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Quality - Service - Responsibility





PMC



Mercury

PMC Mercury is a premier leader in the manufacture and calibration of precision thread and cylindrical gages. For nearly a century, customers from around the world have come to depend on the accuracy and durability of **PMC Mercury** gages. **PMC Mercury** prides itself on the quality and craftsmanship that goes into the manufacturing of each gage. **PMC Mercury** gages are heat treated and then deep frozen to assure dimensional stability for years to come. Plug gages are inspected twice to guard against any deviation from the true helical path of the thread forms (drunken threads). All finishing, lapping and inspection procedures are conducted in a constant temperature, humidity controlled laboratory for optimum accuracy. Our goal is to provide our customers with the highest quality products, service and on time delivery available in the industry. We strive to continually upgrade our manufacturing capabilities and improve our technical abilities through continuing education of our employees and implementation of the latest technology. Our motto is customer awareness and service. We welcome the opportunity to serve your gaging requirements whether they are from our standard product line or are unique to your specifications.

NICK BOSWORTH

PRESIDENT
PMC MERCURY





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MODIFIED SQUARE..... QUOTED UPON REQUEST

PMC Mercury offers a full range of calibration services, including certifications to A2LA ISO 17025

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METRIC THREAD PLUG GAGES



| METRIC THREAD PLUG GAGES | | | | | | | |
|--------------------------|-------|-----------------------------|-------------------------|--------|------------------------------|-------------------------|--------|
| SIZE | PITCH | TAPERLOCK THREAD PLUG GAGES | | | REVERSIBLE THREAD PLUG GAGES | | |
| | | GO 6H "X" TOL | NOT GO 6H "X" TOL | HANDLE | GO 6H "X" TOL | NOT GO 6H "X" TOL | HANDLE |
| M1.6 | 0.35 | W0160356HG | W0160356HN | 000 | V0160356HG | V0160356HN | 1W |
| M1.8 | 0.35 | W0180356HG | W0180356HN | 000 | V0180356HG | V0180356HN | 1W |
| M2 | 0.40 | W0200406HG | W0200406HN | 000 | V0200406HG | V0200406HN | 2W |
| M2.2 | 0.45 | W0220456HG | W0220456HN | 000 | V0220456HG | V0220456HN | 2W |
| M2.5 | 0.45 | W0250456HG | W0250456HN | 00 | V0250456HG | V0250456HN | 2W |
| M3 | 0.50 | W0300506HG | W0300506HN | 00 | V0300506HG | V0300506HN | 2W |
| M3.5 | 0.60 | W0350606HG | W0350606HN | 00 | V0350606HG | V0350606HN | 2W |
| M4 | 0.70 | W0400706HG | W0400706HN | 00 | V0400706HG | V0400706HN | 2W |
| M4.5 | 0.75 | W0450756HG | W0450756HN | 00 | V0450756HG | V0450756HN | 3W |
| M5 | 0.80 | W0500806HG | W0500806HN | 00 | V0500806HG | V0500806HN | 3W |
| M5.5 | 0.75 | W0550756HG | W0550756HN | 00 | V0550756HG | V0550756HN | 3W |
| M6 | 1.00 | W0601006HG | W0601006HN | 1 | V0601006HG | V0601006HN | 3W |
| M7 | 1.00 | W0701006HG | W0701006HN | 1 | V0701006HG | V0701006HN | 3W |
| M8 | 1.25 | W0801256HG | W0801256HN | 1 | V0801256HG | V0801256HN | 4W |
| M9 | 1.25 | W0901256HG | W0901256HN | 2 | V0901256HG | V0901256HN | 4W |
| M10 | 0.75 | W1000756HG | W1000756HN | 2 | V1000756HG | V1000756HN | 4W |
| M10 | 1.25 | W1001256HG | W1001256HN | 2 | V1001256HG | V1001256HN | 4W |
| M10 | 1.50 | W1001506HG | W1001506HN | 2 | V1001506HG | V1001506HN | 4W |
| M11 | 1.50 | W1101506HG | W1101506HN | 2 | V1101506HG | V1101506HN | 4W |
| M12 | 1.25 | W1201256HG | W1201256HN | 2 | V1201256HG | V1201256HN | 5W |
| M12 | 1.50 | W1201506HG | W1201506HN | 2 | V1201506HG | V1201506HN | 5W |
| M12 | 1.75 | W1201756HG | W1201756HN | 2 | V1201756HG | V1201756HN | 5W |
| M14 | 1.50 | W1401506HG | W1401506HN | 3 | V1401506HG | V1401506HN | 6W |
| M14 | 2.00 | W1402006HG | W1402006HN | 3 | V1402006HG | V1402006HN | 6W |
| M15 | 1.00 | W1501006HG | W1501006HN | 3 | V1501006HG | V1501006HN | 6W |
| M15 | 1.50 | W1501506HG | W1501506HN | 3 | V1501506HG | V1501506HN | 6W |
| M16 | 1.50 | W1601506HG | W1601506HN | 3 | V1601506HG | V1601506HN | 7W |
| M16 | 2.00 | W1602006HG | W1602006HN | 3 | V1602006HG | V1602006HN | 7W |
| M17 | 1.00 | W1701006HG | W1701006HN | 3 | V1701006HG | V1701006HN | 7W |
| M17 | 1.50 | W1701506HG | W1701506HN | 3 | V1701506HG | V1701506HN | 7W |
| M18 | 1.50 | W1801506HG | W1801506HN | 3 | V1801506HG | V1801506HN | 7W |
| M18 | 2.50 | W1802506HG | W1802506HN | 3 | V1802506HG | V1802506HN | 7W |

METRIC THREAD PLUG GAGES CONTINUED



| METRIC THREAD PLUG GAGES | | | | | | | |
|--------------------------|-------|-----------------------------|-------------------------|--------|------------------------------|-------------------------|--------|
| SIZE | PITCH | TAPERLOCK THREAD PLUG GAGES | | | REVERSIBLE THREAD PLUG GAGES | | |
| | | GO 6H "X" TOL | NOT GO 6H "X" TOL | HANDLE | GO 6H "X" TOL | NOT GO 6H "X" TOL | HANDLE |
| M20 | 1.00 | W2001006HG | W2001006HN | 4 | Quoted Upon Request | | |
| M20 | 1.50 | W2001506HG | W2001506HN | 4 | | | |
| M20 | 2.50 | W2002506HG | W2002506HN | 4 | | | |
| M22 | 1.50 | W2201506HG | W2201506HN | 4 | | | |
| M22 | 2.50 | W2202506HG | W2202506HN | 4 | | | |
| M24 | 2.00 | W2402006HG | W2402006HN | 4 | | | |
| M24 | 3.00 | W2403006HG | W2403006HN | 4 | | | |
| M25 | 1.50 | W2501506HG | W2501506HN | 4 | | | |
| M25 | 2.00 | W2502006HG | W2502006HN | 4 | | | |
| M26 | 1.00 | W2601006HG | W2601006HN | 4 | | | |
| M26 | 1.50 | W2601506HG | W2601506HN | 4 | | | |
| M27 | 2.00 | W2702006HG | W2702006HN | 4 | | | |
| M27 | 3.00 | W2703006HG | W2703006HN | 4 | | | |
| M28 | 1.00 | W2801006HG | W2801006HN | 4 | | | |
| M28 | 1.50 | W2801506HG | W2801506HN | 4 | | | |
| M28 | 2.00 | W2802006HG | W2802006HN | 4 | | | |
| M30 | 1.50 | W3001506HG | W3001506HN | 5 | | | |
| M30 | 2.00 | W3002006HG | W3002006HN | 5 | | | |
| M30 | 3.50 | W3003506HG | W3003506HN | 5 | | | |
| M32 | 1.50 | W3201506HG | W3201506HN | 5 | | | |
| M32 | 2.00 | W3202006HG | W3202006HN | 5 | | | |
| M33 | 2.00 | W3302006HG | W3302006HN | 5 | | | |
| M33 | 3.50 | W3303506HG | W3303506HN | 5 | | | |
| M35 | 1.50 | W3501506HG | W3501506HN | 5 | | | |
| M36 | 2.00 | W3602006HG | W3602006HN | 5 | | | |
| M36 | 3.00 | W3603006HG | W3603006HN | 5 | | | |
| M36 | 4.00 | W3604006HG | W3604006HN | 5 | | | |
| M38 | 1.50 | W3801506HG | W3801506HN | 5 | | | |
| *M39 | 2.00 | W3902006HG | W3902006HN | 5 | | | |
| *M39 | 3.00 | W3903006HG | W3903006HN | 5 | | | |
| *M39 | 4.00 | W3904006HG | W3904006HN | 5 | | | |

* GAGES ARE TRILOCK DESIGN

METRIC THREAD RING & SETTING PLUG GAGES



METRIC THREAD RING & SETTING PLUG GAGES

| SIZE | PITCH | THREAD RING GAGES | | | TAPERLOCK TRUNCATED SETTING PLUG GAGES | | | TAPERLOCK HILO SETTING PLUG GAGES | | |
|------|-------|-------------------|-------------------|--------|--|-----------------------------|--------|-----------------------------------|------------------------|--------|
| | | GO 6g "X" TOL | NOT GO 6g "X" TOL | HOLDER | TRUNCATED GO 6g "X" TOL | TRUNCATED NOT GO 6g "X" TOL | HANDLE | HILO GO 6g "W" TOL | HILO NOT GO 6g "W" TOL | HANDLE |
| M1.6 | 0.35 | R0160356GG | R0160356GN | 1 | S0160356GG | S0160356GN | 000 | HL0160356GG | HL0160356GN | 000 |
| M1.8 | 0.35 | R0180356GG | R0180356GN | 1 | S0180356GG | S0180356GN | 000 | HL0180356GG | HL0180356GN | 000 |
| M2 | 0.40 | R0200406GG | R0200406GN | 1 | S0200406GG | S0200406GN | 000 | HL0200406GG | HL0200406GN | 000 |
| M2.2 | 0.45 | R0220456GG | R0220456GN | 1 | S0220456GG | S0220456GN | 000 | HL0220456GG | HL0220456GN | 000 |
| M2.5 | 0.45 | R0250456GG | R0250456GN | 1 | S0250456GG | S0250456GN | 00 | HL0250456GG | HL0250456GN | 00 |
| M3 | 0.50 | R0300506GG | R0300506GN | 1 | S0300506GG | S0300506GN | 00 | HL0300506GG | HL0300506GN | 00 |
| M3.5 | 0.60 | R0350606GG | R0350606GN | 1 | S0350606GG | S0350606GN | 00 | HL0350606GG | HL0350606GN | 00 |
| M4 | 0.70 | R0400706GG | R0400706GN | 1 | S0400706GG | S0400706GN | 00 | HL0400706GG | HL0400706GN | 00 |
| M4.5 | 0.75 | R0450756GG | R0450756GN | 1 | S0450756GG | S0450756GN | 00 | HL0450756GG | HL0450756GN | 00 |
| M5 | 0.80 | R0500806GG | R0500806GN | 1 | S0500806GG | S0500806GN | 00 | HL0500806GG | HL0500806GN | 00 |
| M5.5 | 0.75 | R0550756GG | R0550756GN | 1 | S0550756GG | S0550756GN | 00 | ***** | ***** | ** |
| M6 | 1.00 | R0601006GG | R0601006GN | 1 | S0601006GG | S0601006GN | 1 | HL0601006GG | HL0601006GN | 1 |
| M7 | 1.00 | R0701006GG | R0701006GN | 2 | S0701006GG | S0701006GN | 1 | HL0701006GG | HL0701006GN | 1 |
| M8 | 1.25 | R0801256GG | R0801256GN | 2 | S0801256GG | S0801256GN | 1 | HL0801256GG | HL0801256GN | 1 |
| M9 | 1.25 | R0901256GG | R0901256GN | 3 | S0901256GG | S0901256GN | 2 | ***** | ***** | ** |
| M10 | 0.75 | R1000756GG | R1000756GN | 3 | S1000756GG | S1000756GN | 2 | ***** | ***** | ** |
| M10 | 1.25 | R1001256GG | R1001256GN | 3 | S1001256GG | S1001256GN | 2 | HL1001256GG | HL1001256GN | 2 |
| M10 | 1.50 | R1001506GG | R1001506GN | 3 | S1001506GG | S1001506GN | 2 | HL1001506GG | HL1001506GN | 2 |
| M11 | 1.50 | R1101506GG | R1101506GN | 3 | S1101506GG | S1101506GN | 2 | ***** | ***** | ** |
| M12 | 1.25 | R1201256GG | R1201256GN | 3 | S1201256GG | S1201256GN | 2 | HL1201256GG | HL1201256GN | 2 |
| M12 | 1.50 | R1201506GG | R1201506GN | 3 | S1201506GG | S1201506GN | 2 | HL1201506GG | HL1201506GN | 2 |
| M12 | 1.75 | R1201756GG | R1201756GN | 3 | S1201756GG | S1201756GN | 2 | HL1201756GG | HL1201756GN | 2 |
| M14 | 1.50 | R1401506GG | R1401506GN | 4 | S1401506GG | S1401506GN | 3 | HL1401506GG | HL1401506GN | 3 |
| M14 | 2.00 | R1402006GG | R1402006GN | 4 | S1402006GG | S1402006GN | 3 | HL1402006GG | HL1402006GN | 3 |
| M15 | 1.00 | R1501006GG | R1501006GN | 4 | S1501006GG | S1501006GN | 3 | ***** | ***** | ** |
| M15 | 1.50 | R1501506GG | R1501506GN | 4 | S1501506GG | S1501506GN | 3 | ***** | ***** | ** |
| M16 | 1.50 | R1601506GG | R1601506GN | 4 | S1601506GG | S1601506GN | 3 | HL1601506GG | HL1601506GN | 3 |
| M16 | 2.00 | R1602006GG | R1602006GN | 4 | S1602006GG | S1602006GN | 3 | HL1602006GG | HL1602006GN | 3 |
| M17 | 1.00 | R1701006GG | R1701006GN | 4 | S1701006GG | S1701006GN | 3 | ***** | ***** | ** |
| M17 | 1.50 | R1701506GG | R1701506GN | 4 | S1701506GG | S1701506GN | 3 | ***** | ***** | ** |
| M18 | 1.50 | R1801506GG | R1801506GN | 4 | S1801506GG | S1801506GN | 3 | HL1801506GG | HL1801506GN | 3 |
| M18 | 2.50 | R1802506GG | R1802506GN | 4 | S1802506GG | S1802506GN | 3 | HL1802506GG | HL1802506GN | 3 |

