1.3750	1.2934	1.3361	1.3750	1.2827	1.3750	1.3750
1 <sup>1</sup> / <sub>2</sub>	9	1.5-9 NH	Max	1.9742	1.9907	1.9178	1.9548	1.9907	1.9071	1.9907	1.9907
			Min	1.9735	1.9900	1.9174	1.9541	1.9900	1.9067	1.9900	1.9900
2 <sup>1</sup> / <sub>2</sub>	7.5	2.5-7.5 NH	Max	3.0507	3.0693	2.9820	3.0237	3.0693	2.9665	3.0693	3.0693
			Min	3.0500	3.0686	2.9815	3.0230	3.0686	2.9660	3.0686	3.0686
3	6	3-6 NH	Max	3.6029	3.6247	3.5156	3.5698	3.6247	3.4981	3.6247	3.6247
			Min	3.6021	3.6239	3.5151	3.5690	3.6239	3.4976	3.6239	3.6239
3 <sup>1</sup> / <sub>2</sub>	6	3.5-6 NH	Max	4.2229	4.2452	4.1356	4.1898	4.2452	4.1182	4.2452	4.2452
			Min	4.2216	4.2439	4.1350	4.1885	4.2439	4.1176	4.2439	4.2439
4	4	4-4 NH	Max	4.9828	5.0124	4.8485	4.9318	5.0124	4.8241	5.0124	5.0124
			Min	4.9813	5.0109	4.8479	4.9303	5.0109	4.8235	5.0109	5.0109
4 <sup>1</sup> / <sub>2</sub>	4	4.5-4 NH	Max	5.7328	5.7624	5.5985	5.6818	5.7624	5.5741	5.7624	5.7624
			Min	5.7313	5.7609	5.5979	5.6803	5.7609	5.5735	5.7609	5.7609
5	4	5-4 NH	Max	6.2319	6.2615	6.0976	6.1809	6.2615	6.0732	6.2615	6.2615
			Min	6.2304	6.2600	6.0970	6.1794	6.2600	6.0726	6.2600	6.2600
6	4	6-4 NH	Max	6.9969	7.0265	6.8626	6.9459	7.0265	6.8382	7.0265	7.0265
			Min	6.9954	7.0250	6.8620	6.9444	7.0250	6.8376	7.0250	7.0250

<sup>1</sup>Gauge limit values in this table have been obtained in accordance with ANSI/ASME B1.2, *Gages and Gaging for Unified Inch Screw Threads*.

<sup>2</sup>All other values are given in inches.

<sup>3</sup>Pitch diameter limits for basic-crest GO setting plugs are the same as those shown in column 7. Pitch diameter limits for basic-crest LO (NOT GO) setting plugs are the same as those shown in column 10.

**Table 3-6.1(b) Gauge Limits of Size for Ring Gauges for NH External (Nipple) Threads<sup>1</sup>**

Nominal Size of Connection	Threads <sup>2</sup> per Inch (tpi)	Thread <sup>2</sup> Designation (NH)		X Thread Ring Gauges				Z Plain Ring Gauges	
				GO		LO (NOT GO)		Major Diameter	
				Pitch Diameter	Minor Diameter	Pitch Diameter	Minor Diameter	GO	NOT GO
Gauge Tolerance				—	—	+	+	—	—
1	2	3	4	5	6	7	8	9	10
<sup>3</sup> / <sub>4</sub>	8	0.75-8 NH	Max	1.2938	1.2246	1.2831	1.2563	1.37500	1.35292
			Min	1.2934	1.2239	1.2827	1.2556	1.37488	1.35280
1	8	1-8 NH	Max	1.2938	1.2246	1.2831	1.2563	1.37500	1.35292
			Min	1.2934	1.2239	1.2827	1.2556	1.37488	1.35280
1 <sup>1</sup> / <sub>2</sub>	9	1.5-9 NH	Max	1.9178	1.8577	1.9071	1.8833	1.99000	1.96796
			Min	1.9174	1.8570	1.9067	1.8826	1.98984	1.96780
2 <sup>1</sup> / <sub>2</sub>	7.5	2.5-7.5 NH	Max	2.9820	2.9104	2.9665	2.9378	3.06860	3.03680
			Min	2.9815	2.9097	2.9660	2.9371	3.06840	3.03660
3	6	3-6 NH	Max	3.5156	3.4223	3.4981	3.4623	3.62390	3.58810
			Min	3.5151	3.4215	3.4976	3.4615	3.62370	3.58790
3 <sup>1</sup> / <sub>2</sub>	6	3.5-6 NH	Max	4.1356	4.0473	4.1182	4.0828	4.24390	4.20810
			Min	4.1350	4.0460	4.1176	4.0815	4.24370	4.20790
4	4	4-4 NH	Max	4.8485	4.7111	4.8241	4.7709	5.01090	4.96115
			Min	4.8479	4.7096	4.8235	4.7694	5.01065	4.96090
4 <sup>1</sup> / <sub>2</sub>	4	4.5-4 NH	Max	5.5985	5.4611	5.5741	5.5209	5.76090	5.71115
			Min	5.5979	5.4596	5.5735	5.5194	5.76065	5.71090
5	4	5-4 NH	Max	6.0976	5.9602	6.0732	6.0200	6.26000	6.21025
			Min	6.0970	5.9587	6.0726	6.0185	6.25975	6.21000
6	4	6-4 NH	Max	6.8626	6.7252	6.8382	6.7850	7.02500	6.97532
			Min	6.8620	6.7237	6.8376	6.7835	7.02468	6.97500

<sup>1</sup>Gauge limit values in this table have been obtained in accordance with ANSI/ASME B1.2, *Gages and Gaging for Unified Inch Screw Threads*, except for the values shown in column 6. The maximum values shown in column 6 are values for the minimum minor diameter of the internal thread.

<sup>2</sup>All other values are given in inches.

