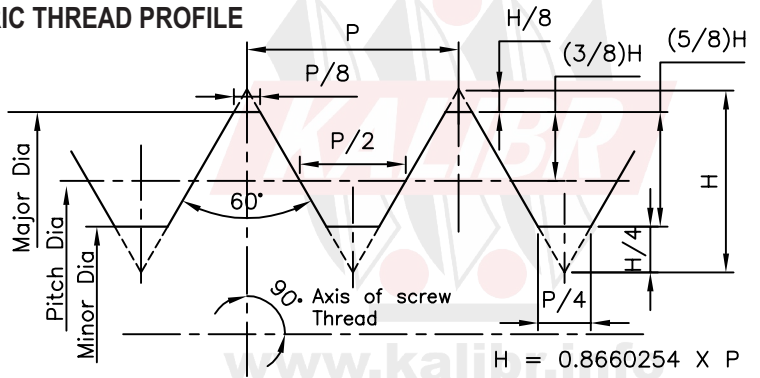


ISO METRIC THREADS

Application : General purpose Fastening, most commonly used threads.



ISO METRIC THREAD PROFILE



SPECIFICATION:

ISO standard : Basic Dimensions : ISO 965 Part 1,2,3 - 1998
Gauging Practice : ISO 1502 - 1996

Indian standard : Basic Dimensions: IS 14962 Part 1,2,3 - 2001
Gauging Practice: IS 2334- 2001.

DIN standard : Basic Dimensions & Gauging Practice: DIN 13-1999

JIS standard : Basic Dimensions: JIS B0205 & JIS B 0209
Gauging Practice: JIS B 0251-1998*

ANSI standard: Basic Dimensions: ANSI/ASME B 1.13 M

Gauge Dimensions: ANSI / ASME B 1.16 M - 1984.

BS standard : Basic Dimensions: B.S. 3643 Part I & II - 2007

Gauging Practice: B.S 919 Part III - 2007.

ANSI & BS standards use unilateral Tolerances for gauges.

These gauges are manufactured only against specific customer order.

We require Minimum Ordering quantity for these.

*See foot note for JIS Standard, JIS B 0251-1975 & JIS B0252 -1996.

MANUFACTURING RANGE

Gauge Type	Diameter Range	Pitches in mm	Tolerance Class
Thread Plug Gauges.	1.6mm - 355 mm	0.35, 0.4, 0.45, 0.5, 0.6, 0.7, 0.75, 0.8, 1, 1.25, 1.5, 1.75, 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, Pitches above 6mm up to 12 mm can be supplied based on customer request.	As given in below Table
Thread Ring Gauges.	2 mm - 285 mm	0.4, 0.45, 0.5, 0.6, 0.7, 0.75, 0.8, 1, 1.25, 1.5, 1.75, 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, Pitches above 6mm up to 12 mm can be supplied based on customer request.	As given in below Table
Plain Plugs to check Minor Diameter of Internal Threads	1.6mm - 285 mm		
Plain Rings to check Major Diameter of External Threads.	2 mm - 285 mm		
Check Plug Gauges	To check NEW Go & Nogo Ring Gauges as given above.		
Wear Check Plug Gauges	To check / calibrate USED Go & Nogo Ring Gauges as given above.		
Check Ring Gauges	To check NEW Go & Nogo Plug Gauges as given above.		
Wear Check Ring Gauges	To check / calibrate USED Go & Nogo Plug Gauges as given above.		

Recommended Tolerance classes for Internal Threads (Plug Gauges)

	Tolerance position 'G'			Tolerance position 'H'		
	S	N	L	S	N	L
Fine	-	-	-	4H	5H	6H
Medium	(5G)	6G	(7G)	5H	6H	7H
Coarse	-	(7G)	(8G)	-	7H	8H

S- Short length of Thread engagement
N – Normal length of Thread engagement
L - Long length of Thread engagement

Recommended Tolerance classes for External Threads (Ring Gauges)

	Tolerance position 'e'			Tolerance position 'f'			Tolerance position 'g'			Tolerance position 'h'		
	S	N	L	S	N	L	S	N	L	S	N	L
Fine	-	-	-	-	-	-	-	(4g)	(5g4g)	(3h4h)	4h	(5h4h)
Medium	-	6e	(7e6e)	-	6f	-	(5g6g)	6g	(7g6g)	(5h6h)	6h	(7h6h)
Coarse	-	(8e)	(9e8e)	-	-	-	-	8g	(9g8g)	-	-	-

Tolerance classes in bold are first choice,
Tolerance classes in normal print are second choice
Tolerance classes in parentheses are third choice.

ISO METRIC THREADS

Application : General purpose Fastening, most commonly used threads.

☛ We manufacture ISO Metric Gauges with,

- a) customer specified Pitch Diameters.
- b) modified pitch diameters to check **components Before coating/ Plating** OR **components After coating / plating**.

* **JIS standard : Gauging Practice: JIS B 0251-1975 & JIS B 0252-1996.**

Tolerance Class – I, II, & III & two grades Machine work & Inspection are recommended.

Gauge are denoted as,

GO Plugs - Common for Working & Inspection (GP) - GP I, GP II, GP III	GO Rings - Common for Working & Inspection (GR) - GR I, GR II, GR III
NOGO Plugs for Working (WP) - WP I, WP II, WP III	NOGO Rings for Working (WR) - WR I, WR II, WR III
NOGO Plugs for Inspection (IP) - IP I, IP II, IP III	NOGO Rings for Inspection (IR) - IR I, IR II, IR III

☛ Gauges as per these obsolete JIS standard are manufactured if requested by customer.