METRIC THREAD RING & SETTING PLUG GAGES CONTINUED



| METRIC THREAD RING & SETTING PLUG GAGES | | | | | | | | | | |
|---|-------|---------------------|-------------------------|--------|--|--------------------------------------|--------|-----------------------------------|---------------------------------|--------|
| SIZE | PITCH | THREAD RING GAGES | | | TAPERLOCK TRUNCATED SETTING PLUG GAGES | | | TAPERLOCK HILO SETTING PLUG GAGES | | |
| | | GO 6g "X" TOL | NOT GO 6g "X" TOL | HOLDER | TRUNCATED GO 6g "X" TOL | TRUNCATED NOT GO 6g "X" TOL | HANDLE | HILO GO 6g "W" TOL | HILO NOT GO 6g "W" TOL | HANDLE |
| M20 | 1.00 | R2001006GG | R2001006GN | 5 | S2001006GG | S2001006GN | 4 | HL2001006GG | HL2001006GN | 4 |
| M20 | 1.50 | R2001506GG | R2001506GN | 5 | S2001506GG | S2001506GN | 4 | HL2001506GG | HL2001506GN | 4 |
| M20 | 2.50 | R2002506GG | R2002506GN | 5 | S2002506GG | S2002506GN | 4 | HL2002506GG | HL2002506GN | 4 |
| M22 | 1.50 | R2201506GG | R2201506GN | 5 | S2201506GG | S2201506GN | 4 | HL2201506GG | HL2201506GN | 4 |
| M22 | 2.50 | R2202506GG | R2202506GN | 5 | S2202506GG | S2202506GN | 4 | HL2202506GG | HL2202506GN | 4 |
| M24 | 2.00 | R2402006GG | R2402006GN | 5 | S2402006GG | S2402006GN | 4 | HL2402006GG | HL2402006GN | 4 |
| M24 | 3.00 | R2403006GG | R2403006GN | 5 | S2403006GG | S2403006GN | 4 | HL2403006GG | HL2403006GN | 4 |
| M25 | 1.50 | R2501506GG | R2501506GN | 5 | S2501506GG | S2501506GN | 4 | ***** | ***** | ** |
| M25 | 2.00 | R2502006GG | R2502006GN | 5 | S2502006GG | S2502006GN | 4 | ***** | ***** | ** |
| M26 | 1.00 | R2601006GG | R2601006GN | 5 | S2601006GG | S2601006GN | 4 | ***** | ***** | ** |
| M26 | 1.50 | R2601506GG | R2601506GN | 5 | S2601506GG | S2601506GN | 4 | ***** | ***** | ** |
| M27 | 2.00 | R2702006GG | R2702006GN | 5 | S2702006GG | S2702006GN | 4 | HL2702006GG | HL2702006GN | 4 |
| M27 | 3.00 | R2703006GG | R2703006GN | 5 | S2703006GG | S2703006GN | 4 | HL2703006GG | HL2703006GN | 4 |
| M28 | 1.00 | R2801006GG | R2801006GN | 5 | S2801006GG | S2801006GN | 4 | ***** | ***** | ** |
| M28 | 1.50 | R2801506GG | R2801506GN | 5 | S2801506GG | S2801506GN | 4 | ***** | ***** | ** |
| M28 | 2.00 | R2802006GG | R2802006GN | 5 | S2802006GG | S2802006GN | 4 | ***** | ***** | ** |
| M30 | 1.50 | R3001506GG | R3001506GN | 6 | S3001506GG | S3001506GN | 5 | ***** | ***** | ** |
| M30 | 2.00 | R3002006GG | R3002006GN | 6 | S3002006GG | S3002006GN | 5 | HL3002006GG | HL3002006GN | 5 |
| M30 | 3.50 | R3003506GG | R3003506GN | 6 | S3003506GG | S3003506GN | 5 | HL3003506GG | HL3003506GN | 5 |
| M32 | 1.50 | R3201506GG | R3201506GN | 6 | S3201506GG | S3201506GN | 5 | ***** | ***** | ** |
| M32 | 2.00 | R3202006GG | R3202006GN | 6 | S3202006GG | S3202006GN | 5 | ***** | ***** | ** |
| M33 | 2.00 | R3302006GG | R3302006GN | 6 | S3302006GG | S3302006GN | 5 | HL3302006GG | HL3302006GN | 5 |
| M33 | 3.50 | R3303506GG | R3303506GN | 6 | S3303506GG | S3303506GN | 5 | HL3303506GG | HL3303506GN | 5 |
| M35 | 1.50 | R3501506GG | R3501506GN | 6 | S3501506GG | S3501506GN | 5 | HL3501506GG | HL3501506GN | 5 |
| M36 | 2.00 | R3602006GG | R3602006GN | 6 | S3602006GG | S3602006GN | 5 | ***** | ***** | ** |
| M36 | 3.00 | R3603006GG | R3603006GN | 6 | S3603006GG | S3603006GN | 5 | HL3603006GG | HL3603006GN | 5 |
| M36 | 4.00 | R3604006GG | R3604006GN | 6 | S3604006GG | S3604006GN | 5 | HL3604006GG | HL3604006GN | 5 |
| M38 | 1.50 | R3801506GG | R3801506GN | 6 | S3801506GG | S3801506GN | 5 | ***** | ***** | ** |
| *M39 | 2.00 | R3902006GG | R3902006GN | 6 | S3902006GG | S3902006GN | 5 | ***** | ***** | ** |
| *M39 | 3.00 | R3903006GG | R3903006GN | 6 | S3903006GG | S3903006GN | 5 | HL3903006GG | HL3903006GN | 5 |
| *M39 | 4.00 | R3904006GG | R3904006GN | 6 | S3904006GG | S3904006GN | 5 | HL3904006GG | HL3904006GN | 5 |

*GAGES ARE TRILOCK DESIGN

UNIFIED THREAD PLUG GAGES



UNIFIED THREAD PLUG GAGES

CLASS X

| SIZE | TAPERLOCK THREAD PLUGS | | | | REVERSIBLE PIN THREAD PLUGS | | | |
|--------------|------------------------|-------------|-------------|--------|-----------------------------|-------------|-------------|--------|
| | GO 2B & 3B | NOTGO 2B | NOTGO 3B | HANDLE | GO 2B & 3B | NOTGO 2B | NOTGO 3B | HANDLE |
| 0-80 UNF | W006080G | W0060802BN | W0060803BN | 000 | V006080G | V0060802BN | V0060803BN | 1W |
| 1-64 UNC | W007364G | W0073642BN | W0073643BN | 000 | V007364G | V0073642BN | V0073643BN | 1W |
| 1-72 UNF | W007372G | W0073722BN | W0073723BN | 000 | V007372G | V0073722BN | V0073723BN | 1W |
| 2-56 UNC | W008656G | W0086562BN | W0086563BN | 000 | V008656G | V0086562BN | V0086563BN | 2W |
| 2-64 UNF | W008664G | W0086642BN | W0086643BN | 000 | V008664G | V0086642BN | V0086643BN | 2W |
| 3-48 UNC | W009948G | W0099482BN | W0099483BN | 000 | V009948G | V0099482BN | V0099483BN | 2W |
| 3-56 UNF | W009956G | W0099562BN | W0099563BN | 000 | V009956G | V0099562BN | V0099563BN | 2W |
| 4-40 UNC | W011240G | W0112402BN | W0112403BN | 00 | V011240G | V0112402BN | V0112403BN | 2W |
| 4-48 UNF | W011248G | W0112482BN | W0112483BN | 00 | V011248G | V0112482BN | V0112483BN | 2W |
| 5-40 UNC | W012540G | W0125402BN | W0125403BN | 00 | V012540G | V0125402BN | V0125403BN | 2W |
| 5-44 UNF | W012544G | W0125442BN | W0125443BN | 00 | V012544G | V0125442BN | V0125443BN | 2W |
| 6-32 UNC | W013832G | W0138322BN | W0138323BN | 00 | V013832G | V0138322BN | V0138323BN | 2W |
| 6-40 UNF | W013840G | W0138402BN | W0138403BN | 00 | V013840G | V0138402BN | V0138403BN | 2W |
| 8-32 UNC | W016432G | W0164322BN | W0164323BN | 0 | V016432G | V0164322BN | V0164323BN | 2W |
| 8-36 UNF | W016436G | W0164362BN | W0164363BN | 0 | V016436G | V0164362BN | V0164363BN | 2W |
| 10-24 UNC | W019024G | W0190242BN | W0190243BN | 0 | V019024G | V0190242BN | V0190243BN | 3W |
| 10-32 UNF | W019032G | W0190322BN | W0190323BN | 0 | V019032G | V0190322BN | V0190323BN | 3W |
| 12-24 UNC | W021624G | W0216242BN | W0216243BN | 0 | V021624G | V0216242BN | V0216243BN | 3W |
| 12-28 UNF | W021628G | W0216282BN | W0216283BN | 0 | V021628G | V0216282BN | V0216283BN | 3W |
| 12-32 UNEF | W021632G | W0216322BN | W0216323BN | 0 | V021632G | V0216322BN | V0216323BN | 3W |
| 1/4-20 UNC | W025020G | W0250202BN | W0250203BN | 1 | V025020G | V0250202BN | V0250203BN | 3W |
| 1/4-28 UNF | W025028G | W0250282BN | W0250283BN | 1 | V025028G | V0250282BN | V0250283BN | 3W |
| 1/4-32 UNEF | W025032G | W0250322BN | W0250323BN | 1 | V025032G | V0250322BN | V0250323BN | 3W |
| 5/16-18 UNC | W031218G | W0312182BN | W0312183BN | 1 | V031218G | V0312182BN | V0312183BN | 4W |
| 5/16-24 UNF | W031224G | W0312242BN | W0312243BN | 1 | V031224G | V0312242BN | V0312243BN | 4W |
| 5/16-32 UNEF | W031232G | W0312322BN | W0312323BN | 1 | V031232G | V0312322BN | V0312323BN | 4W |
| 3/8-16 UNC | W037516G | W0375162BN | W0375163BN | 2 | V037516G | V0375162BN | V0375163BN | 4W |
| 3/8-24 UNF | W037524G | W0375242BN | W0375243BN | 2 | V037524G | V0375242BN | V0375243BN | 4W |
| 3/8-32 UNEF | W037532G | W0375322BN | W0375323BN | 2 | V037532G | V0375322BN | V0375323BN | 4W |
| 7/16-14 UNC | W043714G | W0437142BN | W0437143BN | 2 | V043714G | V0437142BN | V0437143BN | 5W |
| 7/16-20 UNF | W043720G | W0437202BN | W0437203BN | 2 | V043720G | V0437202BN | V0437203BN | 5W |
| 7/16-28 UNEF | W043728G | W0437282BN | W0437283BN | 2 | V043728G | V0437282BN | V0437283BN | 5W |
| 1/2-13 UNC | W050013G | W0500132BN | W0500133BN | 2 | V050013G | V0500132BN | V0500133BN | 5W |
| 1/2-20 UNF | W050020G | W0500202BN | W0500203BN | 2 | V050020G | V0500202BN | V0500203BN | 5W |
| 1/2-28 UNEF | W050028G | W0500282BN | W0500283BN | 2 | V050028G | V0500282BN | V0500283BN | 5W |
| 9/16-12 UNC | W056212G | W0562122BN | W0562123BN | 3 | V056212G | V0562122BN | V0562123BN | 6W |
| 9/16-18 UNF | W056218G | W0562182BN | W0562183BN | 3 | V056218G | V0562182BN | V0562183BN | 6W |
| 9/16-24 UNEF | W056224G | W0562242BN | W0562243BN | 3 | **** | **** | **** | ** |

UNIFIED THREAD PLUG GAGES CONTINUED



| UNIFIED THREAD PLUG GAGES | | | | | | | | |
|---------------------------|------------------------|-------------|-------------|--------|--|-------------|-------------|--------|
| CLASS X | | | | | | | | |
| SIZE | TAPERLOCK THREAD PLUGS | | | | REVERSIBLE PIN THREAD PLUGS | | | |
| | GO 2B & 3B | NOTGO 2B | NOTGO 3B | HANDLE | GO 2B & 3B | NOTGO 2B | NOTGO 3B | HANDLE |
| 5/8-11 UNC | W062511G | W0625112BN | W0625113BN | 3 | V062511G | V0625112BN | V0625113BN | 6W |
| 5/8-18 UNF | W062518G | W0625182BN | W0625183BN | 3 | V062518G | V0625182BN | V0625183BN | 6W |
| 5/8-24 UNEF | W062524G | W0625242BN | W0625243BN | 3 | ***** | ***** | ***** | ** |
| 11/16-24 UNEF | W068724G | W0687242BN | W0687243BN | 3 | ***** | ***** | ***** | ** |
| 3/4-10 UNC | W075010G | W0750102BN | W0750103BN | 3 | V075010G | V0750102BN | V0750103BN | 7W |
| 3/4-16 UNF | W075016G | W0750162BN | W0750163BN | 3 | V075016G | V0750162BN | V0750163BN | 7W |
| 3/4-20 UNEF | W075010G | W0750202BN | W0750203BN | 3 | ***** | ***** | ***** | ** |
| 13/16-20 UNEF | W081220G | W0812202BN | W0812203BN | 3 | REVERSIBLE TRILOCK THREAD PLUGS | | | |
| 7/8-9 UNC | W087509G | W0875092BN | W0875093BN | 4 | Quoted Upon Request | | | |
| 7/8-14 UNF | W087514G | W0875142BN | W0875143BN | 4 | | | | |
| 7/8-20 UNEF | W087520G | W0875202BN | W0875203BN | 4 | | | | |
| 15/16-20 UNEF | W093720G | W0937202BN | W0937203BN | 4 | | | | |
| 1-8 UNC | W100008G | W1000082BN | W1000083BN | 4 | | | | |
| 1-12 UNF | W100012G | W1000122BN | W1000123BN | 4 | | | | |
| 1-14 UNS | W100014G | W1000142BN | W1000143BN | 4 | | | | |
| 1-20 UNEF | W100020G | W1000202BN | W1000203BN | 4 | | | | |
| 1 1/16-12 UNF | W106212G | W1062122BN | W1062123BN | 4 | | | | |
| 1 1/16-18 UNEF | W106218G | W1062182BN | W1062183BN | 4 | | | | |
| 1 1/8-7 UNC | W112507G | W1125072BN | W1125073BN | 4 | | | | |
| 1 1/8-12 UNF | W112512G | W1125122BN | W1125123BN | 4 | | | | |
| 1 1/8-18 UNEF | W112518G | W1125182BN | W1125183BN | 4 | | | | |
| 1 3/16-12 UNF | W118712G | W1187122BN | W1187123BN | 4 | | | | |
| 1 3/16-18 UNEF | W118718G | W1187182BN | W1187183BN | 4 | | | | |
| 1 1/4-7 UNC | W125007G | W1250072BN | W1250073BN | 5 | | | | |
| 1 1/4-12 UNF | W125012G | W1250122BN | W1250123BN | 5 | | | | |
| 1 1/4-18 UNEF | W125018G | W1250182BN | W1250183BN | 5 | | | | |
| 1 5/16-12 UNF | W131212G | W1312122BN | W1312123BN | 5 | | | | |
| 1 5/16-18 UNEF | W131218G | W1312182BN | W1312183BN | 5 | | | | |
| 1 3/8-6 UNC | W137506G | W1375062BN | W1375063BN | 5 | | | | |
| 1 3/8-12 UNF | W137512G | W1375122BN | W1375123BN | 5 | | | | |
| 1 3/8-18 UNEF | W137518G | W1375182BN | W1375183BN | 5 | | | | |
| 1 7/16-12 UNF | W143712G | W1437122BN | W1437123BN | 5 | | | | |
| 1 7/16-18 UNEF | W143718G | W1437182BN | W1437183BN | 5 | | | | |
| 1 1/2-6 UNC | W150006G | W1500062BN | W1500063BN | 5 | | | | |
| 1 1/2-12 UNF | W150012G | W1500122BN | W1500123BN | 5 | | | | |
| 1 1/2-18 UNEF | W150018G | W1500182BN | W1500183BN | 5 | | | | |

UNIFIED THREAD RING GAGES



UNIFIED THREAD RING GAGES

| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HOLDER |
|--------------|------------|-------------|------------|-------------|--------|
| 0-80 UNF | R0060802AG | R0060802AN | R0060803AG | R0060803AN | 1 |
| 1-64 UNC | R0073642AG | R0073642AN | R0073643AG | R0073643AN | 1 |
| 1-72 UNF | R0073722AG | R0073722AN | R0073723AG | R0073723AN | 1 |
| 2-56 UNC | R0086562AG | R0086562AN | R0086563AG | R0086563AN | 1 |
| 2-64 UNF | R0086642AG | R0086642AN | R0086643AG | R0086643AN | 1 |
| 3-48 UNC | R0099482AG | R0099482AN | R0099483AG | R0099483AN | 1 |
| 3-56 UNF | R0099562AG | R0099562AN | R0099563AG | R0099563AN | 1 |
| 4-40 UNC | R0112402AG | R0112402AN | R0112403AG | R0112403AN | 1 |
| 4-48 UNF | R0112482AG | R0112482AN | R0112483AG | R0112483AN | 1 |
| 5-40 UNC | R0125402AG | R0125402AN | R0125403AG | R0125403AN | 1 |
| 5-44 UNF | R0125442AG | R0125442AN | R0125443AG | R0125443AN | 1 |
| 6-32 UNC | R0138322AG | R0138322AN | R0138323AG | R0138323AN | 1 |
| 6-40 UNF | R0138402AG | R0138402AN | R0138403AG | R0138403AN | 1 |
| 8-32 UNC | R0164322AG | R0164322AN | R0164323AG | R0164323AN | 1 |
| 8-36 UNF | R0164362AG | R0164362AN | R0164363AG | R0164363AN | 1 |
| 10-24 UNC | R0190242AG | R0190242AN | R0190243AG | R0190243AN | 1 |
| 10-32 UNF | R0190322AG | R0190322AN | R0190323AG | R0190323AN | 1 |
| 12-24 UNC | R0216242AG | R0216242AN | R0216243AG | R0216243AN | 1 |
| 12-28 UNF | R0216282AG | R0216282AN | R0216283AG | R0216283AN | 1 |
| 12-32 UNEF | R0216322AG | R0216322AN | R0216323AG | R0216323AN | 1 |
| 1/4-20 UNC | R0250202AG | R0250202AN | R0250203AG | R0250203AN | 2 |
| 1/4-28 UNF | R0250282AG | R0250282AN | R0250283AG | R0250283AN | 2 |
| 1/4-32 UNEF | R0250322AG | R0250322AN | R0250323AG | R0250323AN | 2 |
| 5/16-18 UNC | R0312182AG | R0312182AN | R0312183AG | R0312183AN | 2 |
| 5/16-24 UNF | R0312242AG | R0312242AN | R0312243AG | R0312243AN | 2 |
| 5/16-32 UNEF | R0312322AG | R0312322AN | R0312323AG | R0312323AN | 2 |
| 3/8-16 UNC | R0375162AG | R0375162AN | R0375163AG | R0375163AN | 3 |
| 3/8-24 UNF | R0375242AG | R0375242AN | R0375243AG | R0375243AN | 3 |
| 3/8-32 UNEF | R0375322AG | R0375322AN | R0375323AG | R0375323AN | 3 |
| 7/16-14 UNC | R0437142AG | R0437142AN | R0437143AG | R0437143AN | 3 |
| 7/16-20 UNF | R0437202AG | R0437202AN | R0437203AG | R0437203AN | 3 |
| 7/16-28 UNEF | R0437282AG | R0437282AN | R0437283AG | R0437283AN | 3 |
| 1/2-13 UNC | R0500132AG | R0500132AN | R0500133AG | R0500133AN | 3 |
| 1/2-20 UNF | R0500202AG | R0500202AN | R0500203AG | R0500203AN | 3 |
| 1/2-28 UNEF | R0500282AG | R0500282AN | R0500283AG | R0500283AN | 3 |
| 9/16-12 UNC | R0562122AG | R0562122AN | R0562123AG | R0562123AN | 4 |
| 9/16-18 UNF | R0562182AG | R0562182AN | R0562183AG | R0562183AN | 4 |
| 9/16-24 UNEF | R0562242AG | R0562242AN | R0562243AG | R0562243AN | 4 |