**Table 3-6.1(c) Gauge Limits of Size for Plug Gauges for NH Internal (Coupling) Threads<sup>1</sup>**

Nominal Size of Connection	Threads <sup>2</sup> per Inch (tpi)	Thread <sup>2</sup> Designation (NH)		X Thread Plug Gauges				Z Plain Plug Gauges	
				GO		HI (NOT GO)		Minor Diameter	
				Major Diameter	Pitch Diameter	Major Diameter	Pitch Diameter	GO	NOT GO
Gauge Tolerance				+	+	—	—	+	
1	2	3	4	5	6	7	8	9	10
<sup>3</sup> / <sub>4</sub>	8	0.75-8 NH	Max	1.3877	1.3062	1.3710	1.3169	1.22472	1.24680
			Min	1.3870	1.3058	1.3703	1.3165	1.22460	1.24668
1	8	1-8 NH	Max	1.3877	1.3062	1.3710	1.3169	1.22472	1.24680
			Min	1.3870	1.3058	1.3703	1.3165	1.22460	1.24668
1 <sup>1</sup> / <sub>2</sub>	9	1.5-9 NH	Max	2.0027	1.9302	1.9890	1.9409	1.85786	1.87990
			Min	2.0020	1.9298	1.9883	1.9405	1.85770	1.87974
2 <sup>1</sup> / <sub>2</sub>	7.5	2.5-7.5 NH	Max	3.0843	2.9975	3.0707	3.0130	2.91060	2.94240
			Min	3.0836	2.9970	3.0700	3.0125	2.91040	2.94220
3	6	3-6 NH	Max	3.6397	3.5311	3.6208	3.5486	3.42250	3.45830
			Min	3.6389	3.5306	3.6200	3.5481	3.42230	3.45810
3 <sup>1</sup> / <sub>2</sub>	6	3.5-6 NH	Max	4.2652	4.1562	4.2458	4.1736	4.04750	4.08330
			Min	4.2639	4.1556	4.2445	4.1730	4.04730	4.08310
4	4	4-4 NH	Max	5.0374	4.8741	5.0068	4.8985	4.71135	4.76110
			Min	5.0359	4.8735	5.0053	4.8979	4.71110	4.76085
4 <sup>1</sup> / <sub>2</sub>	4	4.5-4 NH	Max	5.7874	5.6241	5.7568	5.6485	5.46135	5.51110
			Min	5.7859	5.6235	5.7553	5.6479	5.46110	5.51085
5	4	5-4 NH	Max	6.2865	6.1232	6.2559	6.1476	5.96045	6.01020
			Min	6.2850	6.1226	6.2544	6.1470	5.96020	6.00995
6	4	6-4 NH	Max	7.0515	6.8882	7.0209	6.9126	6.72552	6.77520
			Min	7.0500	6.8876	7.0194	6.9120	6.72520	6.77488

<sup>1</sup>Gauge limit values in this table have been obtained in accordance with ANSI/ASME B1.2, *Gages and Gaging for Unified Inch Screw Threads*.

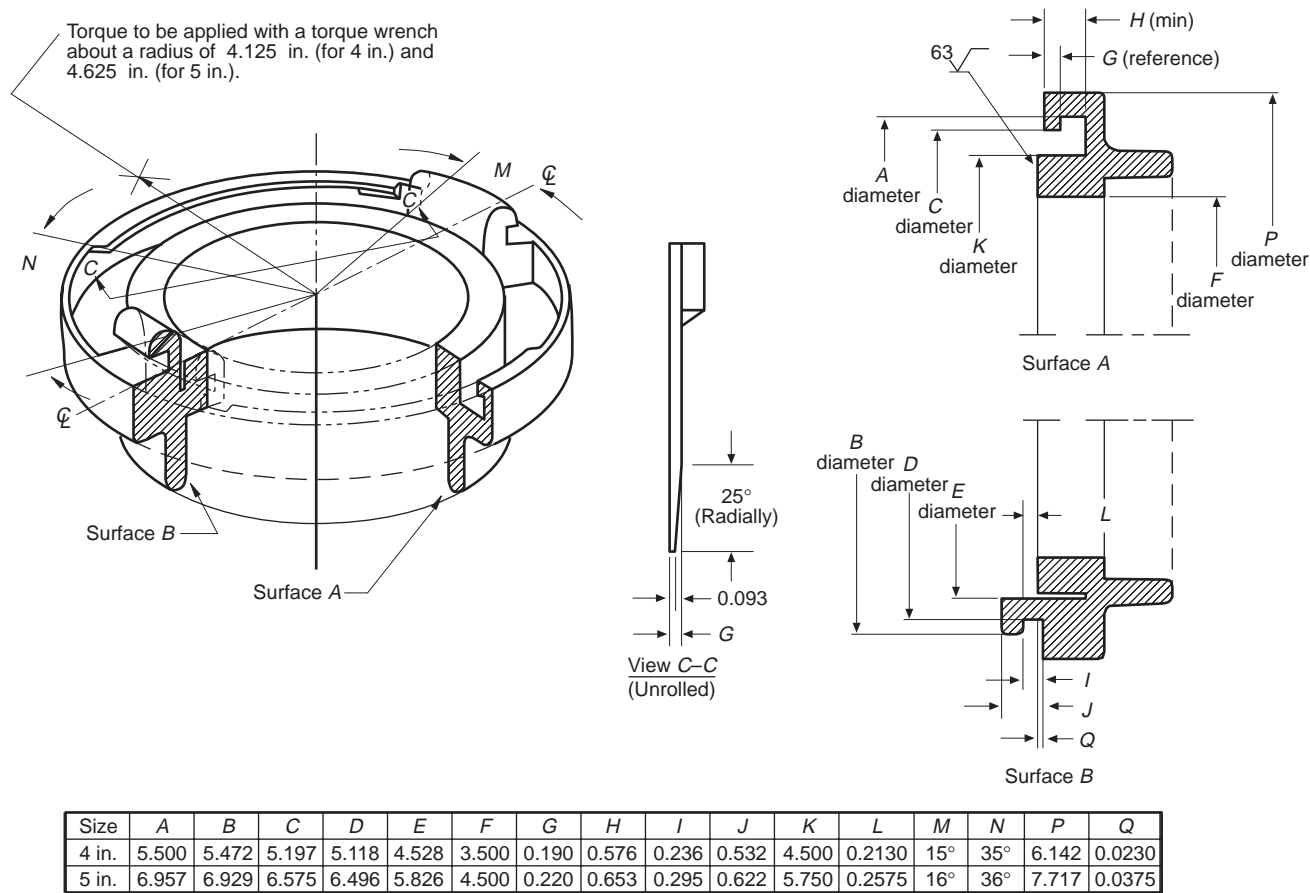
<sup>2</sup>All other values are given in inches.



