



11. GAUGE

■ THREAD PLUG GAUGES



■ TAPER THREAD RING GAUGES



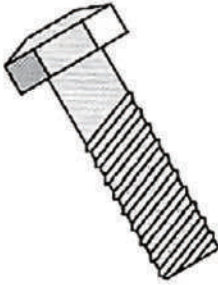

■ THREAD RING GAUGES



Limit Gauges For Screw Thread

To determine thread standard and class of screw thread limit gauges, threads are tested by the two limit method GO and NOT GO system. For the NOT GO side there is a specified JIS method and standard, but no ISO classification.

Symbols of gauges for screw thread

Screw thread to be inspected		ISO		Current JIS	
		Gauge type	Symbol	Gauge type	Symbol
External thread 	Pitch diameter	Go screw ring gauge	GR	GO screw ring gauge	GR
		Not go screw ring gauge	NR	NOT GO screw ring gauge for machine work	WE
				NOT GO screw ring gauge for inspection	IR
	Major diameter	Plain GO ring gauge for major diameter	PR go	Limit snap gauge for machine work	WS
		Plain NOT GO ring gauge for major diameter	PR not-go	Limit snap gauge for inspection	IS
		Plain caliper gauge for major diameter	PC		
Internal thread 	Pitch diameter	GO screw plug gauge	GP	GO screw plug gauge	GP
		NOT GO screw plug gauge	NP	NOT GO screw plug gauge for machine work	WP
				NOT GO screw plug gauge for inspection	IP
	Minor diameter	Plain plug gauge for minor diameter	PP	Limit plug gauge for machine work	WM
				Limit plug gauge for inspection	IM



Limit Gauges For Screw Thread

Mutually related positions of external screw thread and internal screw thread limit gauge and gauge for checking explanation figure.

Example: M3 X 0.5 for ISO 6H 6g and current JIS class 2.