UNIFIED THREAD RING GAGES CONTINUED



| UNIFIED THREAD RING GAGES | | | | | |
|---------------------------|------------|-------------|------------|-------------|--------|
| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HOLDER |
| 5/8-11 UNC | R0625112AG | R0625112AN | R0625113AG | R0625113AN | 4 |
| 5/8-18 UNF | R0625182AG | R0625182AN | R0625183AG | R0625183AN | 4 |
| 5/8-24 UNEF | R0625242AG | R0625242AN | R0625243AG | R0625243AN | 4 |
| 11/16-24 UNEF | R0687242AG | R0687242AN | R0687243AG | R0687243AN | 4 |
| 3/4-10 UNC | R0750102AG | R0750102AN | R0750103AG | R0750103AN | 4 |
| 3/4-16 UNF | R0750162AG | R0750162AN | R0750163AG | R0750163AN | 4 |
| 3/4-20 UNEF | R0750202AG | R0750202AN | R0750203AG | R0750203AN | 4 |
| 13/16-20 UNEF | R0812202AG | R0812202AN | R0812203AG | R0812203AN | 4 |
| 7/8-9 UNC | R0875092AG | R0875092AN | R0875093AG | R0875093AN | 5 |
| 7/8-14 UNF | R0875142AG | R0875142AN | R0875143AG | R0875143AN | 5 |
| 7/8-20 UNEF | R0875202AG | R0875202AN | R0875203AG | R0875203AN | 5 |
| 15/16-20 UNEF | R0937202AG | R0937202AN | R0937203AG | R0937203AN | 5 |
| 1-8 UNC | R1000082AG | R1000082AN | R1000083AG | R1000083AN | 5 |
| 1-12 UNF | R1000122AG | R1000122AN | R1000123AG | R1000123AN | 5 |
| 1-14 UNS | R1000142AG | R1000142AN | R1000143AG | R1000143AN | 5 |
| 1-20 UNEF | R1000202AG | R1000202AN | R1000203AG | R1000203AN | 5 |
| 1 1/16-12 UNF | R1062122AG | R1062122AN | R1062123AG | R1062123AN | 5 |
| 1 1/16-18 UNEF | R1062182AG | R1062182AN | R1062183AG | R1062183AN | 5 |
| 1 1/8-7 UNC | R1125072AG | R1125072AN | R1125073AG | R1125073AN | 5 |
| 1 1/8-12 UNF | R1125122AG | R1125122AN | R1125123AG | R1125123AN | 5 |
| 1 1/8-18 UNEF | R1125182AG | R1125182AN | R1125183AG | R1125183AN | 5 |
| 1 3/16-12 UNF | R1187122AG | R1187122AN | R1187123AG | R1187123AN | 6 |
| 1 3/16-18 UNEF | R1187182AG | R1187182AN | R1187183AG | R1187183AN | 6 |
| 1 1/4-7 UNC | R1250072AG | R1250072AN | R1250073AG | R1250073AN | 6 |
| 1 1/4-12 UNF | R1250122AG | R1250122AN | R1250123AG | R1250123AN | 6 |
| 1 1/4-18 UNEF | R1250182AG | R1250182AN | R1250183AG | R1250183AN | 6 |
| 1 5/16-12 UNF | R1312122AG | R1312122AN | R1312123AG | R1312123AN | 6 |
| 1 5/16-18 UNEF | R1312182AG | R1312182AN | R1312183AG | R1312183AN | 6 |
| 1 3/8-6 UNC | R1375062AG | R1375062AN | R1375063AG | R1375063AN | 6 |
| 1 3/8-12 UNF | R1375122AG | R1375122AN | R1375123AG | R1375123AN | 6 |
| 1 3/8-18 UNEF | R1375182AG | R1375182AN | R1375183AG | R1375183AN | 6 |
| 1 7/16-12 UNF | R1437122AG | R1437122AN | R1437123AG | R1437123AN | 6 |
| 1 7/16-18 UNEF | R1437182AG | R1437182AN | R1437183AG | R1437183AN | 6 |
| 1 1/2-6 UNC | R1500062AG | R1500062AN | R1500063AG | R1500063AN | 6 |
| 1 1/2-12 UNF | R1500122AG | R1500122AN | R1500123AG | R1500123AN | 6 |
| 1 1/2-18 UNEF | R1500182AG | R1500182AN | R1500183AG | R1500183AN | 6 |

UNIFIED TRUNCATED THREAD SETTING PLUG GAGES



| UNIFIED TRUNCATED THREAD SETTING PLUG GAGES | | | | | |
|---|------------|------------|------------|------------|--------|
| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HANDLE |
| 0-80 UNF | S0060802AG | S0060802AN | S0060803AG | S0060803AN | 000 |
| 1-64 UNC | S0073642AG | S0073642AN | S0073643AG | S0073643AN | 000 |
| 1-72 UNF | S0073722AG | S0073722AN | S0073723AG | S0073723AN | 000 |
| 2-56 UNC | S0086562AG | S0086562AN | S0086563AG | S0086563AN | 000 |
| 2-64 UNF | S0086642AG | S0086642AN | S0086643AG | S0086643AN | 000 |
| 3-48 UNC | S0099482AG | S0099482AN | S0099483AG | S0099483AN | 000 |
| 3-56 UNF | S0099562AG | S0099562AN | S0099563AG | S0099563AN | 000 |
| 4-40 UNC | S0112402AG | S0112402AN | S0112403AG | S0112403AN | 00 |
| 4-48 UNF | S0112482AG | S0112482AN | S0012483AG | S0012483AN | 00 |
| 5-40 UNC | S0125402AG | S0125402AN | S0125403AG | S0125403AN | 00 |
| 5-44 UNF | S0125442AG | S0125442AN | S0125443AG | S0125443AN | 00 |
| 6-32 UNC | S0138322AG | S0138322AN | S0138323AG | S0138323AN | 00 |
| 6-40 UNF | S0138402AG | S0138402AN | S0138403AG | S0138403AN | 00 |
| 8-32 UNC | S0164322AG | S0164322AN | S0164323AG | S0164323AN | 0 |
| 8-36 UNF | S0164362AG | S0164362AN | S0164363AG | S0164363AN | 0 |
| 10-24 UNC | S0190242AG | S0190242AN | S0190243AG | S0190243AN | 0 |
| 10-32 UNF | S0190322AG | S0190322AN | S0190323AG | S0190323AN | 0 |
| 12-24 UNC | S0216242AG | S0216242AN | S0216243AG | S0216243AN | 0 |
| 12-28 UNF | S0216282AG | S0216282AN | S0216283AG | S0216283AN | 0 |
| 12-32 UNEF | S0216322AG | S0216322AN | S0216323AG | S0216323AN | 0 |
| 1/4-20 UNC | S0250202AG | S0250202AN | S0250203AG | S0250203AN | 1 |
| 1/4-28 UNF | S0250282AG | S0250282AN | S0250283AG | S0250283AN | 1 |
| 1/4-32 UNEF | S0250322AG | S0250322AN | S0250323AG | S0250323AN | 1 |
| 5/16-18 UNC | S0312182AG | S0312182AN | S0312183AG | S0312183AN | 1 |
| 5/16-24 UNF | S0312242AG | S0312242AN | S0312243AG | S0312243AN | 1 |
| 5/16-32 UNEF | S0312322AG | S0312322AN | S0312323AG | S0312323AN | 1 |
| 3/8-16 UNC | S0375162AG | S0375162AN | S0375163AG | S0375163AN | 2 |
| 3/8-24 UNF | S0375242AG | S0375242AN | S0375243AG | S0375243AN | 2 |
| 3/8-32 UNEF | S0375322AG | S0375322AN | S0375323AG | S0375323AN | 2 |
| 7/16-14 UNC | S0437142AG | S0437142AN | S0437143AG | S0437143AN | 2 |
| 7/16-20 UNF | S0437202AG | S0437202AN | S0437203AG | S0437203AN | 2 |
| 7/16-28 UNEF | S0437282AG | S0437282AN | S0437283AG | S0437283AN | 2 |
| 1/2-13 UNC | S0500132AG | S0500132AN | S0500133AG | S0500133AN | 2 |
| 1/2-20 UNF | S0500202AG | S0500202AN | S0500203AG | S0500203AN | 2 |
| 1/2-28 UNEF | S0500282AG | S0500282AN | S0500283AG | S0500283AN | 2 |
| 9/16-12 UNC | S0562122AG | S0562122AN | S0562123AG | S0562123AN | 3 |
| 9/16-18 UNF | S0562182AG | S0562182AN | S0562183AG | S0562183AN | 3 |
| 9/16-24 UNEF | S0562242AG | S0562242AN | S0562243AG | S0562243AN | 3 |

UNIFIED TRUNCATED THREAD SETTING PLUG GAGES CONTINUED



| UNIFIED TRUNCATED THREAD SETTING PLUG GAGES | | | | | |
|---|------------|------------|------------|------------|--------|
| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HANDLE |
| 5/8-11 UNC | S0625112AG | S0625112AN | S0625113AG | S0625113AN | 3 |
| 5/8-18 UNF | S0625182AG | S0625182AN | S0625183AG | S0625183AN | 3 |
| 5/8-24 UNEF | S0625242AG | S0625242AN | S0625243AG | S0625243AN | 3 |
| 11/16-24 UNEF | S0687242AG | S0687242AN | S0687243AG | S0687243AN | 3 |
| 3/4-10 UNC | S0750102AG | S0750102AN | S0750103AG | S0750103AN | 3 |
| 3/4-16 UNF | S0750162AG | S0750162AN | S0750163AG | S0750163AN | 3 |
| 3/4-20 UNEF | S0750202AG | S0750202AN | S0750203AG | S0750203AN | 3 |
| 13/16-20 UNEF | S0812202AG | S0812202AN | S0812203AG | S0812203AN | 3 |
| 7/8-9 UNC | S0875092AG | S0875092AN | S0875093AG | S0875093AN | 4 |
| 7/8-14 UNF | S0875142AG | S0875142AN | S0875143AG | S0875143AN | 4 |
| 7/8-20 UNEF | S0875202AG | S0875202AN | S0875203AG | S0875203AN | 4 |
| 15/16-20 UNEF | S0937202AG | S0937202AN | S0937203AG | S0937203AN | 4 |
| 1-8 UNC | S1000082AG | S1000082AN | S1000083AG | S1000083AN | 4 |
| 1-12 UNF | S1000122AG | S1000122AN | S1000123AG | S1000123AN | 4 |
| 1-14 UNS | S1000142AG | S1000142AN | S1000143AG | S1000143AN | 4 |
| 1-20 UNEF | S1000202AG | S1000202AN | S1000203AG | S1000203AN | 4 |
| 1 1/16-12 UNF | S1062122AG | S1062122AN | S1062123AG | S1062123AN | 4 |
| 1 1/16-18 UNEF | S1062182AG | S1062182AN | S1062183AG | S1062183AN | 4 |
| 1 1/8-7 UNC | S1125072AG | S1125072AN | S1125073AG | S1125073AN | 4 |
| 1 1/8-12 UNF | S1125122AG | S1125122AN | S1125123AG | S1125123AN | 4 |
| 1 1/8-18 UNEF | S1125182AG | S1125182AN | S1125183AG | S1125183AN | 4 |
| 1 3/16-12 UNF | S1187122AG | S1187122AN | S1187123AG | S1187123AN | 4 |
| 1 3/16-18 UNEF | S1187182AG | S1187182AN | S1187183AG | S1187183AN | 4 |
| 1 1/4-7 UNC | S1250072AG | S1250072AN | S1250073AG | S1250073AN | 5 |
| 1 1/4-12 UNF | S1250122AG | S1250122AN | S1250123AG | S1250123AN | 5 |
| 1 1/4-18 UNEF | S1250182AG | S1250182AN | S1250183AG | S1250183AN | 5 |
| 1 5/16-12 UNF | S1312122AG | S1312122AN | S1312123AG | S1312123AN | 5 |
| 1 5/16-18 UNEF | S1312182AG | S1312182AN | S1312183AG | S1312183AN | 5 |
| 1 3/8-6 UNC | S1375062AG | S1375062AN | S1375063AG | S1375063AN | 5 |
| 1 3/8-12 UNF | S1375122AG | S1375122AN | S1375123AG | S1375123AN | 5 |
| 1 3/8-18 UNEF | S1375182AG | S1375182AN | S1375183AG | S1375183AN | 5 |
| 1 7/16-12 UNF | S1437122AG | S1437122AN | S1437123AG | S1437123AN | 5 |
| 1 7/16-18 UNEF | S1437182AG | S1437182AN | S1437183AG | S1437183AN | 5 |
| 1 1/2-6 UNC | S1500062AG | S1500062AN | S1500063AG | S1500063AN | 5 |
| 1 1/2-12 UNF | S1500122AG | S1500122AN | S1500123AG | S1500123AN | 5 |
| 1 1/2-18 UNEF | S1500182AG | S1500182AN | S1500183AG | S1500183AN | 5 |

UNIFIED HILO THREAD SETTING PLUG GAGES



UNIFIED HILO THREAD SETTING PLUG GAGES

| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HANDLE |
|--------------|-------------|-------------|-------------|-------------|--------|
| 0-80 UNF | HL0060802AG | HL0060802AN | HL0060803AG | HL0060803AN | 000 |
| 1-64 UNC | HL0073642AG | HL0073642AN | HL0073643AG | HL0073643AN | 000 |
| 1-72 UNF | HL0073722AG | HL0073722AN | HL0073723AG | HL0073723AN | 000 |
| 2-56 UNC | HL0086562AG | HL0086562AN | HL0086563AG | HL0086563AN | 000 |
| 2-64 UNF | HL0086642AG | HL0086642AN | HL0086643AG | HL0086643AN | 000 |
| 3-48 UNC | HL0099482AG | HL0099482AN | HL0099483AG | HL0099483AN | 000 |
| 3-56 UNF | HL0099562AG | HL0099562AN | HL0099563AG | HL0099563AN | 000 |
| 4-40 UNC | HL0112402AG | HL0112402AN | HL0112403AG | HL0112403AN | 00 |
| 4-48 UNF | HL0112482AG | HL0112482AN | HL0012483AG | HL0012483AN | 00 |
| 5-40 UNC | HL0125402AG | HL0125402AN | HL0125403AG | HL0125403AN | 00 |
| 5-44 UNF | HL0125442AG | HL0125442AN | HL0125443AG | HL0125443AN | 00 |
| 6-32 UNC | HL0138322AG | HL0138322AN | HL0138323AG | HL0138323AN | 00 |
| 6-40 UNF | HL0138402AG | HL0138402AN | HL0138403AG | HL0138403AN | 00 |
| 8-32 UNC | HL0164322AG | HL0164322AN | HL0164323AG | HL0164323AN | 0 |
| 8-36 UNF | HL0164362AG | HL0164362AN | HL0164363AG | HL0164363AN | 0 |
| 10-24 UNC | HL0190242AG | HL0190242AN | HL0190243AG | HL0190243AN | 0 |
| 10-32 UNF | HL0190322AG | HL0190322AN | HL0190323AG | HL0190323AN | 0 |
| 12-24 UNC | HL0216242AG | HL0216242AN | HL0216243AG | HL0216243AN | 0 |
| 12-28 UNF | HL0216282AG | HL0216282AN | HL0216283AG | HL0216283AN | 0 |
| 12-32 UNEF | HL0216322AG | HL0216322AN | HL0216323AG | HL0216323AN | 0 |
| 1/4-20 UNC | HL0250202AG | HL0250202AN | HL0250203AG | HL0250203AN | 1 |
| 1/4-28 UNF | HL0250282AG | HL0250282AN | HL0250283AG | HL0250283AN | 1 |
| 1/4-32 UNEF | HL0250322AG | HL0250322AN | HL0250323AG | HL0250323AN | 1 |
| 5/16-18 UNC | HL0312182AG | HL0312182AN | HL0312183AG | HL0312183AN | 1 |
| 5/16-24 UNF | HL0312242AG | HL0312242AN | HL0312243AG | HL0312243AN | 1 |
| 5/16-32 UNEF | HL0312322AG | HL0312322AN | HL0312323AG | HL0312323AN | 1 |
| 3/8-16 UNC | HL0375162AG | HL0375162AN | HL0375163AG | HL0375163AN | 2 |
| 3/8-24 UNF | HL0375242AG | HL0375242AN | HL0375243AG | HL0375243AN | 2 |
| 3/8-32 UNEF | HL0375322AG | HL0375322AN | HL0375323AG | HL0375323AN | 2 |
| 7/16-14 UNC | HL0437142AG | HL0437142AN | HL0437143AG | HL0437143AN | 2 |
| 7/16-20 UNF | HL0437202AG | HL0437202AN | HL0437203AG | HL0437203AN | 2 |
| 7/16-28 UNEF | HL0437282AG | HL0437282AN | HL0437283AG | HL0437283AN | 2 |
| 1/2-13 UNC | HL0500132AG | HL0500132AN | HL0500133AG | HL0500133AN | 2 |
| 1/2-20 UNF | HL0500202AG | HL0500202AN | HL0500203AG | HL0500203AN | 2 |
| 1/2-28 UNEF | HL0500282AG | HL0500282AN | HL0500283AG | HL0500283AN | 2 |
| 9/16-12 UNC | HL0562122AG | HL0562122AN | HL0562123AG | HL0562123AN | 3 |
| 9/16-18 UNF | HL0562182AG | HL0562182AN | HL0562183AG | HL0562183AN | 3 |
| 9/16-24 UNEF | HL0562242AG | HL0562242AN | HL0562243AG | HL0562243AN | 3 |