Chapter 4 Nonthreaded Connections

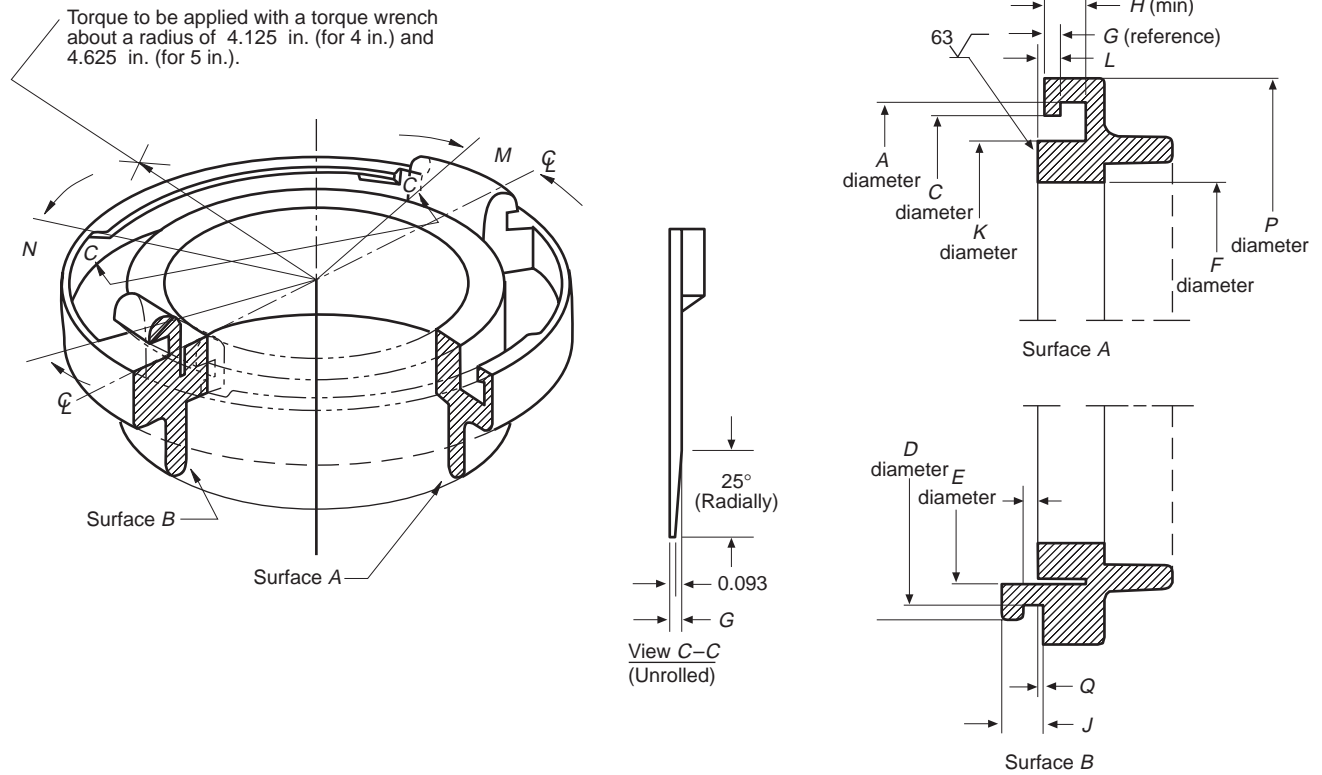
**4-1\* General.** This chapter covers nonthreaded connections only in the 4-in. (100-mm) and 5-in. (125-mm) sizes. The requirements of Chapters 1 and 2 shall apply in addition to the requirements defined in this chapter.

**4-2\* Gauges.** The dimensional characteristics and tolerances for the metal-face gauges to be used in the gauging of nonthreaded connections shall be as specified in Figure 4-2(a) for a Type A test gauge and Figure 4-2(b) for a Type B test gauge. In addition, the 4-in. (100-mm) metal-face gauge shall meet the dimensional characteristics of Figure 4-2(c), and the 5-in. (125-mm) metal-face gauge shall meet the dimensional characteristics of Figure 4-2(d).



Note 1: All linear measurements in inches. Tolerances: .XXXX = ±.002 in.  
Note 2: All dimensions are to be the same for similar configurations on the gauge.

Figure 4-2(a) Dimensions for Type A test gauge (no ramp angle).

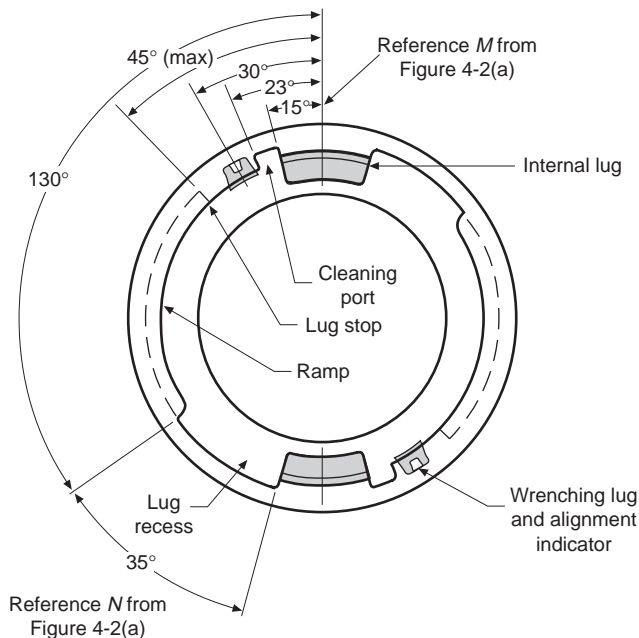


Size	A	B	C	D	E	F	G	H	I	J	K	L	M	N	P	Q
4 in.	5.500	5.472	5.197	5.118	4.528	3.500	0.190	0.576	0.236	0.532	4.500	0.2130	15°	35°	6.142	0.0230
5 in.	6.957	6.929	6.575	6.496	5.826	4.500	0.220	0.653	0.295	0.622	5.750	0.2575	16°	36°	7.717	0.0375

Note 1: All linear measurements in inches. Tolerances: .XXXX =  $\pm 0.005$  in.; .XXX =  $\pm 0.002$  in.

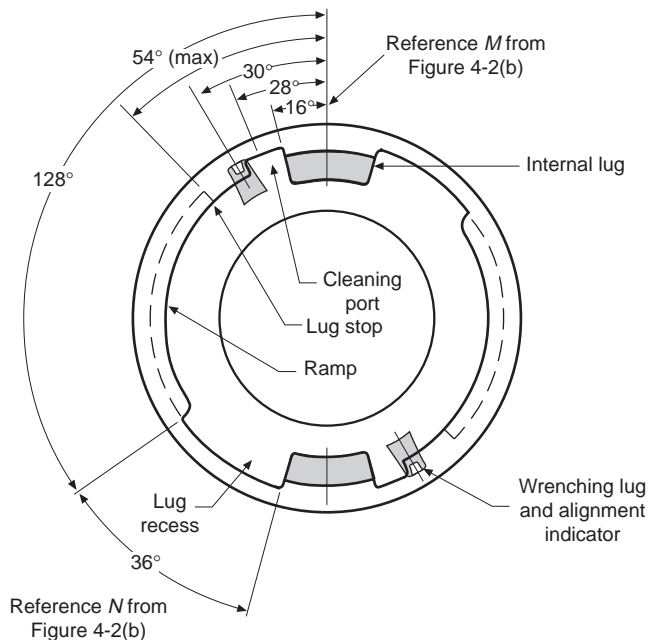
Note 2: All dimensions are to be the same for similar configurations on the gauge.

**Figure 4-2(b) Dimensions for Type B test gauge (with lugs removed).**



Note: All dimensions are to be the same for similar configurations on the gauge.

**Figure 4-2(c) End view of 4-in. (100-mm) metal-face gauge and non-threaded 4-in (100-mm) connections.**



Note: All dimensions are to be the same for similar configurations on the gauge.

