

Here at **Peppers** we take pride in having over 70 years experience providing threaded products. To maintain the ingress protection rating of the product, the entry hole must be perpendicular to the surface of the enclosure. The surface should be sufficiently flat and rigid to make the IP joint. The surface must be clean and dry. It is the users/installers responsibility to ensure that the interface between the enclosure and the product is suitably sealed for the required application. We supply products with parallel entry threads that conform to the flameproof threaded joint requirements of IEC/EN 60079-1 and other equivalent standards. We usually incorporate a thread run out according to general machining techniques and parts will not have a full form thread for the entire length.

The table below outlines our recommended chamfers for internal threads. Following these recommendations will ensure that a suitable ingress protection seal will be maintained.

Size	Minor Dia (d)	Chamfer Depth	Ref Dia (D)
M12 x 1.5	10.4	1.5	13.4
M16 x 1.5	14.4	1.5	17.4
M20 x 1.5	18.4	1.5	21.4
M25 x 1.5	23.4	1.5	26.4
M32 x 1.5	30.4	1.5	33.4
M40 x 1.5	38.4	1.5	41.4
M50 x 1.5	48.4	1.5	51.4
M63 x 1.5	61.4	1.5	64.4
M75 x 1.5	73.4	1.5	76.4
M80 x 2.0	77.8	2.0	81.8
M85 x 2.0	82.8	2.0	86.8
M90 x 2.0	87.8	2.0	91.8
M100 x 2.0	97.8	2.0	101.8
M110 x 2.0	107.8	2.0	111.8
M120 x 2.0	117.8	2.0	121.8
All Sizes are in millimeters			