UNIFIED HILO THREAD SETTING PLUG GAGES CONTINUED



| UNIFIED HILO THREAD SETTING PLUG GAGES | | | | | |
|--|-------------|-------------|-------------|-------------|--------|
| SIZE | 2A GO | 2A NOTGO | 3A GO | 3A NOTGO | HANDLE |
| 5/8-11 UNC | HL0625112AG | HL0625112AN | HL0625113AG | HL0625113AN | 3 |
| 5/8-18 UNF | HL0625182AG | HL0625182AN | HL0625183AG | HL0625183AN | 3 |
| 5/8-24 UNEF | HL0625242AG | HL0625242AN | HL0625243AG | HL0625243AN | 3 |
| 11/16-24 UNEF | HL0687242AG | HL0687242AN | HL0687243AG | HL0687243AN | 3 |
| 3/4-10 UNC | HL0750102AG | HL0750102AN | HL0750103AG | HL0750103AN | 3 |
| 3/4-16 UNF | HL0750162AG | HL0750162AN | HL0750163AG | HL0750163AN | 3 |
| 3/4-20 UNEF | HL0750202AG | HL0750202AN | HL0750203AG | HL0750203AN | 3 |
| 13/16-20 UNEF | HL0812202AG | HL0812202AN | HL0812203AG | HL0812203AN | 3 |
| 7/8-9 UNC | HL0875092AG | HL0875092AN | HL0875093AG | HL0875093AN | 4 |
| 7/8-14 UNF | HL0875142AG | HL0875142AN | HL0875143AG | HL0875143AN | 4 |
| 7/8-20 UNEF | HL0875202AG | HL0875202AN | HL0875203AG | HL0875203AN | 4 |
| 15/16-20 UNEF | HL0937202AG | HL0937202AN | HL0937203AG | HL0937203AN | 4 |
| 1-8 UNC | HL1000082AG | HL1000082AN | HL1000083AG | HL1000083AN | 4 |
| 1-12 UNF | HL1000122AG | HL1000122AN | HL1000123AG | HL1000123AN | 4 |
| 1-14 UNS | HL1000142AG | HL1000142AN | HL1000143AG | HL1000143AN | 4 |
| 1-20 UNEF | HL1000202AG | HL1000202AN | HL1000203AG | HL1000203AN | 4 |
| 1 1/16-12 UNF | HL1062122AG | HL1062122AN | HL1062123AG | HL1062123AN | 4 |
| 1 1/16-18 UNEF | HL1062182AG | HL1062182AN | HL1062183AG | HL1062183AN | 4 |
| 1 1/8-7 UNC | HL1125072AG | HL1125072AN | HL1125073AG | HL1125073AN | 4 |
| 1 1/8-12 UNF | HL1125122AG | HL1125122AN | HL1125123AG | HL1125123AN | 4 |
| 1 1/8-18 UNEF | HL1125182AG | HL1125182AN | HL1125183AG | HL1125183AN | 4 |
| 1 3/16-12 UNF | HL1187122AG | HL1187122AN | HL1187123AG | HL1187123AN | 4 |
| 1 3/16-18 UNEF | HL1187182AG | HL1187182AN | HL1187183AG | HL1187183AN | 4 |
| 1 1/4-7 UNC | HL1250072AG | HL1250072AN | HL1250073AG | HL1250073AN | 5 |
| 1 1/4-12 UNF | HL1250122AG | HL1250122AN | HL1250123AG | HL1250123AN | 5 |
| 1 1/4-18 UNEF | HL1250182AG | HL1250182AN | HL1250183AG | HL1250183AN | 5 |
| 1 5/16-12 UNF | HL1312122AG | HL1312122AN | HL1312123AG | HL1312123AN | 5 |
| 1 5/16-18 UNEF | HL1312182AG | HL1312182AN | HL1312183AG | HL1312183AN | 5 |
| 1 3/8-6 UNC | HL1375062AG | HL1375062AN | HL1375063AG | HL1375063AN | 5 |
| 1 3/8-12 UNF | HL1375122AG | HL1375122AN | HL1375123AG | HL1375123AN | 5 |
| 1 3/8-18 UNEF | HL1375182AG | HL1375182AN | HL1375183AG | HL1375183AN | 5 |
| 1 7/16-12 UNF | HL1437122AG | HL1437122AN | HL1437123AG | HL1437123AN | 5 |
| 1 7/16-18 UNEF | HL1437182AG | HL1437182AN | HL1437183AG | HL1437183AN | 5 |
| 1 1/2-6 UNC | HL1500062AG | HL1500062AN | HL1500063AG | HL1500063AN | 5 |
| 1 1/2-12 UNF | HL1500122AG | HL1500122AN | HL1500123AG | HL1500123AN | 5 |
| 1 1/2-18 UNEF | HL1500182AG | HL1500182AN | HL1500183AG | HL1500183AN | 5 |

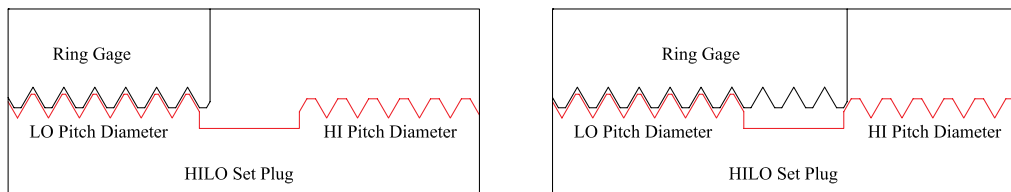
HILO™ Takes The Guesswork Out Of Setting Adjustable Ring Gages



Most times, you have to rely on an individual's sense of "good feel", "good fit", or amount of "shake", to set an adjustable ring gage with a truncated setting plug gage. And sometimes the accuracy of human judgement is highly debatable... especially if you're looking at hundreds of rejected parts.

A HILO setting plug gage provides optimum ring gage accuracy, without subjective human judgements for "fit", "feel", or "shake". It only relies on an inspector to turn it into the thread ring, and then helps the inspector make foolproof adjustments. Here's how:

First, the adjustable ring is set so it can be threaded onto the LO pitch diameter. The second, or HI pitch diameter portion indicates that the setting is too high if the ring gage can be threaded on to it more than 1½ turns. The setting is correct when the adjustable ring gage can be threaded only onto the LO pitch diameter portion, but not more than 1½ turns on the HI. It's that simple!



HILO Prolongs Ring Gage Life

How many gages has your company scrapped or sent to be reconditioned because the "feel", "fit", or "shake" wasn't right? HILO set plugs can tell you without a doubt when flanks are excessively worn, or too much "bell mouting" has affected the accuracy of your gage. Plus, since HILO plugs are designed for the full use of the pitch diameter tolerance, you can often discover additional tolerances in thread rings that couldn't be found with conventional set plug gages.

More Than Just a Setting Plug

HILO is the only plug gage available with the HI and LO portions ground and lapped with identical lead and angles. That means you can use a HILO plug gage to perform positive and dependable wear checks on solid ring gages too

HILO Thread Setting Gages For Standard and Special Threads

HILO master setting plug gages are designed to precisely size and check minimum and maximum tolerances of adjustable and solid type threaded ring gages. They're also ideal for checking flanks and angles for wear, and to determine excessive "bell mouting". Each gage is engraved to indicate: size, threads per inch, thread type, and minimum pitch diameter limit for quick identification.

For Highly Accurate Adjustable Ring Gage Settings

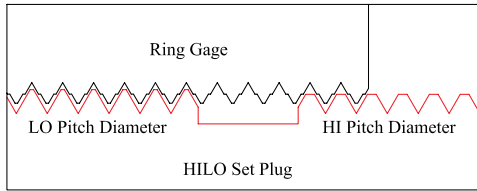
HILO set plugs take the guesswork out of setting high and low tolerances on adjustable thread ring gages. These unique setting plugs are designed with two different thread pitch diameters. The front portion is the low tolerance limit, and the back portion is the high tolerance limit. By adjusting the ring gage so it will thread onto the front portion without threading more than 1½ turns onto the back portion, a precise setting is achieved.

Worn Flank Checks

The back portion, or high limit end of each HILO gage has the outside diameter of the thread truncated in accordance with ANSI/ASME B1.2, latest edition. It automatically furnishes a check on worn flanks similar to, but more exacting than, standard truncated setting plug gages.

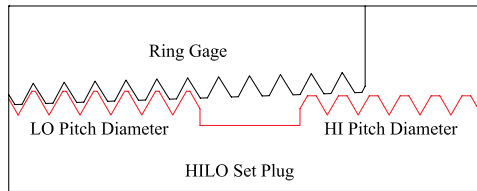
Angle Checks

In addition, HILO setting plugs can also provide a precise angle check on ring gages because of the high limit pitch diameter, and the low outside diameter on the back portion of the plug. Any worn flanks or angles will be indicated when the ring gage fits snugly on the low pitch diameter portion, and enters the high pitch diameter portion more than 1½ turns.



“Bell Mouthing” Inspection

The amount of excessive ring gage “bell mouthing” can be determined by the number of turns required for the high pitch diameter portion to enter the ring. If the high portion does not enter the ring, the ring is within tolerance.



Solid Ring Gage Checks

Since the HILO setting plug has the low and high limit portions ground and lapped with identical leads and angles, the low and high limits on solid gages can be easily and accurately checked. The HILO plug design provides a completely positive and dependable wear check, and allows for full utilization of the pitch diameter tolerance inside the ring in accordance with ANSI/ASME B1.2, latest edition.

Manufacturing Standards

| | |
|---|--|
| Material..... | AGD Standard |
| LO Pitch Diameter Tolerance (Minimum Ring Pitch Diameter Tolerance)..... | ± 0.00005" |
| HI Pitch Diameter Tolerance (Maximum Ring Pitch Diameter Tolerance)..... | + 0.0001" |
| Lead & Angles | W Tolerance |
| Major Diameter Back Portion (HI) | Truncated per ANSI/ASME B1.2 Class X, Standard Truncation |
| Major Diameter Back Portion (LO) | Full Form Class X |
| Straightness & Taper..... | ANSI/ASME B1.2, Latest Edition |



Ring Gage Set On LO
Limit Portion



Ring Gage At HI Limit
Portion



Ring Gage Is Out Of
Tolerance If The HI
Limit Portion Enters The
Ring More Than 1 1/2
Turns

CYLINDRICAL PLUG GAGES



| GAGEMAKER'S TOLERANCES | | | | | |
|-------------------------------|------------|---------|--------|--------|--------|
| SIZE RANGE | | CLASS | | | |
| From | To & Incl. | XX | X | Y | Z |
| .029 | .825 | .00002 | .00004 | .00007 | .00010 |
| .826 | 1.510 | .00003 | .00006 | .00009 | .00012 |
| 1.511 | 2.510 | .00004 | .00008 | .00012 | .00016 |
| 2.511 | 4.510 | .00005 | .00010 | .00015 | .00020 |
| 4.511 | 6.510 | .000065 | .00013 | .00019 | .00025 |
| 6.511 | 9.010 | .00008 | .00016 | .00024 | .00032 |
| 9.011 | 12.010 | .00010 | .00020 | .00030 | .00040 |

CYLINDRICAL PLUG GAGES

REVERSIBLE PLAIN PLUG GAGES

| SIZE RANGE | | CLASS XX | CLASS X | CLASS Y | CLASS Z | HANDLE |
|------------|------------|---------------|--------------|--------------|--------------|--------|
| From | To & Incl. | | | | | |
| .004 | .006 | PPR004-006XX | PPR004-006X | PPR004-006Y | PPR004-006Z | 1W |
| .007 | .010 | PPR007-010XX | PPR007-010X | PPR007-010Y | PPR007-010Z | 1W |
| .011 | .030 | PPR011-030XX | PPR011-030X | PPR011-030Y | PPR011-030Z | 1W |
| .031 | .075 | PPR031-075XX | PPR031-075X | PPR031-075Y | PPR031-075Z | 1W |
| .076 | .180 | PPR076-180XX | PPR076-180X | PPR076-180Y | PPR076-180Z | 2W |
| .181 | .281 | PPR181-281XX | PPR181-281X | PPR181-281Y | PPR181-281Z | 3W |
| .282 | .406 | PPR282-406XX | PPR282-406X | PPR282-406Y | PPR282-406Z | 4W |
| .407 | .510 | PPR407-510XX | PPR407-510X | PPR407-510Y | PPR407-510Z | 5W |
| .511 | .635 | PPR511-635XX | PPR511-635X | PPR511-635Y | PPR511-635Z | 6W |
| .636 | .760 | PPR636-760XX | PPR636-760X | PPR636-760Y | PPR636-760Z | 7W |
| .761 | 1.010 | PPR761-1010XX | PPR761-1010X | PPR761-1010Y | PPR761-1010Z | 8W |

MIDGET TRILOCK PLAIN PLUG GAGES

| | | | | | | |
|-------|-------|----------------|---------------|---------------|---------------|-------|
| .761 | .825 | PPM761-825XX | PPM761-825X | PPM761-825Y | PPM761-825Z | 2-1/2 |
| .826 | .947 | PPM826-947XX | PPM826-947X | PPM826-947Y | PPM826-947Z | 2-1/2 |
| .948 | 1.135 | PPM948-1135XX | PPM948-1135X | PPM948-1135Y | PPM948-1135Z | 3-1/2 |
| 1.136 | 1.510 | PPM1136-1510XX | PPM1136-1510X | PPM1136-1510Y | PPM1136-1510Z | 4-1/2 |

TAPERLOCK & TRILOCK PLAIN PLUG GAGES

| | | | | | | |
|-------|-------|----------------|---------------|---------------|---------------|-------|
| .060 | .105 | PPT060-105XX | PPT060-105X | PPT060-105Y | PPT060-105Z | 000 |
| .106 | .150 | PPT106-150XX | PPT106-150X | PPT106-150Y | PPT106-150Z | 00 |
| .151 | .230 | PPT151-230XX | PPT151-230X | PPT151-230Y | PPT151-230Z | 0 |
| .231 | .365 | PPT231-365XX | PPT231-365X | PPT231-365Y | PPT231-365Z | 1 |
| .366 | .510 | PPT366-510XX | PPT366-510X | PPT366-510Y | PPT366-510Z | 2 |
| .511 | .825 | PPT511-825XX | PPT511-825X | PPT511-825Y | PPT511-825Z | 3 |
| .826 | 1.135 | PPT826-1135XX | PPT826-1135X | PPT826-1135Y | PPT826-1135Z | 4 |
| 1.136 | 1.510 | PPT1136-1510XX | PPT1136-1510X | PPT1136-1510Y | PPT1136-1510Z | 5 |
| 1.511 | 2.010 | PPT1511-2010XX | PPT1511-2010X | PPT1511-2010Y | PPT1511-2010Z | 5-1/2 |
| 2.011 | 2.510 | PPT2011-2510XX | PPT2011-2510X | PPT2011-2510Y | PPT2011-2510Z | 6 |
| 2.511 | 3.010 | PPT2511-3010XX | PPT2511-3010X | PPT2511-3010Y | PPT2511-3010Z | 7 |
| 3.011 | 3.510 | PPT3011-3510XX | PPT3011-3510X | PPT3011-3510Y | PPT3011-3510Z | 7 |