**Figure 4-2(d) End view of 5-in. (125-mm) metal-face gauge and non-threaded 5-in (125-mm) connections.**

### 4.3 Locks.

**4.3.1\*** Nonthreaded connections shall be provided with locks within the confines of the nonthreaded connection to ensure against unintentional disconnection.

*Exception: Caps for use with nonthreaded connections.*

**4.3.2** The locks shall be located so that the nonthreaded connection will connect to the Type A metal-face test gauge and lock.

**4.3.3** The locks shall be designed so as to lock automatically when connecting two nonthreaded connections without additional action needed to engage the locks. The lock shall not be capable of being secured (mechanically) in the open (unlocked) position.

**4.3.4** The locks shall be field repairable.

**4.3.5** The locks shall be designed so as to be disengaged by hand in a separate action other than that needed to disconnect the nonthreaded connection. The locks shall be capable of being unlocked by a fire fighter wearing gloves meeting the requirements of NFPA 1971, *Standard on Protective Ensemble for Structural Fire Fighting*. A device such as a wrench incorporating both actions in one motion shall be permitted to be used.

**4.3.6** The lock mechanism shall not shear when a force of 300 lb × ft (407 N × m) is applied at the nut on the test wrench.

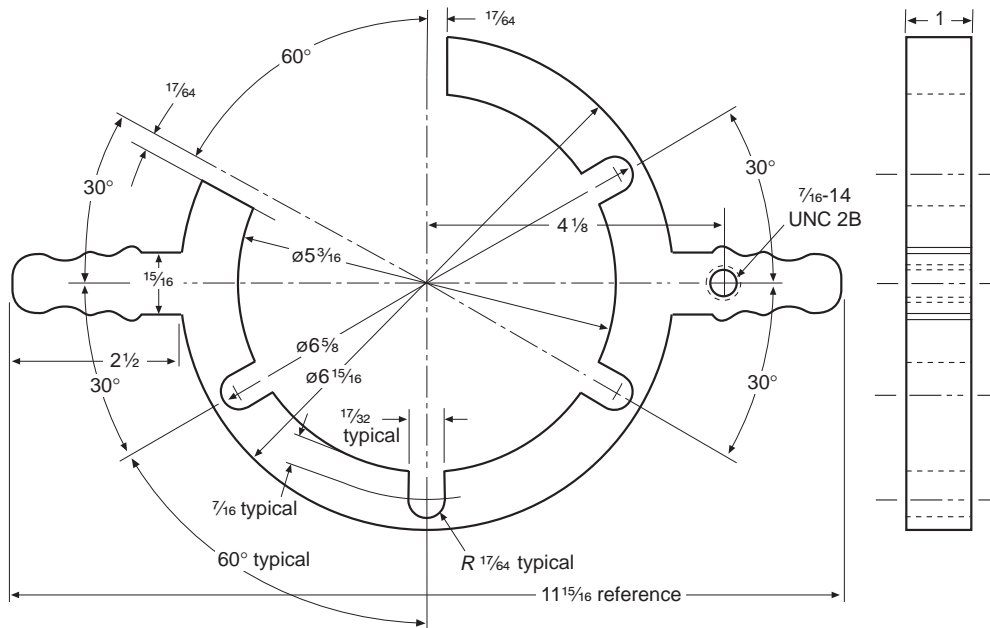
**4.4 Indicators.** Permanent indicators, obvious to sight and touch, shall be located at two points 180 degrees apart as shown on Figures 4-2(c) and 4-2(d) to indicate the fully engaged position of the connections.

### 4.5 Force to Connect and Disconnect Requirements.

**4.5.1\*** All nonthreaded pressure connections shall be capable of connection and disconnection to both the Type A and the Type B metal-face test gauges at a force of between 6.0 lb × in. (0.68 N × m) and 30 lb × in. (3.4 N × m) when measured as described in 4-5.3 and under the conditions described in 4-5.4. The force to connect and disconnect nonthreaded pressure connections to each other shall not exceed 40 lb × in. (4.5 N × m) when measured as described in 4-5.3 and under the conditions described in 4-5.4.

**4.5.2** All nonthreaded suction connections shall be capable of connection and disconnection to both the Type A and the Type B metal-face test gauges at a force of between 168 lb × in. (19.0 N × m) and 312 lb × in. (35.3 N × m) and under the conditions described in 4-5.4. The force to connect and disconnect nonthreaded suction connections to each other shall not exceed 360 lb × in. (40.7 N × m) when measured as described in 4-5.3 and under the conditions described in 4-5.4.

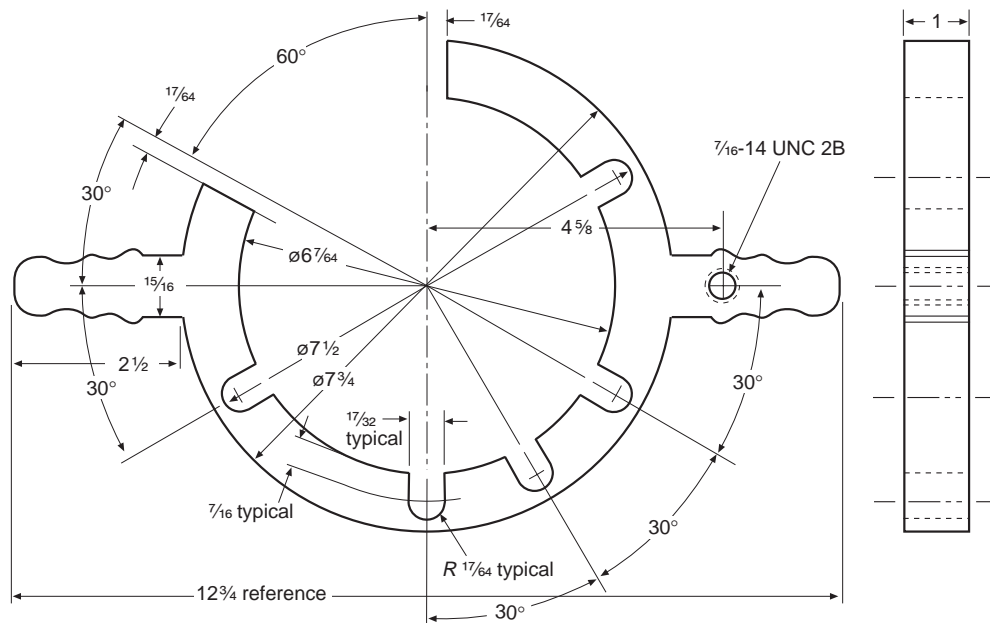
**4.5.3\*** The force to connect and disconnect shall be tested as follows. One of the metal-face test gauges, or one-half of a pressure or suction connector, depending on the force to be checked, shall be secured in a vise or similar device. The connector to be tested shall be free to turn without constraint or assistance. For 4-in. (100-mm) connectors, a test wrench with dimensions as shown in Figure 4-5.3(a) shall be attached over the external lugs of the connector being tested. For 5-in. (125-mm) connectors, a test wrench with dimensions as shown in Figure 4-5.3(b) shall be attached over the external lugs of the connector to be tested. A standard torque wrench measuring inch pounds shall be connected to the test wrench. The torque wrench shall be moved in the direction necessary to connect or disconnect the connector being tested. The lock shall be held open only when the connector is being disconnected. The torque wrench shall be in direct line with the center of the connector when the torque reading is being taken.



Note 1: Use  $\frac{7}{16}$ -14 UNC 2A  $\times$  1-in. long hex head cap screw to connect torque wrench socket to.  
Note 2: Unless otherwise specified, tolerance shall be decimals: X.XXX  $\pm$  0.005; fractions:  $\pm \frac{1}{64}$ .

Drawing units = inches  
Angles =  $\pm \frac{1}{2}$  degree  
125 micro-inch finish on all machine surfaces.  
Do not scale drawing.

Figure 4-5.3(a) Test wrench for force to connect test of 4-in. (100-mm) connectors.



Note 1: Use  $\frac{7}{16}$ -14 UNC 2A  $\times$  1-in. long hex head cap screw to connect torque wrench socket to.  
Note 2: Unless otherwise specified, tolerance shall be decimals: X.XXX  $\pm$  0.005; fractions:  $\pm \frac{1}{64}$ .

Drawing units = inches  
Angles =  $\pm \frac{1}{2}$  degree  
125 micro-inch finish on all machine surfaces.  
Do not scale drawing.

Figure 4-5.3(b) Test wrench for force to connect test of 5-in. (125-mm) connectors.

**4-5.4** The force to connect and disconnect test shall be done at 70°F (21°C) ambient temperature. The gaskets shall be clean but not lubricated.

**4-6 Caps.** All nonthreaded caps shall have suction gaskets installed.

**4-7 Adapters.** All nonthreaded adapters shall have pressure gaskets installed.

**4-8 Metal-Face Hydrant Connections.** All nonthreaded, metal-face hydrant connections shall be made to the dimensions as specified in Figure 4-8. In addition, 4-in. (100-mm) metal-face hydrant connections shall meet the dimensional characteristics of Figure 4-2(c), and the 5-in. (125-mm) metal-face connections shall meet the dimensional characteristics of Figure 4-2(d).

## Chapter 5 Gaskets

### 5-1 Threaded Coupling Gasket.

**5-1.1** Each internal connection shall be provided with a resilient thread gasket that does not leak under normal use when fitted accurately in the seat specified in this standard.

**5-1.2** Each thread gasket shall meet the dimensions specified in Table 5-1.2.

**5-1.3** The durometer of the thread gasket shall be  $70 \pm 5$  Shore A.

### 5-2 Nonthreaded Coupling Gaskets.

**5-2.1** Each nonthreaded connection shall be fitted with a resilient face gasket that does not leak under normal use.

**5-2.2** The durometer of the gasket shall be  $70 \pm 5$  Shore A.

**5-2.3** The face gasket shall be either a suction gasket or a pressure gasket, depending on the application in which the coupling is to be used.

**5-2.3.1** Pressure gaskets shall be designed to withstand the pressure requirements of Sections 2-6 and 2-10 without leakage. They shall be black in color.

**5-2.3.2** Suction gaskets shall be designed to allow couplings equipped with the gasket to meet the requirements of Section 2-11. They shall be gray in color.

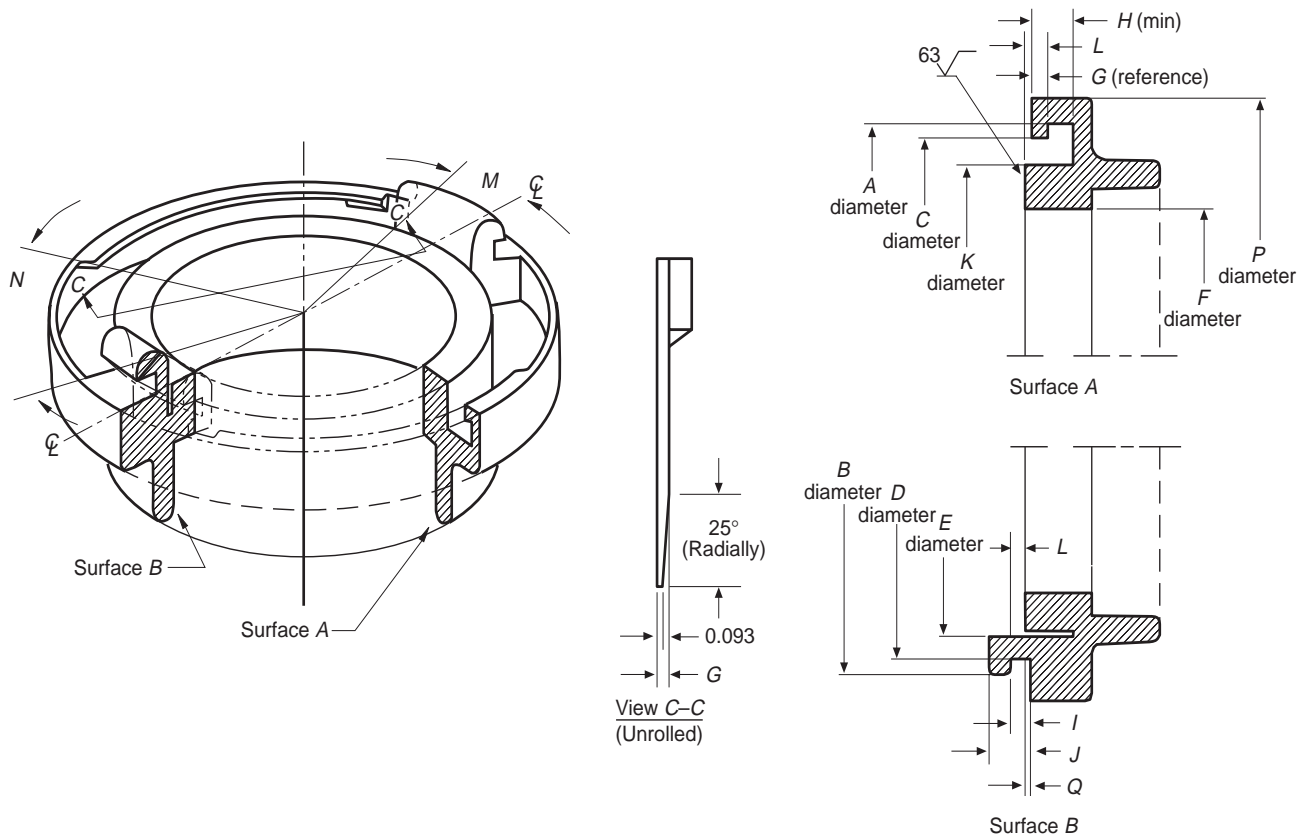
**5-3\* Tail Gasket.** Each coupling that is installed on a fire hose with an expansion ring shall be equipped with a resilient gasket of durometer  $60 \pm 5$  Shore A in the hose bowl that keeps the ends of the fabric of the fire hose dry. The nominal dimensions of these gaskets shall be as follows:

- (a) Minimum inside diameter as specified in Table 5-1.2
- (b) Outside diameter to accurately fit the recess provided
- (c) Thickness  $\frac{3}{16}$  in. (4.8 mm) minimum

**Table 5-1.2 Dimensions of Thread Gaskets for Standard Internal Threaded Connections**

Nominal Size of Connection	Inside Diameter	Outside Diameter	Thickness
$\frac{3}{4}$	$\frac{13}{16}$ (20.6)	$1 \frac{7}{16}$ (36.5)	$\frac{1}{8}$ (3.18)
1	$1 \frac{1}{16}$ (27)	$1 \frac{7}{16}$ (36.5)	$\frac{1}{8}$ (3.18)
$1 \frac{1}{2}$	$1 \frac{9}{16}$ (40)	$2 \frac{1}{16}$ (52)	$\frac{1}{8}$ (3.18)
$2 \frac{1}{2}$	$2 \frac{9}{16}$ (65)	$3 \frac{3}{16}$ (81)	$\frac{3}{16}$ (4.8)
3	$3 \frac{1}{16}$ (78)	$3 \frac{3}{4}$ (95)	$\frac{1}{4}$ (6.4)
$3 \frac{1}{2}$	$3 \frac{9}{16}$ (91)	$4 \frac{3}{8}$ (111)	$\frac{1}{4}$ (6.4)
4	$4 \frac{1}{16}$ (103)	$5 \frac{1}{8}$ (130)	$\frac{1}{4}$ (6.4)
$4 \frac{1}{2}$	$4 \frac{9}{16}$ (117)	$5 \frac{7}{8}$ (149)	$\frac{1}{4}$ (6.4)
5	$5 \frac{1}{16}$ (129)	$6 \frac{3}{8}$ (162)	$\frac{1}{4}$ (6.4)
6	$6 \frac{1}{16}$ (154)	$7 \frac{1}{8}$ (181)	$\frac{1}{4}$ (6.4)

Note: All dimensions are given in inches (mm).



Note 1: All linear dimensions in inches. Tolerances: .XXXX =  $\pm 0.002$  in.; .XXX =  $\pm 0.005$  in.

Note 2: Attachment to hydrant — as specified by purchaser.

Note 3: All dimensions are to be the same for similar configurations on the hydrant connection.

**Figure 4-8 Metal-face hydrant connection showing required dimensions.**

## Chapter 6 Use of NH Threads and Nonthreaded Connections

### 6-1\* Hose Coupling Threads.

**6-1.1\*  $\frac{3}{4}$ -in. and 1-in. (19-mm and 25-mm) Hose.** All  $\frac{3}{4}$ -in. and 1-in. (19-mm and 25-mm) hose shall be provided with couplings having the 0.75-8 NH standard thread and 1-8 NH standard thread, respectively.

**6-1.2  $1\frac{1}{2}$ -in. through 2-in. (38-mm through 52-mm) Fire Hose.** All  $1\frac{1}{2}$ -in. through 2-in. (38-mm through 52-mm) fire hose shall be provided with couplings having the 1.5-9 NH standard thread.

**6-1.3  $2\frac{1}{2}$ -in. (65-mm) Fire Hose.** All  $2\frac{1}{2}$ -in. (65-mm) fire hose shall be provided with couplings having the 2.5-7.5 NH standard thread.

**6-1.4 3-in. (75-mm) Fire Hose.** All 3-in. (75-mm) fire hose shall be provided with couplings having the 2.5-7.5 NH standard thread for interchangeability with  $2\frac{1}{2}$ -in. (65-mm) fire hose.

**6-1.4.1** Where interchangeability with  $2\frac{1}{2}$ -in. (65-mm) fire hose is not a factor, the couplings shall be permitted to have the 3-6 NH standard thread.

**6-1.5  $3\frac{1}{2}$ -in. (90-mm) Fire Hose.** All  $3\frac{1}{2}$ -in. (90-mm) fire hose shall be provided with couplings having the 3.5-6 NH standard thread.

**6-1.5.1** Where interchangeability with 3-in. (75-mm) fire hose or other connections is required, the couplings shall be permitted to have the 3-6 NH standard thread.

**6-1.6 4-in. (100-mm) Fire Hose.** All 4-in. (100-mm) fire hose shall be provided with couplings having the 4-4 NH standard thread.

**6-1.6.1** Where interchangeability with  $3\frac{1}{2}$ -in. (90-mm) fire hose or other connections is required, the couplings shall be permitted to have the 3.5-6 NH standard thread.

**6-1.6.2** Where the authority having jurisdiction permits, 4-in. (100-mm) nonthreaded couplings shall be permitted to be used.

**6-1.7  $4\frac{1}{2}$ -in. (114-mm) Fire Hose.** All  $4\frac{1}{2}$ -in. (114-mm) fire hose shall be provided with couplings having the 4.5-4 NH standard thread.

**6-1.7.1** Where interchangeability with 4-in. (100-mm) fire hose or other connections is required, the couplings shall be permitted to have the 4-4 NH standard thread.

**6-1.8 5-in. (125-mm) Fire Hose.** All 5-in. (125-mm) fire hose shall be provided with couplings having the 5-4 NH standard thread.

**6-1.8.1** Where interchangeability with  $4\frac{1}{2}$ -in. (114-mm) fire hose or other connections is required, the couplings shall be permitted to have the 4.5-4 NH standard thread.

**6-1.8.2** Where the authority having jurisdiction permits, 5-in. (125-mm) nonthreaded couplings shall be permitted to be used.

**6-1.9 6-in. (150-mm) Fire Hose.** All 6-in. (150-mm) fire hose shall be provided with couplings having the 6-4 NH standard thread.

**6-1.9.1** Where interchangeability with 5-in. (125-mm) fire hose or other connections is required, the couplings shall be permitted to have the 5-4 NH standard thread.

**6-1.10\* Hard Suction Hose.** Hard suction hose shall be provided with couplings having the NH standard thread compatible with the nominal size of the hard suction hose.

### 6-2\* Connections for Fire Service Nozzles for Handlines.

**6-2.1** Playpipes for connecting shutoff nozzles to  $2\frac{1}{2}$ -in. (65-mm) fire hose shall have the 2.5-7.5 NH standard thread at the base or primary inlet and the 1.5-9 NH standard thread at the discharge end, as shown in Figure 6-2.1.