Above 3.510 Quoted Upon Request

MASTER SETTING DISCS

| GAGEMAKER'S TOLERANCES | | | | | |
|------------------------|------------|---------|--------|--------|--------|
| SIZE RANGE | | CLASS | | | |
| From | To & Incl. | XX | X | Y | Z |
| .029 | .825 | .00002 | .00004 | .00007 | .00010 |
| .826 | 1.510 | .00003 | .00006 | .00009 | .00012 |
| 1.511 | 2.510 | .00004 | .00008 | .00012 | .00016 |
| 2.511 | 4.510 | .00005 | .00010 | .00015 | .00020 |
| 4.511 | 6.510 | .000065 | .00013 | .00019 | .00025 |
| 6.511 | 9.010 | .00008 | .00016 | .00024 | .00032 |
| 9.011 | 12.010 | .00010 | .00020 | .00030 | .00040 |



STYLE 1



STYLE 2



STYLE 3

| MASTER SETTING DISCS | | | | | | |
|----------------------|------------|-----------|----------------|---------------|---------------|---------------|
| SIZE RANGE | | STYLE NO. | CLASS XX | CLASS X | CLASS Y | CLASS Z |
| From | To & Incl. | | | | | |
| .150 | .240 | 1 | 1MD150-240XX | 1MD150-240X | 1MD150-240Y | NOT AVAILABLE |
| | | 2 | 2MD150-240XX | 2MD150-240X | 2MD150-240Y | |
| | | 3 | 3MD150-240XX | 3MD150-240X | 3MD150-240Y | |
| .241 | .365 | 1 | 1MD241-365XX | 1MD241-365X | 1MD241-365Y | |
| | | 2 | 2MD241-365XX | 2MD241-365X | 2MD241-365Y | |
| | | 3 | 3MD241-365XX | 3MD241-365X | 3MD241-365Y | |
| .366 | .510 | 1 | 1MD366-510XX | 1MD366-510X | 1MD366-510Y | |
| | | 2 | 2MD366-510XX | 2MD366-510X | 2MD366-510Y | |
| | | 3 | 3MD366-510XX | 3MD366-510X | 3MD366-510Y | |
| .511 | .825 | 1 | 1MD511-825XX | 1MD511-825X | 1MD511-825Y | |
| | | 2 | 2MD511-825XX | 2MD511-825X | 2MD511-825Y | |
| | | 3 | 3MD511-825XX | 3MD511-825X | 3MD511-825Y | |
| .826 | 1.135 | 1 | 1MD826-1135XX | 1MD826-1135X | 1MD826-1135Y | |
| | | 2 | 2MD826-1135XX | 2MD826-1135X | 2MD826-1135Y | |
| | | 3 | 3MD826-1135XX | 3MD826-1135X | 3MD826-1135Y | |
| 1.136 | 1.510 | 1 | 1MD1136-1510XX | 1MD1136-1510X | 1MD1136-1510Y | |
| | | 2 | 2MD1136-1510XX | 2MD1136-1510X | 2MD1136-1510Y | |
| | | 3 | 3MD1136-1510XX | 3MD1136-1510X | 3MD1136-1510Y | |
| 1.511 | 2.010 | 1 | 1MD1511-2010XX | 1MD1511-2010X | 1MD1511-2010Y | |
| | | 2 | 2MD1511-2010XX | 2MD1511-2010X | 2MD1511-2010Y | |
| | | 3 | 3MD1511-2010XX | 3MD1511-2010X | 3MD1511-2010Y | |
| 2.011 | 2.510 | 1 | 1MD2011-2510XX | 1MD2011-2510X | 1MD2011-2510Y | |
| | | 2 | 2MD2011-2510XX | 2MD2011-2510X | 2MD2011-2510Y | |
| | | 3 | 3MD2011-2510XX | 3MD2011-2510X | 3MD2011-2510Y | |
| 2.511 | 3.010 | 1 | 1MD2511-3010XX | 1MD2511-3010X | 1MD2511-3010Y | |
| | | 2 | 2MD2511-3010XX | 2MD2511-3010X | 2MD2511-3010Y | |
| | | 3 | 3MD2511-3010XX | 3MD2511-3010X | 3MD2511-3010Y | |
| 3.011 | 3.510 | 1 | 1MD3011-3510XX | 1MD3011-3510X | 1MD3011-3510Y | |
| | | 2 | 2MD3011-3510XX | 2MD3011-3510X | 2MD3011-3510Y | |
| | | 3 | 3MD3011-3510XX | 3MD3011-3510X | 3MD3011-3510Y | |
| 3.511 | 4.010 | 1 | 1MD3511-4010XX | 1MD3511-4010X | 1MD3511-4010Y | |
| | | 2 | 2MD3511-4010XX | 2MD3511-4010X | 2MD3511-4010Y | |
| | | 3 | 3MD3511-4010XX | 3MD3511-4010X | 3MD3511-4010Y | |

Above 4.010 Quoted Upon Request

CYLINDRICAL RING GAGES

GAGEMAKER'S TOLERANCES

| SIZE RANGE | | CLASS | | | |
|------------|------------|---------|--------|--------|--------|
| From | To & Incl. | XX | X | Y | Z |
| .029 | .825 | .00002 | .00004 | .00007 | .00010 |
| .826 | 1.510 | .00003 | .00006 | .00009 | .00012 |
| 1.511 | 2.510 | .00004 | .00008 | .00012 | .00016 |
| 2.511 | 4.510 | .00005 | .00010 | .00015 | .00020 |
| 4.511 | 6.510 | .000065 | .00013 | .00019 | .00025 |
| 6.511 | 9.010 | .00008 | .00016 | .00024 | .00032 |
| 9.011 | 12.010 | .00010 | .00020 | .00030 | .00040 |



STEEL CYLINDRICAL RING GAGES

| SIZE RANGE | | CLASS XX | CLASS X | CLASS Y | CLASS Z |
|------------|------------|---------------|--------------|--------------|--------------|
| From | To & Incl. | | | | |
| .015 | .020 | PR015-020XX | PR015-020X | PR015-020Y | PR015-020Z |
| .021 | .025 | PR021-025XX | PR021-025X | PR021-025Y | PR021-025Z |
| .026 | .040 | PR026-040XX | PR026-040X | PR026-040Y | PR026-040Z |
| .041 | .070 | PR041-070XX | PR041-070X | PR041-070Y | PR041-070Z |
| .071 | .150 | PR071-150XX | PR071-150X | PR071-150Y | PR071-150Z |
| .151 | .230 | PR151-230XX | PR151-230X | PR151-230Y | PR151-230Z |
| .231 | .365 | PR231-365XX | PR231-365X | PR231-365Y | PR231-365Z |
| .366 | .510 | PR366-510XX | PR366-510X | PR366-510Y | PR366-510Z |
| .511 | .825 | PR511-825XX | PR511-825X | PR511-825Y | PR511-825Z |
| .826 | 1.135 | PR826-1135XX | PR826-1135X | PR826-1135Y | PR826-1135Z |
| 1.136 | 1.510 | PR1136-1510XX | PR1136-1510X | PR1136-1510Y | PR1136-1510Z |
| 1.511 | 2.010 | PR1511-2010XX | PR1511-2010X | PR1511-2010Y | PR1511-2010Z |
| 2.011 | 2.510 | PR2011-2510XX | PR2011-2510X | PR2011-2510Y | PR2011-2510Z |
| 2.511 | 3.010 | PR2511-3010XX | PR2511-3010X | PR2511-3010Y | PR2511-3010Z |
| 3.011 | 3.510 | PR3011-3510XX | PR3011-3510X | PR3011-3510Y | PR3011-3510Z |
| 3.511 | 4.010 | PR3511-4010XX | PR3511-4010X | PR3511-4010Y | PR3511-4010Z |
| 4.011 | 4.760 | PR4011-4760XX | PR4011-4760X | PR4011-4760Y | PR4011-4760Z |

Above 4.760 Quoted Upon Request

Class XXX Quoted Upon Request

Chrome Quoted Upon Request

CARBIDE CYLINDRICAL RING GAGES

| SIZE RANGE | | CLASS XX | CLASS X | CLASS Y | CLASS Z |
|------------|------------|----------------|---------------|---------------|---------------|
| From | To & Incl. | | | | |
| .015 | .020 | PRC015-020XX | PRC015-020X | PRC015-020Y | PRC015-020Z |
| .021 | .025 | PRC021-025XX | PRC021-025X | PRC021-025Y | PRC021-025Z |
| .026 | .040 | PRC026-040XX | PRC026-040X | PRC026-040Y | PRC026-040Z |
| .041 | .070 | PRC041-070XX | PRC041-070X | PRC041-070Y | PRC041-070Z |
| .071 | .150 | PRC071-150XX | PRC071-150X | PRC071-150Y | PRC071-150Z |
| .151 | .230 | PRC151-230XX | PRC151-230X | PRC151-230Y | PRC151-230Z |
| .231 | .365 | PRC231-365XX | PRC231-365X | PRC231-365Y | PRC231-365Z |
| .366 | .510 | PRC366-510XX | PRC366-510X | PRC366-510Y | PRC366-510Z |
| .511 | .825 | PRC511-825XX | PRC511-825X | PRC511-825Y | PRC511-825Z |
| .826 | 1.135 | PRC826-1135XX | PRC826-1135X | PRC826-1135Y | PRC826-1135Z |
| 1.136 | 1.510 | PRC1136-1510XX | PRC1136-1510X | PRC1136-1510Y | PRC1136-1510Z |

Class XXX Quoted Upon Request

Master (Split) Tolerance
Go (Minus) Tolerance
Not Go (Plus) Tolerance

HELICAL COIL GAGES (STI)



| HELICAL COIL GAGES (STI) | | | | | | |
|--------------------------|---------------|--------|----------|------------|------------|--------|
| CLASS X TAPERLOCK DESIGN | | | | | | |
| SIZE | THREAD LENGTH | | GO | NOT GO | | HANDLE |
| | GO | NOT GO | 2B & 3B | 2B | 3B | |
| 2-56 UNC | 5/16 | 7/32 | H008656G | H0086562BN | G0086563BN | 00 |
| 4-40 UNC | 5/16 | 7/32 | H011240G | H0112402BN | H0112403BN | 00 |
| 4-48 UNF | 5/16 | 7/32 | H011248G | H0112482BN | H0112483BN | 00 |
| 5-40 UNC | 5/16 | 7/32 | H012540G | H0125402BN | H0125403BN | 00 |
| 6-32 UNC | 13/32 | 7/32 | H013832G | H0132322BN | H0138323BN | 0 |
| 6-40 UNF | 13/32 | 7/32 | H013840G | H0138402BN | H0138403BN | 0 |
| 8-32 UNC | 13/32 | 7/32 | H016432G | H0164322BN | G0164323BN | 0 |
| 8-36 UNF | 13/32 | 7/32 | H016436G | H0164362BN | H0164363BN | 0 |
| 10-24 UNC | 13/32 | 7/32 | H019024G | H0190242BN | H0190243BN | 0 |
| 10-32 UNF | 13/32 | 7/32 | H019032G | H0190322BN | H0190323BN | 0 |
| 12-24 UNC | 1/2 | 5/16 | H021624G | H0216242BN | H0216243BN | 1 |
| 1/4-20 UNC | 1/2 | 5/16 | H025020G | H0250202BN | H0250203BN | 1 |
| 1/4-28 UNF | 1/2 | 5/16 | H025028G | H0250282BN | H0250283BN | 1 |
| 5/16-18 UNC | 3/4 | 3/8 | H031218G | H0312182BN | H0312183BN | 2 |
| 5/16-24UNF | 3/4 | 3/8 | H031224G | H0312242BN | H0312243BN | 2 |
| 3/8-16 UNC | 3/4 | 3/8 | H037516G | H0375162BN | H0375163BN | 2 |
| 3/8-24 UNF | 3/4 | 3/8 | H037524G | H0375242BN | H0375243BN | 2 |
| 7/16-14 UNC | 3/4 | 3/8 | H043714G | H0437142BN | H0375143BN | 2 |
| 7/16-20 UNF | 3/4 | 3/8 | H043720G | H0437202BN | H0437203BN | 2 |
| 1/2-13 UNC | 7/8 | 1/2 | H050013G | H0500132BN | H0500133BN | 3 |
| 1/2-20 UNF | 7/8 | 1/2 | H050020G | H0500202BN | H0500203BN | 3 |
| 9/16-12 UNC | 7/8 | 1/2 | H056212G | H0562122BN | H0562123BN | 3 |
| 9/16-18 UNF | 7/8 | 1/2 | H056212G | H0562122BN | H0562123BN | 3 |
| 5/8-11 UNC | 7/8 | 1/2 | H062511G | H0625112BN | H0625113BN | 3 |
| 5/8-18 UNF | 7/8 | 1/2 | H062518G | H0625182BN | H0625183BN | 3 |
| 3/4-10 UNC | 1.0 | 5/8 | H075010G | H0750102BN | H0750103BN | 4 |
| 3/4-16 UNF | 1.0 | 5/8 | H075016G | H0750162BN | H0750163BN | 4 |

STRAIGHT PIPE THREAD GAGES



| NPSF | | | | | |
|----------|------------|--------|------------|------------|--------|
| SIZE | NPSF | | PLUG | | HANDLE |
| | PITCH DIA. | | GO | NOT GO | |
| | MIN. | MAX. | | | |
| 1/8-27 | .3692 | .3727 | W012527NFG | W012527NFN | 2 |
| 1/4-18 | .4852 | .4904 | W025018NFG | W025018NFN | 2 |
| 3/8-18 | .6205 | .6257 | W037518NFG | W037518NFN | 3 |
| 1/2-14 | .7700 | .7767 | W050014NFG | W050014NFN | 3 |
| 3/4-14 | .9805 | .9872 | W075014NFG | W075014NFN | 4 |
| 1-11 1/2 | 1.2284 | 1.2365 | W100099NFG | W100099NFN | 5 |

| NPSM | | | | | |
|--------------|------------|--------|----------|------------|--------|
| SIZE | NPSM-2B | | NPSM-2B | | HANDLE |
| | PITCH DIA. | | PLUG | | |
| | MIN. | MAX. | GO | NOT GO | |
| 1/8-27 | .3736 | .3783 | W012527G | W0125272BN | 2 |
| 1/4-18 | .4916 | .4974 | W025018G | W0250182BN | 2 |
| 3/8-18 | .6270 | .6329 | W037518G | W0375182BN | 3 |
| 1/2-14 | .7784 | .7851 | W050014G | W0500142BN | 3 |
| 3/4-14 | .9889 | .9958 | W075014G | W0750142BN | 4 |
| 1-11 1/2 | 1.2386 | 1.2462 | W100099G | W1000992BN | 5 |
| 1 1/4-11 1/2 | 1.5834 | 1.5912 | W125099G | W1250992BN | 5-1/2 |
| 1 1/2-11 1/2 | 1.8223 | 1.8302 | W150099G | W1500992BN | 5-1/2 |
| 2-11 1/2 | 2.2963 | 2.3044 | W200099G | W2000992BN | 6 |
| 2 1/2-8 | 2.7622 | 2.7720 | W250008G | W2500082BN | 7 |
| 3-8 | 3.3885 | 3.3984 | W300008G | W3000082BN | 7 |

| NPSM | | | | | | | |
|--------------|------------|--------|------------|------------|------------|------------|--------|
| SIZE | NPSM-2A | | NPSM-2A | | NPSM-2A | | HANDLE |
| | PITCH DIA. | | RING | | SET PLUG | | |
| | MIN. | MAX. | GO | NOT GO | GO | NOT GO | |
| 1/8-27 | .3725 | .3689 | R0125272AG | R0125272AN | S0125272AG | S0125272AN | 2 |
| 1/4-18 | .4903 | .4859 | R0250182AG | R0250182AN | S0250182AG | S0250182AN | 2 |
| 3/8-18 | .6256 | .6211 | R0375182AG | R0375182AN | S0375182AG | S0375182AN | 3 |
| 1/2-14 | .7769 | .7718 | R0500142AG | R0500142AN | S0500142AG | S0500142AN | 3 |
| 3/4-14 | .9873 | .9820 | R0750142AG | R0750142AN | S0750142AG | S0750142AN | 4 |
| 1-11 1/2 | 1.2369 | 1.2311 | R1000992AG | R1000992AN | S1000992AG | S1000992AN | 5 |
| 1 1/4-11 1/2 | 1.5816 | 1.5756 | R1250992AG | R1250992AN | S1250992AG | S1250992AN | 5-1/2 |
| 1 1/2-11 1/2 | 1.8205 | 1.8144 | R1500992AG | R1500992AN | S1500992AG | S1500992AN | 5-1/2 |
| 2-11 1/2 | 2.2944 | 2.2882 | R2000992AG | R2000992AN | S2000992AG | S2000992AN | 6 |
| 2 1/2-8 | 2.7600 | 2.7526 | R2500082AG | R2500082AN | S2500082AG | S2500082AN | 7 |
| 3-8 | 3.3862 | 3.3786 | R3000082AG | R3000082AN | S3000082AG | S3000082AN | 7 |

TAPER PIPE GAGES



| NPT | | | | |
|--------------|-----------|---------------------|-----------|---------------------|
| SIZE | PLUG GAGE | | RING GAGE | |
| | L-1 | L-3 | L-1 | L-2 |
| 1/16-27 | P006227N | Quoted Upon Request | T006227N | Quoted Upon Request |
| 1/8-27 | P012527N | | T012527N | |
| 1/4-18 | P025018N | | T025018N | |
| 3/8-18 | P037518N | | T037518N | |
| 1/2-14 | P050014N | | T050014N | |
| 3/4-14 | P075014N | | T075014N | |
| 1-11 1/2 | P100099N | | T100099N | |
| 1 1/4-11 1/2 | P125099N | | T125099N | |
| 1 1/2-11 1/2 | P150099N | | T150099N | |
| 2-11 1/2 | P200099N | | T200099N | |
| 2 1/2-8 | P250008N | | T250008N | |
| 3-8 | P300008N | | T300008N | |
| 3 1/2-8 | P350008N | | T350008N | |
| 4-8 | P400008N | | T400008N | |
| 5-8 | P500008N | | T500008N | |
| 6-8 | P600008N | | T600008N | |
| 8-8 | P800008N | T800008N | | |

NPT Gages Above 8" Quoted Upon Request

| NPTF | | | | | | | | |
|--------------|------------|------------|--------------|--------------|--------------|------------|------------|--------------|
| SIZE | PLUG GAGE | | | | | RING GAGE | | |
| | BASIC L-1 | BASIC L-3 | 3-STEP L-1 | 3-STEP L-3 | 6-STEP PLAIN | L-1 | L-2 | 6-STEP PLAIN |
| 1/16-27 | P006227NL1 | P006227NL3 | P006227NL1-3 | P006227NL3-3 | P006227N6 | T006227NL1 | T006227NL2 | T006227N6 |
| 1/8-27 | P012527NL1 | P012527NL3 | P012527NL1-3 | P012527NL3-3 | P012527N6 | T012527NL1 | T012527NL2 | T012527N6 |
| 1/4-18 | P025018NL1 | P025018NL3 | P025018NL1-3 | P025018NL3-3 | P025018N6 | T025018NL1 | T025018NL2 | T025018N6 |
| 3/8-18 | P037518NL1 | P037518NL3 | P037518NL1-3 | P037518NL3-3 | P037518N6 | T037518NL1 | T037518NL2 | T037518N6 |
| 1/2-14 | P050014NL1 | P050014NL3 | P050014NL1-3 | P050014NL3-3 | P050014N6 | T050014NL1 | T050014NL2 | T050014N6 |
| 3/4-14 | P075014NL1 | P075014NL3 | P075014NL1-3 | P075014NL3-3 | P075014N6 | T075014NL1 | T075014NL2 | T075014N6 |
| 1-11 1/2 | P100099NL1 | P100099NL3 | P100099NL1-3 | P100099NL3-3 | P100099N6 | T100099NL1 | T100099NL2 | T100099N6 |
| 1 1/4-11 1/2 | P125099NL1 | P125099NL3 | P125099NL1-3 | P125099NL3-3 | P125099N6 | T125099NL1 | T125099NL2 | T125099N6 |
| 1 1/2-11 1/2 | P150099NL1 | P150099NL3 | P150099NL1-3 | P150099NL3-3 | P150099N6 | T150099NL1 | T150099NL2 | T150099N6 |
| 2-11 1/2 | P200099NL1 | P200099NL3 | P200099NL1-3 | P200099NL3-3 | P200099N6 | T200099NL1 | T200099NL2 | T200099N6 |
| 2 1/2-8 | P250008NL1 | P250008NL3 | P250008NL1-3 | P250008NL3-3 | P250008N6 | T250008NL1 | T250008NL2 | T250008N6 |
| 3-8 | P300008NL1 | P300008NL3 | P300008NL1-3 | P300008NL3-3 | P300008N6 | T300008NL1 | T300008NL2 | T300008N6 |

NPTF Gages Above 3" Quoted Upon Request

TAPER PIPE GAGES CONTINUED



ANPT

| SIZE | PLUG GAGE | | | RING GAGE | | |
|--------------|------------|------------|--------------|------------|------------|--------------|
| | 3-STEP L-1 | 3-STEP L-3 | 6-STEP PLAIN | L-1 | L-2 | 6-STEP PLAIN |
| 1/16-27 | P006227AL1 | P006227AL3 | P006227A6 | T006227AL1 | T006227AL2 | T006227A6 |
| 1/8-27 | P012527AL1 | P012527AL3 | P012527A6 | T012527AL1 | T012527AL2 | T012527A6 |
| 1/4-18 | P025018AL1 | P025018AL3 | P025018A6 | T025018AL1 | T025018AL2 | T025018A6 |
| 3/8-18 | P037518AL1 | P037518AL3 | P037518A6 | T037518AL1 | T037518AL2 | T037518A6 |
| 1/2-14 | P050014AL1 | P050014AL3 | P050014A6 | T050014AL1 | T050014AL2 | T050014A6 |
| 3/4-14 | P075014AL1 | P075014AL3 | P075014A6 | T075014AL1 | T075014AL2 | T075014A6 |
| 1-11 1/2 | P100099AL1 | P100099AL3 | P100099A6 | T100099AL1 | T100099AL2 | T100099A6 |
| 1 1/4-11 1/2 | P125099AL1 | P125099AL3 | P125099A6 | T125099AL1 | T125099AL2 | T125099A6 |
| 1 1/2-11 1/2 | P150099AL1 | P150099AL3 | P150099A6 | T150099AL1 | T150099AL2 | T150099A6 |
| 2-11 1/2 | P200099AL1 | P200099AL3 | P200099A6 | T200099AL1 | T200099AL2 | T200099A6 |
| 2 1/2-8 | P250008AL1 | P250008AL3 | P250008A6 | T250008AL1 | T250008AL2 | T250008A6 |
| 3-8 | P300008AL1 | P300008AL3 | P300008A6 | T300008AL1 | T300008AL2 | T300008A6 |

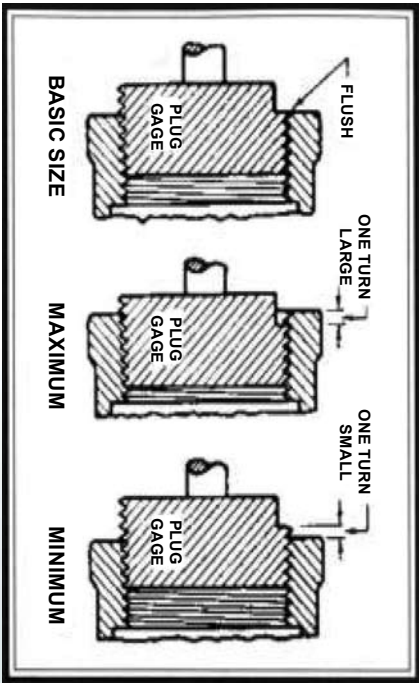
ANPT Gages Above 3" Quoted Upon Request

BASIC DIMENSIONS OF TAPER PIPE THREADS

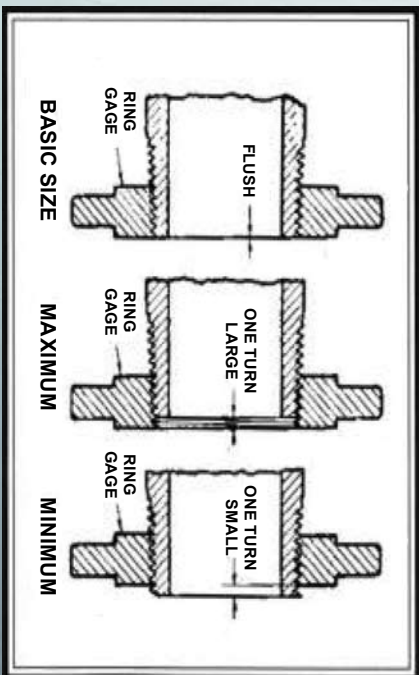
National Pipe Threads (NPT)

| Nominal Pipe Size | O.D. of Pipe | Threads Per Inch | Pitch | Major Diameters of Plug Gages | | | | | | Pitch Diameters of Plug & Ring Gages | | | | Minor Diameters of Ring Gages | | Increase In Diam./ Thread | Thickness of Ring |
|-------------------|--------------|------------------|---------|-------------------------------|-----------------|--------------|--------------|-----------------|-------------------------|--------------------------------------|-----------------|---------|--------|-------------------------------|--|---------------------------|-------------------|
| | | | | At Small End | At Gaging Notch | At Large End | At Small End | At Gaging Notch | At Large End, Plug Gage | At Small End | At Gaging Notch | 13 | 14 | | | | |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | | | | |
| 1/16 | 0.3125 | 27 | 0.03704 | 0.29289 | 0.30289 | 0.30921 | 0.27118 | 0.28118 | 0.28750 | 0.24947 | 0.25947 | 0.00231 | 0.160 | | | | |
| 1/8 | 0.405 | 27 | 0.03704 | 0.38522 | 0.39531 | 0.40171 | 0.36351 | 0.37360 | 0.38000 | 0.34180 | 0.35189 | 0.00231 | 0.1615 | | | | |
| 1/4 | 0.540 | 18 | 0.05556 | 0.51339 | 0.52763 | 0.53850 | 0.47739 | 0.49163 | 0.50250 | 0.44139 | 0.45563 | 0.00347 | 0.2278 | | | | |
| 3/8 | 0.675 | 18 | 0.05556 | 0.64801 | 0.66301 | 0.67350 | 0.61201 | 0.62701 | 0.63750 | 0.57601 | 0.59101 | 0.00347 | 0.240 | | | | |
| 1/2 | 0.840 | 14 | 0.07143 | 0.80600 | 0.82600 | 0.83936 | 0.75843 | 0.77843 | 0.79179 | 0.71086 | 0.73086 | 0.00446 | 0.320 | | | | |
| 3/4 | 1.050 | 14 | 0.07143 | 1.01525 | 1.03644 | 1.04936 | 0.96768 | 0.98887 | 1.00179 | 0.92011 | 0.94129 | 0.00446 | 0.339 | | | | |
| 1 | 1.315 | 11.5 | 0.08696 | 1.27154 | 1.29654 | 1.31422 | 1.21363 | 1.23863 | 1.25630 | 1.15572 | 1.18072 | 0.00543 | 0.400 | | | | |
| 1-1/4 | 1.660 | 11.5 | 0.08696 | 1.61504 | 1.64129 | 1.65922 | 1.55713 | 1.58338 | 1.60130 | 1.49922 | 1.52547 | 0.00543 | 0.420 | | | | |
| 1-1/2 | 1.900 | 11.5 | 0.08696 | 1.85400 | 1.88025 | 1.89922 | 1.79609 | 1.82234 | 1.84130 | 1.73817 | 1.76442 | 0.00543 | 0.420 | | | | |
| 2 | 2.375 | 11.5 | 0.08696 | 2.32693 | 2.35418 | 2.37422 | 2.26902 | 2.29627 | 2.31630 | 2.21111 | 2.23836 | 0.00543 | 0.436 | | | | |
| 2-1/2 | 2.875 | 8 | 0.12500 | 2.80278 | 2.84541 | 2.87388 | 2.71953 | 2.76216 | 2.79062 | 2.63628 | 2.67891 | 0.00781 | 0.682 | | | | |
| 3 | 3.500 | 8 | 0.12500 | 3.42388 | 3.47175 | 3.49888 | 3.34062 | 3.38850 | 3.41562 | 3.25737 | 3.30525 | 0.00781 | 0.766 | | | | |
| 3-1/2 | 4.000 | 8 | 0.12500 | 3.92075 | 3.97207 | 3.99888 | 3.83750 | 3.88881 | 3.91562 | 3.75425 | 3.80556 | 0.00781 | 0.821 | | | | |
| 4 | 4.500 | 8 | 0.12500 | 4.41762 | 4.47038 | 4.49888 | 4.33438 | 4.38712 | 4.41562 | 4.25112 | 4.30387 | 0.00781 | 0.844 | | | | |

INTERNAL THREADS



EXTERNAL THREADS



NPT DIMENSIONS

GAGING PRACTICES

TAPER PIPE THREAD GAGES

N.P.T. (National Taper Pipe)

To gage **Internal N.P.T.** taper pipe threads, screw the N.P.T. thread plug firmly into the product – do not force. The thread is within the permissible tolerance when the gaging notch of the plug is not more than one turn plus or minus from being flush with the end of the product. N.P.T. plugs are regularly furnished with the basic step only. Minimum and maximum steps can be added on request. To gage **External N.P.T.** taper pipe threads, screw the N.P.T. thread ring on to the product as far as it will go without using force. If the face of the small end of the ring is flush with the face of the product the thread is basic. The permissible tolerance is one turn plus or minus from basic.

A.N.P.T. (Aeronautical National Pipe Taper)

A.N.P.T. internal taper pipe threads are basically the same as the N.P.T. pipe threads except that for Army and Navy Aeronautical use they must be more carefully controlled for diameter, taper and thread form.

To gage **Internal A.N.P.T.** taper pipe threads, check first with the A.N.P.T. L-1 thread plug gage. This plug differs in dimensions from the N.P.T. plug and has minimum and maximum steps in addition to the basic step. If the face of the product is between the minimum and maximum steps of the plug, the product is in tolerance. The A.N.P.T. L-3 plug gage is used to check the three threads beyond the L-1 depth. As a check on taper the “reading” on the L-3 thread plug must be within one-half turn of the “reading” on the L-1 thread plug gage. The truncation is checked with a six-step plain taper plug gage. This plug has minimum and maximum truncation steps for each of the three pitch diameter conditions – Minimum, Maximum and Basic. If the L-1 plug shows the product to be basic pitch diameter, the face of the product should lie between the basic minimum and the basic maximum steps of the truncation plug. If the pitch diameter is minimum, the part should fall between the MN and MNT step. If the pitch diameter is maximum, the part should fall between the MX and MXT steps. No appreciable shake or wobble is permitted. Shaky fit indicates taper error.

To gage **External A.N.P.T.** taper pipe threads, first check with the A.N.P.T. L-1 ring. The small end of the ring must be within one turn plus or minus of being flush with the end of the product thread. Note exactly what this “standoff” is and compare it with the “standoff” obtained with the A.N.P.T. L-2 thread ring. As a check on taper the total tolerance on standoff variation between the L-1 and L-2 rings must not exceed one-half turn. The truncation is checked with a six-step plain taper ring gage. This ring has minimum and maximum truncation steps for each of the three pitch diameter conditions – Minimum, Basic, and Maximum. If the L-1 ring shows the part to be basic pitch diameter, the end of the part should fall between the B and BT steps on the six-step plain ring. If the pitch diameter is minimum, the part should fall between the MN and MNT step. If the pitch diameter is maximum, the part should fall between the MX and MXT steps. No appreciable shake or wobble should be permitted. Lead, angles and root truncation should be checked whenever possible, by projection as a check on tool wear.

See Military Standard AS71051 latest edition for complete specifications

N.P.T.F. (National Pipe Taper Dryseal Pressure-Tight Joints)

N.P.T.F. Internal taper pipe threads may be gaged in the same manner as the A.N.P.T. threads. Gages are dimensionally different, however, and must not be interchanged. The turns method may be substituted for the “standoff” method to compensate for gage and product chamfers. With the turns method, the number of turns are counted from hand tight engagement to complete release, and the gaging steps are completely disregarded. A tolerance of plus or minus one turn is permitted from the basic number of turns specified. As a check on taper, the difference in turns between the L-1 and L-3 plugs shall be within one-half turn of the difference between the basic turns engagement of the plug gages. Truncation must be within the proper limits on a six-step dryseal plain taper plug gage.

N.P.T.F. External taper pipe threads are checked in the same manner as A.N.P.T. threads. Gages are dimensionally different, however, and must not be interchanged. The turns method may be substituted for the “standoff” method to compensate for gage and product chamfers. A tolerance of plus or minus one turn is permitted from the basic number of turns specified. As a check on taper, the difference in turns engagement with the L-1 and L-2 dryseal rings shall be within one-half turn of the difference between the basic turns engagement of the ring gages.

A.N.P.T. & N.P.T.F. Pipe Thread Gages

For Gaging Internal Threads – A.N.P.T. or N.P.T.F.



**L-1 THREAD PLUG
(3 STEPS)**



**L-3 THREAD PLUG
(3 STEPS)**



**PLAIN PLUG
(6 STEPS)**

In gaging internal threads, either A.N.P.T. or N.P.T.F., there are three gaging members involved: (1) L-1 thread plug gage which checks the thread elements within hand tight engagement; (2) L-3 thread plug which checks the threads that will be engaged when wrench tight; and (3) 6-Step plain plug which is used to check the minor diameter of the female fitting.

For Gaging External Threads – A.N.P.T. or N.P.T.F.