**6-2.2** Nozzle shutoff valves for either  $2\frac{1}{2}$ -in. (65-mm) nozzles or  $1\frac{1}{2}$ -in. (38-mm) nozzles shall have the 1.5-9 NH standard thread for both the inlet and discharge sides of the valve, as shown in Figure 6-2.1 for  $1\frac{1}{2}$ -in. (38-mm) and Figure 6-2.2 for  $2\frac{1}{2}$ -in. (65-mm).

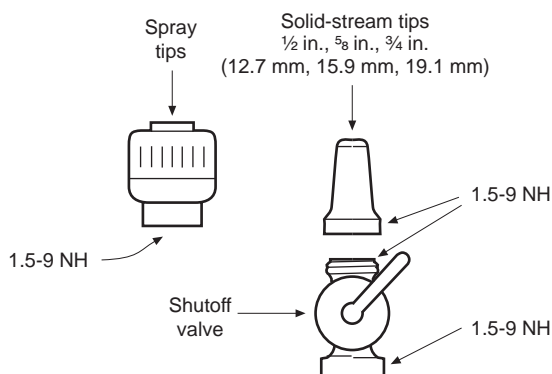


Figure 6-2.1 Nozzle assembly for  $1\frac{1}{2}$ -in. (38-mm) hose.

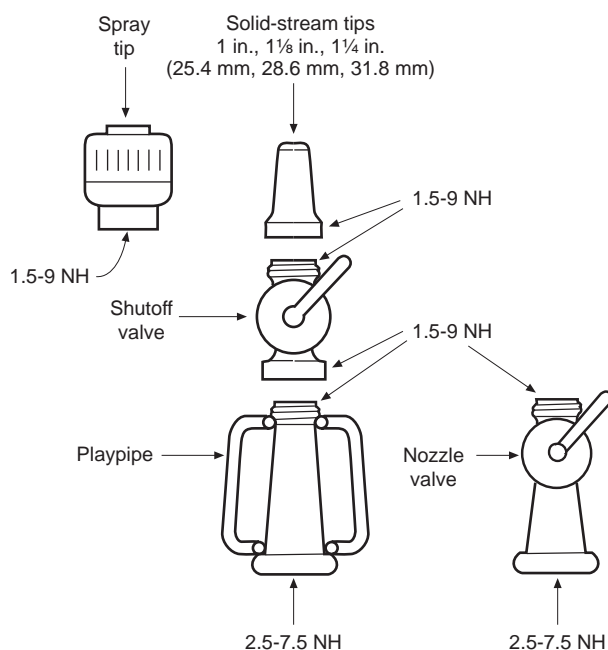


Figure 6-2.2 Nozzle assembly for  $2\frac{1}{2}$ -in. (65-mm) hose.

**6-2.2.1** Where the valve is an integral nondetachable part of a 2<sup>1</sup>/<sub>2</sub>-in. (65-mm) playpipe, the 1.5-9 NH standard thread shall be provided only on the discharge side of the valve.

**6-2.3** All nozzles used on booster hose shall have the 1-8 NH standard thread.

**6-2.4** All nozzle tips for use on 2<sup>1</sup>/<sub>2</sub>-in. (65-mm) and 1<sup>1</sup>/<sub>2</sub>-in. (38-mm) nozzles shall have the 1.5-9 NH standard thread.

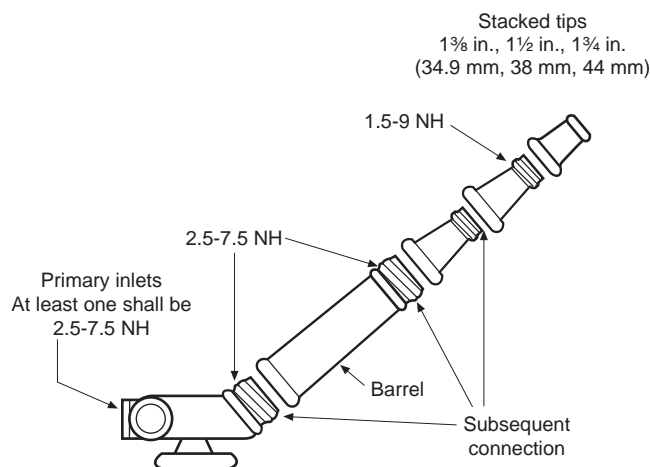
**6-2.5\*** All spray nozzles with a shutoff valve for use on 1<sup>1</sup>/<sub>2</sub>-in. (38-mm) and 2<sup>1</sup>/<sub>2</sub>-in. (65-mm) hose where flows at rated pressure do not exceed 400 gpm (1600 L/min) shall have at least 1.5-9 NH standard thread at the internal connection.

### 6-3 Connections for Large Stream Devices.

**6-3.1\* Primary Inlet.** At least one inlet connection on each fire department large stream device equipped with multiple primary inlets (other than devices piped permanently to a pump) shall be fitted with at least one female swivel connection, which shall have 2.5-7.5 NH standard thread as shown in Figures 6-3.2.1 and 6-3.2.2. An adapter shall be permitted to be provided to meet this intent.

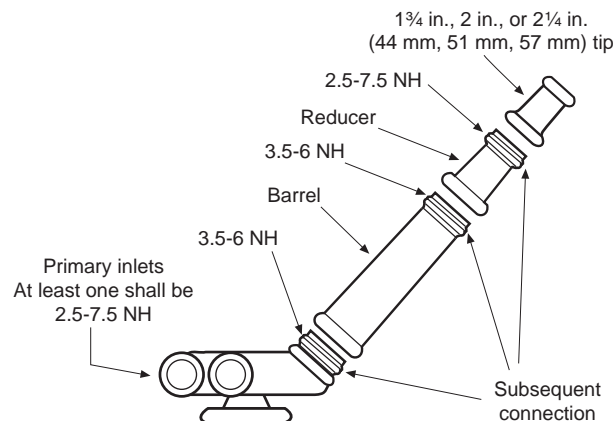
#### 6-3.2\* Subsequent Connections.

**6-3.2.1** Discharge ends of large stream devices designed to discharge from 400 to 1250 gpm (1600 to 5000 L/min) shall have the 2.5-7.5 NH standard thread for attaching nozzle tips or spray nozzles. If stacked tips are used, one of these tips shall have the 1.5-9 NH standard thread as shown in Figure 6-3.2.1.



**Figure 6-3.2.1** Large stream device rated under 1250 gpm (5000 L/min).

**6-3.2.2** Discharge ends of large stream devices designed to discharge in excess of 1250 gpm (5000 L/min) but less than 3000 gpm (12,000 L/min) shall have the 3.5-6 NH standard thread for attaching nozzle tips or spray nozzles. However, all such large-capacity appliances shall be provided with a reducer fitting, 3.5-6 NH female × 2.5-7.5 NH male. A stacked tip meeting the requirements of 6-3.2.5 and having the male 2.5-7.5 NH standard thread as an integral component shall be accepted as meeting this requirement as shown in Figure 6-3.2.2.