L-1 RING (THIN)



L-2 RING (THICK)



PLAIN RING (6 STEP)

In gaging external threads, either A.N.P.T. or N.P.T.F., there are three more gages employed: (1) L-1 (thin) ring which checks the thread elements over the distance of hand tight engagement; (2) L-2 (thick) ring which checks the thread elements of those threads engaged when wrench tight; and (3) 6-Step plain ring which checks the major diameter of the male fitting.

A.N.P.T. and N.P.T.F. are not meant to be interchangeable

UNIFIED THREAD PLUG P.D. CHART



| UNIFIED THREAD GAGES | | | |
|----------------------|----------|----------|----------|
| THREAD PLUGS | | | |
| NOMINAL SIZE | GO BASIC | NOTGO 2B | NOTGO 3B |
| 0-80 UNF | .0519 | .0542 | .0536 |
| 1-64 UNC | .0629 | .0655 | .0648 |
| 1-72 UNF | .0640 | .0665 | .0659 |
| 2-56 UNC | .0744 | .0772 | .0765 |
| 2-64 UNF | .0759 | .0786 | .0779 |
| 3-48 UNC | .0855 | .0885 | .0877 |
| 3-56 UNF | .0874 | .0902 | .0895 |
| 4-40 UNC | .0958 | .0991 | .0982 |
| 4-48 UNF | .0985 | .1016 | .1008 |
| 5-40 UNC | .1088 | .1121 | .1113 |
| 5-44 UNF | .1102 | .1134 | .1126 |
| 6-32 UNC | .1177 | .1214 | .1204 |
| 6-40 UNF | .1218 | .1252 | .1243 |
| 8-32 UNC | .1437 | .1475 | .1465 |
| 8-36 UNF | .1460 | .1496 | .1487 |
| 10-24 UNC | .1629 | .1672 | .1661 |
| 10-32 UNF | .1697 | .1736 | .1726 |
| 12-24 UNC | .1889 | .1933 | .1922 |
| 12-28 UNF | .1928 | .1970 | .1959 |
| 12-32 UNEF | .1957 | .1998 | .1988 |
| 1/4-20 UNC | .2175 | .2224 | .2211 |
| 1/4-28 UNF | .2268 | .2311 | .2300 |
| 1/4-32 UNEF | .2297 | .2339 | .2328 |
| 5/16-18 UNC | .2764 | .2817 | .2803 |
| 5/16-24 UNF | .2854 | .2902 | .2890 |
| 5/16-32 UNEF | .2922 | .2964 | .2953 |
| 3/8-16 UNC | .3344 | .3401 | .3387 |
| 3/8-24 UNF | .3479 | .3528 | .3516 |
| 3/8-32 UNEF | .3547 | .3591 | .3580 |
| 7/16-14 UNC | .3911 | .3972 | .3957 |
| 7/16-20 UNF | .4050 | .4104 | .4091 |
| 7/16-28 UNEF | .4143 | .4189 | .4178 |
| 1/2-13 UNC | .4500 | .4565 | .4548 |
| 1/2-20 UNF | .4675 | .4731 | .4717 |
| 1/2-28 UNEF | .4768 | .4816 | .4804 |
| 9/16-12 UNC | .5084 | .5152 | .5135 |
| 9/16-18 UNF | .5264 | .5323 | .5308 |

| UNIFIED THREAD GAGES | | | |
|----------------------|----------|----------|----------|
| THREAD PLUGS | | | |
| NOMINAL SIZE | GO BASIC | NOTGO 2B | NOTGO 3B |
| 9/16-24 UNEF | .5354 | .5405 | .5392 |
| 5/8-11 UNC | .5660 | .5732 | .5714 |
| 5/8-18 UNF | .5889 | .5949 | .5934 |
| 5/8-24 UNEF | .5979 | .6031 | .6018 |
| 11/16-24 UNEF | .6604 | .6656 | .6643 |
| 3/4-10 UNC | .6850 | .6927 | .6907 |
| 3/4-16 UNF | .7094 | .7159 | .7143 |
| 3/4-20 UNEF | .7175 | .7232 | .7218 |
| 13/16-20 UNEF | .7800 | .7857 | .7843 |
| 7/8-9 UNC | .8028 | .8110 | .8089 |
| 7/8-14 UNF | .8286 | .8356 | .8339 |
| 7/8-20 UNEF | .8425 | .8482 | .8468 |
| 15/16-20 UNEF | .9050 | .9109 | .9094 |
| 1-8 UNC | .9188 | .9276 | .9254 |
| 1-12 UNF | .9459 | .9535 | .9516 |
| 1-14 UNS | .9536 | .9609 | .9590 |
| 1-20 UNEF | .9675 | .9734 | .9719 |
| 1 1/16-12 UNF | 1.0084 | 1.0158 | 1.0139 |
| 1 1/16-18 UNEF | 1.0264 | 1.0326 | 1.0310 |
| 1 1/8-7 UNC | 1.0322 | 1.0416 | 1.0393 |
| 1 1/8-12 UNF | 1.0709 | 1.0787 | 1.0768 |
| 1 1/8-18 UNEF | 1.0889 | 1.0951 | 1.0935 |
| 1 3/16-12 UNF | 1.1334 | 1.1409 | 1.1390 |
| 1 3/16-18 UNEF | 1.1514 | 1.1577 | 1.1561 |
| 1 1/4-7 UNC | 1.1572 | 1.1668 | 1.1644 |
| 1 1/4-12 UNF | 1.1959 | 1.2039 | 1.2019 |
| 1 1/4-18 UNEF | 1.2139 | 1.2202 | 1.2186 |
| 1 5/16-12 UNF | 1.2584 | 1.2659 | 1.2640 |
| 1 5/16-18 UNEF | 1.2764 | 1.2827 | 1.2811 |
| 1 3/8-6 UNC | 1.2667 | 1.2771 | 1.2745 |
| 1 3/8-12 UNF | 1.3209 | 1.3291 | 1.3270 |
| 1 3/8-18 UNEF | 1.3389 | 1.3452 | 1.3436 |
| 1 7/16-12 UNF | 1.3834 | 1.3910 | 1.3891 |
| 1 7/16-18 UNEF | 1.4014 | 1.4079 | 1.4062 |
| 1 1/2-6 UNC | 1.3917 | 1.4022 | 1.3996 |
| 1 1/2-12 UNF | 1.4459 | 1.4542 | 1.4522 |
| 1 1/2-18 UNEF | 1.4639 | 1.4704 | 1.4687 |

UNIFIED THREAD RING & SETTING PLUG P.D. CHART



| UNIFIED THREAD GAGES | | | | |
|-----------------------------|-------|----------|-------|----------|
| THREAD RING & SETTING PLUGS | | | | |
| NOMINAL SIZE | GO 3A | NOTGO 3A | GO 2A | NOTGO 2A |
| 0-80 UNF | .0519 | .0506 | .0514 | .0496 |
| 1-64 UNC | .0629 | .0614 | .0623 | .0603 |
| 1-72 UNF | .0640 | .0626 | .0634 | .0615 |
| 2-56 UNC | .0744 | .0728 | .0738 | .0717 |
| 2-64 UNF | .0759 | .0744 | .0753 | .0733 |
| 3-48 UNC | .0855 | .0838 | .0848 | .0825 |
| 3-56 UNF | .0874 | .0858 | .0867 | .0845 |
| 4-40 UNC | .0958 | .0939 | .0950 | .0925 |
| 4-48 UNF | .0985 | .0967 | .0978 | .0954 |
| 5-40 UNC | .1088 | .1069 | .1080 | .1054 |
| 5-44 UNF | .1102 | .1083 | .1095 | .1070 |
| 6-32 UNC | .1177 | .1156 | .1169 | .1141 |
| 6-40 UNF | .1218 | .1198 | .1210 | .1184 |
| 8-32 UNC | .1437 | .1415 | .1428 | .1399 |
| 8-36 UNF | .1460 | .1439 | .1452 | .1424 |
| 10-24 UNC | .1629 | .1604 | .1619 | .1586 |
| 10-32 UNF | .1697 | .1674 | .1688 | .1658 |
| 12-24 UNC | .1889 | .1863 | .1879 | .1845 |
| 12-28 UNF | .1928 | .1904 | .1918 | .1886 |
| 12-32 UNEF | .1957 | .1933 | .1948 | .1917 |
| 1/4-20 UNC | .2175 | .2147 | .2164 | .2127 |
| 1/4-28 UNF | .2268 | .2243 | .2258 | .2225 |
| 1/4-32 UNEF | .2297 | .2273 | .2287 | .2255 |
| 5/16-18 UNC | .2764 | .2734 | .2752 | .2712 |
| 5/16-24 UNF | .2854 | .2827 | .2843 | .2806 |
| 5/16-32 UNEF | .2922 | .2898 | .2912 | .2880 |
| 3/8-16 UNC | .3344 | .3311 | .3331 | .3287 |
| 3/8-24 UNF | .3479 | .3450 | .3468 | .3430 |
| 3/8-32 UNEF | .3547 | .3522 | .3537 | .3503 |
| 7/16-14 UNC | .3911 | .3876 | .3897 | .3850 |
| 7/16-20 UNF | .4050 | .4019 | .4037 | .3995 |
| 7/16-28 UNEF | .4143 | .4116 | .4132 | .4096 |
| 1/2-13 UNC | .4500 | .4463 | .4485 | .4435 |
| 1/2-20 UNF | .4675 | .4643 | .4662 | .4619 |
| 1/2-28 UNEF | .4768 | .4740 | .4757 | .4720 |
| 9/16-12 UNC | .5084 | .5045 | .5068 | .5016 |
| 9/16-18 UNF | .5264 | .5230 | .5250 | .5205 |

| UNIFIED THREAD GAGES | | | | |
|-----------------------------|--------|----------|--------|----------|
| THREAD RING & SETTING PLUGS | | | | |
| NOMINAL SIZE | GO 3A | NOTGO 3A | GO 2A | NOTGO 2A |
| 9/16-24 UNEF | .5354 | .5325 | .5342 | .5303 |
| 5/8-11 UNC | .5660 | .5619 | .5644 | .5589 |
| 5/8-18 UNF | .5889 | .5854 | .5875 | .5828 |
| 5/8-24 UNEF | .5979 | .5949 | .5967 | .5927 |
| 11/16-24 UNEF | .6604 | .6574 | .6592 | .6552 |
| 3/4-10 UNC | .6850 | .6806 | .6832 | .6773 |
| 3/4-16 UNF | .7094 | .7056 | .7079 | .7029 |
| 3/4-20 UNEF | .7175 | .7142 | .7162 | .7118 |
| 13/16-20 UNEF | .7800 | .7767 | .7787 | .7743 |
| 7/8-9 UNC | .8028 | .7981 | .8009 | .7946 |
| 7/8-14 UNF | .8286 | .8245 | .8270 | .8216 |
| 7/8-20 UNEF | .8425 | .8392 | .8412 | .8368 |
| 15/16-20 UNEF | .9050 | .9016 | .9036 | .8991 |
| 1-8 UNC | .9188 | .9137 | .9168 | .9100 |
| 1-12 UNF | .9459 | .9415 | .9441 | .9382 |
| 1-14 UNS | .9536 | .9494 | .9519 | .9463 |
| 1-20 UNEF | .9675 | .9641 | .9661 | .9616 |
| 1 1/16-12 UNF | 1.0084 | 1.0042 | 1.0067 | 1.0010 |
| 1 1/16-18 UNEF | 1.0264 | 1.0228 | 1.0250 | 1.0203 |
| 1 1/8-7 UNC | 1.0322 | 1.0268 | 1.0300 | 1.0228 |
| 1 1/8-12 UNF | 1.0709 | 1.0664 | 1.0691 | 1.0631 |
| 1 1/8-18 UNEF | 1.0889 | 1.0853 | 1.0875 | 1.0828 |
| 1 3/16-12 UNF | 1.1334 | 1.1291 | 1.1317 | 1.1259 |
| 1 3/16-18 UNEF | 1.1514 | 1.1478 | 1.1499 | 1.1450 |
| 1 1/4-7 UNC | 1.1572 | 1.1517 | 1.1550 | 1.1476 |
| 1 1/4-12 UNF | 1.1959 | 1.1913 | 1.1941 | 1.1879 |
| 1 1/4-18 UNEF | 1.2139 | 1.2103 | 1.2124 | 1.2075 |
| 1 5/16-12 UNF | 1.2584 | 1.2541 | 1.2567 | 1.2509 |
| 1 5/16-18 UNEF | 1.2764 | 1.2728 | 1.2749 | 1.2700 |
| 1 3/8-6 UNC | 1.2667 | 1.2607 | 1.2643 | 1.2563 |
| 1 3/8-12 UNF | 1.3209 | 1.3162 | 1.3190 | 1.3127 |
| 1 3/8-18 UNEF | 1.3389 | 1.3353 | 1.3374 | 1.3325 |
| 1 7/16-12 UNF | 1.3834 | 1.3790 | 1.3816 | 1.3757 |
| 1 7/16-18 UNEF | 1.4014 | 1.3977 | 1.3999 | 1.3949 |
| 1 1/2-6 UNC | 1.3917 | 1.3856 | 1.3893 | 1.3812 |
| 1 1/2-12 UNF | 1.4459 | 1.4411 | 1.4440 | 1.4376 |
| 1 1/2-18 UNEF | 1.4639 | 1.4602 | 1.4624 | 1.4574 |

METRIC THREAD PLUG P.D. CHART



| METRIC THREAD GAGES | | | | |
|---------------------|--------|----------|--------------|----------|
| THREAD PLUGS | | | | |
| NOMINAL SIZE | METRIC | | DECIMAL REF. | |
| | GO 6H | NOTGO 6H | GO 6H | NOTGO 6H |
| 1.6 x .35 | 1.373 | 1.458 | .05406 | .05740 |
| 1.8 x .35 | 1.573 | 1.658 | .06193 | .06528 |
| 2 x .4 | 1.740 | 1.830 | .06850 | .07205 |
| 2.2 x .45 | 1.908 | 2.003 | .07512 | .07886 |
| 2.5 x .45 | 2.208 | 2.303 | .08693 | .09067 |
| 3 x .5 | 2.675 | 2.775 | .10531 | .10925 |
| 3.5 x .6 | 3.110 | 3.222 | .12244 | .12685 |
| 4 x .7 | 3.545 | 3.663 | .13957 | .14421 |
| 4.5 x .75 | 4.013 | 4.131 | .15799 | .16264 |
| 5 x .8 | 4.480 | 4.605 | .17638 | .18130 |
| 5.5 x .75 | 5.013 | 5.131 | .19736 | .20201 |
| 6 x 1.0 | 5.350 | 5.500 | .21063 | .21654 |
| 6.3 x 1.0 | 5.650 | 5.800 | .22244 | .22835 |
| 7 x 1.0 | 6.350 | 6.500 | .25000 | .25591 |
| 8 x 1.25 | 7.188 | 7.348 | .28299 | .28929 |
| 8 x 1.0 | 7.350 | 7.500 | .28937 | .29528 |
| 9 x 1.25 | 8.188 | 8.348 | .32236 | .32866 |
| 10 x .75 | 9.513 | 9.645 | .37453 | .37972 |
| 10 x 1.5 | 9.026 | 9.206 | .35535 | .36244 |
| 10 x 1.25 | 9.188 | 9.348 | .36173 | .36803 |
| 11 x 1.5 | 10.026 | 10.206 | .39472 | .40181 |
| 12 x 1.0 | 11.350 | 11.510 | .44685 | .45315 |
| 12 x 1.5 | 11.026 | 11.216 | .43409 | .44157 |
| 12 x 1.75 | 10.863 | 11.063 | .42768 | .43555 |
| 12 x 1.25 | 11.188 | 11.368 | .44047 | .44756 |
| 14 x 2.0 | 12.701 | 12.913 | .50004 | .50838 |
| 14 x 1.5 | 13.026 | 13.216 | .51283 | .52031 |
| 15 x 1.5 | 14.026 | 14.216 | .55220 | .55968 |
| 15 x 1.0 | 14.350 | 14.510 | .56496 | .57126 |
| 16 x 2.0 | 14.701 | 14.913 | .57878 | .58712 |
| 16 x 1.5 | 15.026 | 15.216 | .59157 | .59905 |
| 17 x 1.0 | 16.350 | 16.510 | .54370 | .65000 |

| METRIC THREAD GAGES | | | | |
|---------------------|--------|----------|--------------|----------|
| THREAD PLUGS | | | | |
| NOMINAL SIZE | METRIC | | DECIMAL REF. | |
| | GO 6H | NOTGO 6H | GO 6H | NOTGO 6H |
| 17 x 1.5 | 16.026 | 16.216 | .63094 | .63842 |
| 18 x 2.5 | 16.376 | 16.600 | .64472 | .65354 |
| 18 x 1.5 | 17.026 | 17.216 | .67031 | .67779 |
| 20 x 1.0 | 19.350 | 19.510 | .76181 | .76811 |
| 20 x 2.5 | 18.376 | 18.600 | .72346 | .73228 |
| 20 x 1.5 | 19.026 | 19.216 | .74905 | .75653 |
| 22 x 2.5 | 20.376 | 20.600 | .80220 | .81102 |
| 22 x 1.5 | 21.026 | 21.216 | .82779 | .83527 |
| 24 x 3.0 | 22.051 | 22.316 | .86815 | .87858 |
| 24 x 2.0 | 22.701 | 22.925 | .89374 | .90256 |
| 25 x 2.0 | 23.701 | 23.925 | .93311 | .94193 |
| 25 x 1.5 | 24.026 | 24.226 | .94590 | .95378 |
| 26 x 1.5 | 25.026 | 25.226 | .98527 | .99315 |
| 26 x 1.0 | 25.350 | 25.520 | .99803 | 1.00472 |
| 27 x 3.0 | 25.051 | 25.316 | .98626 | .99669 |
| 27 x 2.0 | 25.701 | 25.925 | 1.01185 | 1.02067 |
| 28 x 2.0 | 26.701 | 26.925 | 1.05122 | 1.06004 |
| 28 x 1.5 | 27.026 | 27.226 | 1.06401 | 1.07189 |
| 28 x 1.0 | 27.350 | 27.520 | 1.07677 | 1.08346 |
| 30 x 1.5 | 29.026 | 29.226 | 1.14276 | 1.15063 |
| 30 x 3.5 | 27.727 | 28.007 | 1.09161 | 1.10264 |
| 30 x 2.0 | 28.701 | 28.925 | 1.12996 | 1.13878 |
| 32 x 2.0 | 30.701 | 30.925 | 1.20870 | 1.21752 |
| 32 x 1.5 | 31.026 | 31.226 | 1.22149 | 1.22937 |
| 33 x 3.5 | 30.727 | 31.007 | 1.20972 | 1.22075 |
| 33 x 2.0 | 31.701 | 31.925 | 1.24807 | 1.25689 |
| 35 x 1.5 | 34.026 | 34.226 | 1.33960 | 1.34748 |
| 36 x 2.0 | 34.701 | 34.925 | 1.36618 | 1.37500 |
| 36 x 4.0 | 33.402 | 33.702 | 1.31504 | 1.32685 |
| 36 x 3.0 | 34.051 | 34.316 | 1.34059 | 1.35102 |
| 38 x 1.5 | 37.026 | 37.226 | 1.45771 | 1.46559 |
| 39 x 2.0 | 37.701 | 37.925 | 1.48429 | 1.49311 |

METRIC THREAD RING & SETTING PLUG P.D. CHART



| METRIC THREAD GAGES | | | | |
|-----------------------------|--------|----------|--------------|----------|
| THREAD RING & SETTING PLUGS | | | | |
| NOMINAL SIZE | METRIC | | DECIMAL REF. | |
| | GO 6g | NOTGO 6g | GO 6g | NOTGO 6g |
| 1.6 x .35 | 1.354 | 1.291 | .05331 | .05083 |
| 1.8 x .35 | 1.554 | 1.491 | .06118 | .05870 |
| 2 x .4 | 1.721 | 1.654 | .06776 | .06512 |
| 2.2 x .45 | 1.888 | 1.817 | .07433 | .07154 |
| 2.5 x .45 | 2.188 | 2.117 | .08614 | .08335 |
| 3 x .5 | 2.655 | 2.580 | .10453 | .10157 |
| 3.5 x .6 | 3.089 | 3.004 | .12161 | .11827 |
| 4 x .7 | 3.523 | 3.433 | .13870 | .13516 |
| 4.5 x .75 | 3.991 | 3.901 | .15713 | .15358 |
| 5 x .8 | 4.456 | 4.361 | .17543 | .17169 |
| 5.5 x .75 | 4.991 | 4.901 | .19650 | .19295 |
| 6 x 1.0 | 5.324 | 5.212 | .20961 | .20520 |
| 6.3 x 1.0 | 5.624 | 5.512 | .22142 | .21701 |
| 7 x 1.0 | 6.324 | 6.212 | .24898 | .24457 |
| 8 x 1.25 | 7.160 | 7.042 | .28189 | .27724 |
| 8 x 1.0 | 7.324 | 7.212 | .28835 | .28394 |
| 9 x 1.25 | 8.160 | 8.042 | .32126 | .31661 |
| 10 x .75 | 9.491 | 9.391 | .37366 | .36972 |
| 10 x 1.5 | 8.994 | 8.862 | .35409 | .34890 |
| 10 x 1.25 | 9.160 | 9.042 | .36063 | .35598 |
| 11 x 1.5 | 9.994 | 9.862 | .39346 | .38827 |
| 12 x 1.0 | 11.324 | 11.206 | .44583 | .44118 |
| 12 x 1.5 | 10.994 | 10.854 | .43283 | .42732 |
| 12 x 1.75 | 10.829 | 10.679 | .42634 | .42043 |
| 12 x 1.25 | 11.160 | 11.028 | .43937 | .43417 |
| 14 x 2.0 | 12.663 | 12.503 | .49854 | .49224 |
| 14 x 1.5 | 12.994 | 12.854 | .51157 | .50606 |
| 15 x 1.5 | 13.994 | 13.854 | .55094 | .54543 |
| 15 x 1.0 | 14.324 | 14.206 | .56394 | .55929 |
| 16 x 2.0 | 14.663 | 14.503 | .57728 | .57098 |
| 16 x 1.5 | 14.994 | 14.854 | .59031 | .58480 |
| 17 x 1.0 | 16.324 | 16.206 | .64268 | .63803 |

| METRIC THREAD GAGES | | | | |
|-----------------------------|--------|----------|--------------|----------|
| THREAD RING & SETTING PLUGS | | | | |
| NOMINAL SIZE | METRIC | | DECIMAL REF. | |
| | GO 6g | NOTGO 6g | GO 6g | NOTGO 6g |
| 17 x 1.5 | 15.994 | 15.854 | .62968 | .62417 |
| 18 x 2.5 | 16.334 | 16.164 | .64307 | .63638 |
| 18 x 1.5 | 16.994 | 16.854 | .66905 | .66354 |
| 20 x 1.0 | 19.324 | 19.206 | .76079 | .75614 |
| 20 x 2.5 | 18.334 | 18.164 | .72181 | .71512 |
| 20 x 1.5 | 18.994 | 18.854 | .74779 | .74228 |
| 22 x 2.5 | 20.334 | 20.164 | .80055 | .79386 |
| 22 x 1.5 | 20.994 | 20.854 | .82653 | .82102 |
| 24 x 3.0 | 22.003 | 21.803 | .86626 | .85838 |
| 24 x 2.0 | 22.663 | 22.493 | .89224 | .88555 |
| 25 x 2.0 | 23.663 | 23.493 | .93161 | .92492 |
| 25 x 1.5 | 23.994 | 23.844 | .94464 | .93874 |
| 26 x 1.5 | 24.994 | 24.844 | .98401 | .97811 |
| 26 x 1.0 | 25.324 | 25.199 | .99701 | .99209 |
| 27 x 3.0 | 25.003 | 24.803 | .98437 | .97649 |
| 27 x 2.0 | 25.663 | 25.493 | 1.01035 | 1.00366 |
| 28 x 2.0 | 26.663 | 26.493 | 1.04972 | 1.04303 |
| 28 x 1.5 | 26.994 | 26.844 | 1.07625 | 1.05684 |
| 28 x 1.0 | 27.324 | 27.199 | 1.07575 | 1.07082 |
| 30 x 1.5 | 28.994 | 28.844 | 1.14150 | 1.13559 |
| 30 x 3.5 | 27.674 | 27.462 | 1.08953 | 1.08118 |
| 30 x 2.0 | 28.663 | 28.493 | 1.12846 | 1.12177 |
| 32 x 2.0 | 30.663 | 30.493 | 1.20720 | 1.20051 |
| 32 x 1.5 | 30.994 | 30.844 | 1.22023 | 1.21432 |
| 33 x 3.5 | 30.674 | 30.462 | 1.20764 | 1.19929 |
| 33 x 2.0 | 31.663 | 31.493 | 1.24657 | 1.23988 |
| 35 x 1.5 | 33.994 | 33.844 | 1.33834 | 1.33244 |
| 36 x 2.0 | 34.663 | 34.493 | 1.36469 | 1.35799 |
| 36 x 4.0 | 33.342 | 33.118 | 1.31267 | 1.30386 |
| 36 x 3.0 | 34.003 | 33.803 | 1.33870 | 1.33082 |
| 38 x 1.5 | 36.994 | 36.844 | 1.45645 | 1.45055 |
| 39 x 2.0 | 37.663 | 37.493 | 1.48280 | 1.47610 |

X TOLERANCE TABLE

X TOLERANCE

AMERICAN NATIONAL and UNIFIED FORM THREADS

For "GO" and "NOT GO" Thread Gages

| TPI | LEAD | HALF ANGLE | MAJOR or MINOR DIAMETER | | PITCH DIAMETER | | |
|-----|--------|------------|-------------------------|---------------|---------------------|--------------------------|----------------------|
| | + - | + - | To and Incl. 4" | Above 4" Dia. | To and Incl. 1 1/2" | Above 1 1/2" to 4" Incl. | Above 4" to 8" Incl. |
| 80 | .0002 | 30 min | .0003 | | .0002 | | |
| 72 | .0002 | 30 min | .0003 | | .0002 | | |
| 64 | .0002 | 30 min | .0004 | | .0002 | | |
| 56 | .0002 | 30 min | .0004 | | .0002 | .0003 | |
| 48 | .0002 | 30 min | .0004 | | .0002 | .0003 | |
| 44 | .0002 | 20 min | .0004 | | .0002 | .0003 | |
| 40 | .0002 | 20 min | .0004 | | .0002 | .0003 | |
| 36 | .0002 | 20 min | .0004 | | .0002 | .0003 | |
| 32 | .0003 | 15 min | .0005 | .0007 | .0003 | .0004 | .0005 |
| 28 | .0003 | 15 min | .0005 | .0007 | .0003 | .0004 | .0005 |
| 24 | .0003 | 15 min | .0005 | .0007 | .0003 | .0004 | .0005 |
| 20 | .0003 | 15 min | .0005 | .0007 | .0003 | .0004 | .0005 |
| 18 | .0003 | 10 min | .0005 | .0007 | .0003 | .0004 | .0005 |
| 16 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 14 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 13 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 12 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 11 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 10 | .0003 | 10 min | .0006 | .0009 | .0003 | .0004 | .0006 |
| 9 | .0003 | 10 min | .0007 | .0011 | .0003 | .0004 | .0006 |
| 8 | .0004 | 5 min | .0007 | .0011 | .0004 | .0005 | .0006 |
| 7 | .0004 | 5 min | .0007 | .0011 | .0004 | .0005 | .0006 |
| 6 | .0004 | 5 min | .0008 | .0013 | .0004 | .0005 | .0006 |
| 5 | .0004 | 5 min | .0008 | .0013 | | .0005 | .0006 |
| 4.5 | .0004 | 5 min | .0008 | .0013 | | .0005 | .0006 |
| 4 | .0004 | 5 min | .0009 | .0015 | | .0005 | .0006 |

Thread Gages are made to Class X tolerances unless otherwise specified on orders or drawings

DIRECTION OF TOLERANCES

| | MAJOR DIAMETER FULL FORM | MAJOR DIAMETER TRUNCATED SECTION | PITCH DIAMETER | MINOR DIAMETER |
|--------------------|-----------------------------|-------------------------------------|-------------------|-------------------|
| "GO" Work Plug | Plus | | Plus | |
| "NOT GO" Work Plug | Minus | | Minus | |
| "GO" Ring | | | Minus | |
| "NOT GO" Ring | | | Plus | Minus |
| "GO" Set Plug | Plus | Minus | Minus | Plus |
| "NOT GO" Set Plug | Plus | Minus | Plus | |

W TOLERANCE TABLE

| W TOLERANCE | | | | | | | | | | | | | | |
|--|----------------------|-----------------|------------|-------------------------|------------------|----------|-----------------|----------------------|--------------------|----------------|----------------------------|----------------------|--------------------|----------------|
| AMERICAN NATIONAL and UNIFIED FORM THREADS | | | | | | | | | | | | | | |
| For "GO" and "NOT GO" Thread Gages | | | | | | | | | | | | | | |
| TPI | LEAD | | HALF ANGLE | MAJOR or MINOR DIAMETER | | | PITCH DIAMETER | | | | TOTAL CUMULATIVE TOLERANCE | | | |
| | To & Incl. 1/2" Dia. | Above 1/2" Dia. | + - | To & Incl. 1/2" | Above 1/2" to 4" | Above 4" | To & Incl. 1/2" | Above 1/2" to 1 1/2" | Above 1 1/2" to 4" | Above 4" to 8" | To & Incl. 1/2" | Above 1/2" to 1 1/2" | Above 1 1/2" to 4" | Above 4" to 8" |
| 80 | .0001 | .00015 | 20 min | .0003 | .0003 | | .0001 | .00015 | | | .00038 | .00052 | | |
| 72 | .0001 | .00015 | 20 min | .0003 | .0003 | | .0001 | .00015 | | | .00039 | .00053 | | |
| 64 | .0001 | .00015 | 20 min | .0003 | .0004 | | .0001 | .00015 | | | .00041 | .00055 | | |
| 56 | .0001 | .00015 | 20 min | .0003 | .0004 | | .0001 | .00015 | .0002 | | .00043 | .00057 | .00062 | |
| 48 | .0001 | .00015 | 18 min | .0003 | .0004 | | .0001 | .00015 | .0002 | | .00044 | .00057 | .00062 | |
| 44 | .0001 | .00015 | 15 min | .0003 | .0004 | | .0001 | .00015 | .0002 | | .00042 | .00056 | .00061 | |
| 40 | .0001 | .00015 | 15 min | .0003 | .0004 | | .0001 | .00015 | .0002 | | .00044 | .00057 | .00062 | |
| 36 | .0001 | .00015 | 12 min | .0003 | .0004 | | .0001 | .00015 | .0002 | | .00042 | .00056 | .00061 | |
| 32 | .0001 | .00015 | 12 min | .0003 | .0005 | .0007 | .0001 | .00015 | .0002 | .00025 | .00044 | .00057 | .00062 | .00067 |
| 28 | .00015 | .00015 | 8 min | .0005 | .0005 | .0007 | .0001 | .00015 | .0002 | .00025 | .00048 | .00053 | .00058 | .00063 |
| 24 | .00015 | .00015 | 8 min | .0005 | .0005 | .0007 | .0001 | .00015 | .0002 | .00025 | .00051 | .00056 | .00061 | .00066 |
| 20 | .00015 | .00015 | 8 min | .0005 | .0005 | .0007 | .0001 | .00015 | .0002 | .00025 | .00053 | .00058 | .00063 | .00068 |
| 18 | .00015 | .00015 | 8 min | .0005 | .0005 | .0007 | .0001 | .00015 | .0002 | .00025 | .00055 | .00060 | .00065 | .00070 |
| 16 | .00015 | .00015 | 8 min | .0006 | .0006 | .0009 | .0001 | .0002 | .00025 | .0003 | .00058 | .00068 | .00073 | .00078 |
| 14 | .0002 | .0002 | 6 min | .0006 | .0006 | .0009 | .00015 | .0002 | .00025 | .0003 | .00068 | .00073 | .00078 | .00083 |
| 13 | .0002 | .0002 | 6 min | .0006 | .0006 | .0009 | .00015 | .0002 | .00025 | .0003 | .00070 | .00075 | .00080 | .00085 |
| 12 | .0002 | .0002 | 6 min | .0006 | .0006 | .0009 | .00015 | .0002 | .00025 | .0003 | .00071 | .00076 | .00081 | .00086 |
| 11 | .0002 | .0002 | 6 min | .0006 | .0006 | .0009 | .00015 | .0002 | .00025 | .0003 | .00073 | .00078 | .00083 | .00088 |
| 10 | | .00025 | 6 min | | .0006 | .0009 | | .0002 | .00025 | .0003 | | .00089 | .00094 | .00099 |
| 9 | | .00025 | 6 min | | .0007 | .0011 | | .0002 | .00025 | .0003 | | .00092 | .00097 | .00102 |
| 8 | | .00025 | 5 min | | .0007 | .0011 | | .0002 | .00025 | .0003 | | .00091 | .00096 | .00101 |
| 7 | | .0003 | 5 min | | .0007 | .0011 | | .0002 | .00025 | .0003 | | .00103 | .00108 | .00113 |
| 6 | | .0003 | 5 min | | .0008 | .0013 | | .0002 | .00025 | .0003 | | .00108 | .00113 | .00118 |
| 5 | | .0003 | 4 min | | .0008 | .0013 | | | .00025 | .0003 | | | .00112 | .00117 |
| 4.5 | | .0003 | 4 min | | .0008 | .0013 | | | .00025 | .0003 | | | .00116 | .00121 |
| 4 | | .0003 | 4 min | | .0009 | .0015 | | | .00025 | .0003 | | | .00121 | .00126 |

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