**Figure 6-3.2.2** Large stream device rated over 1250 gpm (5000 L/min) but less than 3000 gpm (12,000 L/min).

**6-3.2.3** Straight tip and spray nozzle tips that are designed to discharge flows between 400 and 1250 gpm (1600 and 5000 L/min) shall have 2.5-7.5 NH inlet thread.

**6-3.2.4** Straight tip and spray nozzle tips designed to discharge flows above 1250 gpm (5000 L/min) but less than 3000 gpm (12,000 L/min) shall have 3.5-6 NH inlet thread.

**6-3.2.5** Subsequent connections, straight tips, and spray nozzle tips on large stream devices over 3000 gpm (12,000 L/min) shall have an NH standard thread consistent with the nominal inlet or outlet size.

## Chapter 7 Referenced Publications

**7-1** The following documents or portions thereof are referenced within this standard as mandatory requirements and shall be considered part of the requirements of this standard. The edition indicated for each referenced mandatory document is the current edition as of the date of the NFPA issuance of this standard. Some of these mandatory documents might also be referenced in this standard for specific informational purposes and, therefore, are also listed in Appendix C.

**7-1.1 NFPA Publication.** National Fire Protection Association, 1 Batterymarch Park, P.O. Box 9101, Quincy, MA 02269-9101.

NFPA 1971, *Standard on Protective Ensemble for Structural Fire Fighting*, 1997 edition.

**7-1.2 ANSI Publication.** American National Standards Institute, 11 West 42nd Street, 13th floor, New York, NY 10036.

ANSI/ASME B1.2, *Gages and Gaging for Unified Inch Screw Threads*, 1983.

**7-1.3 ASTM Publications.** American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 30, *Standard Specification for Copper-Brass Alloys in Ingot Form*, 1996.

ASTM B 117, *Standard Practice for Operating Salt Spray (Fog) Apparatus*, 1995.

ASTM B 584, *Standard Specification for Copper Alloy Sand Castings for General Applications*, 1996.

ASTM D 395, *Standard Test Methods for Rubber Property — Compression Set*, 1989.



ASTM D 573, *Standard Test Method for Rubber Deterioration in an Air Oven*, 1988.

ASTM D 3183, *Standard Practice for Rubber — Preparation of Pieces for Test Purposes from Products*, 1984.

## Appendix A Explanatory Material

*Appendix A is not a part of the requirements of this NFPA document but is included for informational purposes only. This appendix contains explanatory material, numbered to correspond with the applicable text paragraphs.*

**A-1-1** Some fire-fighting organizations use small hose less than  $\frac{3}{4}$  in. (19 mm) nominal diameter fitted with garden hose couplings. Such couplings should have 0.75-11.5 NH (garden hose thread) threads conforming to ANSI/ASME B1.20.7, *Standard on Hose Coupling Screw Threads*.

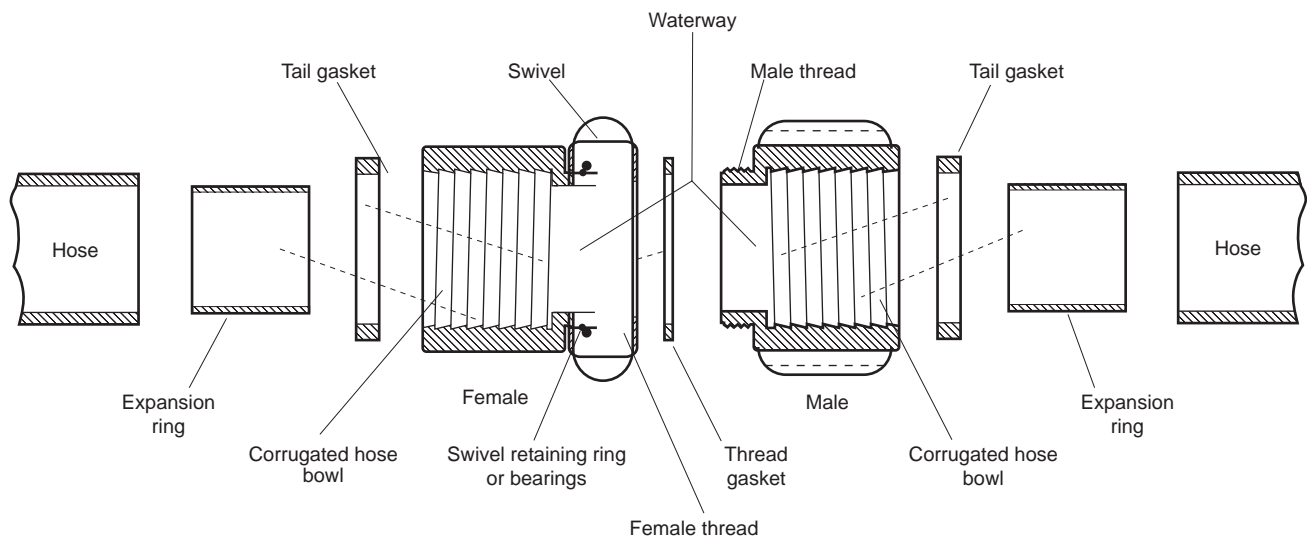
**A-1-3 Approved.** The National Fire Protection Association does not approve, inspect, or certify any installations, procedures, equipment, or materials; nor does it approve or evaluate testing laboratories. In determining the acceptability of installations, procedures, equipment, or materials, the authority having jurisdiction may base acceptance on compliance with NFPA or other appropriate standards. In the absence of such standards, said authority may require evidence of proper installation, procedure, or use. The authority having jurisdiction may also refer to the listings or labeling practices of an organization that is concerned with product evaluations and is thus in a position to determine compliance with appropriate standards for the current production of listed items.

**A-1-3 Authority Having Jurisdiction.** The phrase “authority having jurisdiction” is used in NFPA documents in a broad manner, since jurisdictions and approval agencies vary, as do their responsibilities. Where public safety is primary, the authority having jurisdiction may be a federal, state, local, or other regional department or individual such as a fire chief; fire marshal; chief of a fire prevention bureau, labor department, or health department; building official; electrical inspector; or others having statutory authority. For insurance purposes, an insurance inspection department, rating bureau, or other insurance company representative may be the authority having jurisdiction. In many circumstances, the property owner or his or her designated agent assumes the role of the authority having jurisdiction; at government installations, the commanding officer or departmental official may be the authority having jurisdiction.

**A-2-1** Figure A-2-1(a) shows an expansion ring coupling set for a set of threaded couplings. Figure A-2-1(b) shows a typical nonthreaded fire hose connection that connects to the fire hose with a tailpiece and external reattachable collar

**A-3-2** American National Fire Hose Connection Screw Threads are also sometimes known by the abbreviations NST and NS.

**A-3-6.3** See Figure A-3-6.3.



**Figure A-2-1(a) An expansion ring coupling set.**