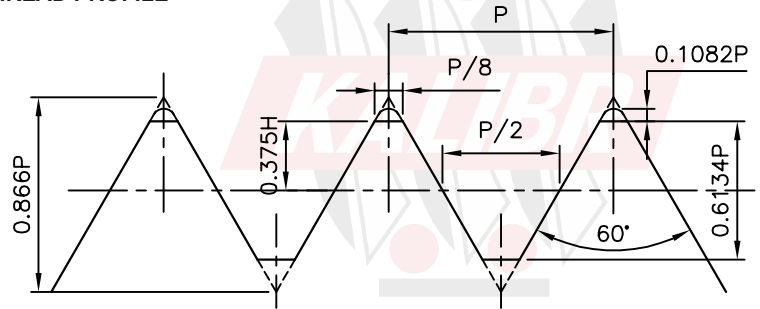


UNIFIED THREADS

Application : General purpose fastening applications for Imperial system of units.



UNIFIED THREAD PROFILE



SPECIFICATION: ANSI / ASME B1.2-1983.

☛ We manufacture Unified Gauges with Basic Dimensions as per B.S. 1580, Part I & II-2007 & Gauging practice as per B.S. 919 Part (I)-2007 if requested by customer.

MANUFACTURING RANGE

Gauge Type	Diameter Range (Inch)	TPI (Threads per Inch)	Tolerance Class
Thread Plug Gauges.	No.4 (0.112-14)	48, 44, 40, 36, 32, 28, 24, 20, 18, 16, 14, 13, 12, 11.5, 11, 10, 9, 8, 7, 6, 5, 4.5, 4 TPI not covered here can be supplied based on customer request	As given in below Table
Thread Ring Gauges.	No.4 (0.112-11)	48, 44, 40, 36, 32, 28, 24, 20, 18, 16, 14, 13, 12, 11.5, 11, 10, 9, 8, 7, 6, 5, 4.5, 4 TPI not covered here can be supplied based on customer request.	As given in below Table
Plain Plugs	To check Minor Diameter of Internal Threads as per above Diameter range.		
Plain Rings	To check Major Diameter of External Threads as per above Diameter range.		
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.		

TOLERANCE CLASS

Tolerance Class for Plug gauges (Internal threads)	Tolerance Class for Ring gauges (External threads)	Application
1B	1A	Where quick assembly is needed, even when threads are dirty / damaged. Wide tolerances for male and female threads.
2B	2A	Corresponds to medium fit and used for general applications, which requires free assembly.
3B	3A	Where closer fit is required.

☛ We manufacture **AG** class Thread Ring Gauges for lubricant and high temperature applications as recommended in B.S. 1580, Part I & II 1962 specification.

UNIFIED THREADS

Application : General purpose fastening applications for Imperial system of units.

TPI / Threads Per Inch

Dia	Dia. in Inch	UNC	UNF	UNEF	UN
No. 0	0.06	-	80	-	-
No. 1	0.073	64	72	-	-
No. 2	0.086	56	64	-	-
No. 3	0.099	48	56	-	-
No. 4	0.112	40	48	-	-
No. 5	0.125	40	44	-	-
No. 6	0.138	32	40	-	-
No. 8	0.164	32	36	-	-
No. 10	0.190	24	32	-	-
No. 12	0.216	24	28	32	-
1/4"	0.25	20	28	32	-
5/16"	0.3125	18	24	32	20,28
3/8"	0.375	16	24	32	20,28
7/16"	0.4375	14	20	28	16,32
1/2"	0.5	13	20	28	16,32
9/16"	0.5625	12	18	24	16,20,28,32
5/8"	0.625	11	18	24	12,16,20,28,32
*11/16"	0.6875			24	12,16,20,28,32
3/4"	0.75	10	16	20	12,28,32
*13/16"	0.8125			20	12,16,28,32
7/8"	0.875	9	14	20	12,16,28,32
*15/16"	0.9375			20	12,16,28,32
1"	1.00	8	12	20	16,28,32
*1.1/16"	1.0625			18	8,12,16,20,28
1.1/8"	1.125	7	12	18	8,16,20,28
*1.3/16"	1.1875			18	8,12,16,20,28
1.1/4"	1.25	7	12	18	8,16,20,28
*1.5/16"	1.3125			18	8,12,16,20,28
1.3/8"	1.375	6	12	18	8,16,20,28
*1.7/16"	1.4375			18	6,8,12,16,20,28
1.1/2"	1.5	6	12	18	8,16,20,28
*1.9/16"	1.5625			18	6,8,12,16,20
1.5/8"	1.625			18	6,8,12,16,20
*1.11/16"	1.6875			18	6,8,12,16,20
1.3/4"	1.75	5			6,8,12,16,20
*1.13/16"	1.8125				6,8,12,16,20
1.7/8"	1.875				6,8,12,16,20
*1.15/16"	1.9375				6,8,12,16,20
2"	2.0	4.5			6,8,12,16,20
*2.1/8"	2.125	-	-	-	6,8,12,16,20
2.1/4"	2.25	4.5	-	-	6,8,12,16,20
*2.3/8"	2.375	-	-	-	6,8,12,16,20
2.1/2"	2.5	4	-	-	6,8,12,16,20
*2.5/8"	2.625	-	-	-	4,6,8,12,16,20
2.3/4"	2.75	4	-	-	6,8,12,16,20
*2.7/8"	2.875	-	-	-	4,6,8,12,16,20
3"	3.0	4	-	-	6,8,12,16,20
*3.1/8"	3.125	-	-	-	4,6,8,12,16
3.1/4"	3.25	4	-	-	6,8,12,16
*3.3/8"	3.375	-	-	-	4,6,8,12,16
3.1/2"	3.5	4	-	-	6,8,12,16
*3.5/8"	3.625	-	-	-	4,6,8,12,16
3.3/4"	3.75	4	-	-	6,8,12,16
*3.7/8"	3.875	-	-	-	4,6,8,12,16
4"	4.0	4	-	-	6,8,12,16
*4.1/8"	4.125	-	-	-	4,6,8,12,16
4.1/4"	4.25	-	-	-	4,6,8,12,16
*4.3/8"	4.375	-	-	-	4,6,8,12,16
4.1/2"	4.5	-	-	-	4,6,8,12,16
*4.5/8"	4.625	-	-	-	4,6,8,12,16
4.3/4"	4.75	-	-	-	4,6,8,12,16
*4.7/8"	4.875	-	-	-	4,6,8,12,16
5"	5.0	-	-	-	4,6,8,12,16
*5.1/8"	5.125	-	-	-	4,6,8,12,16
5.1/4"	5.25	-	-	-	4,6,8,12,16
*5.3/8"	5.375	-	-	-	4,6,8,12,16
5.1/2"	5.50	-	-	-	4,6,8,12,16
*5.5/8"	5.625	-	-	-	4,6,8,12,16
5.3/4"	5.75	-	-	-	4,6,8,12,16
*5.7/8"	5.875	-	-	-	4,6,8,12,16
6"	6.0	-	-	-	4,6,8,12,16

DIAMETER – TPI COMBINATION

UNC Unified National Coarse.

UNF Unified National Fine.

UNEF Unified National Extra Fine.

UN Unified National Constant (uniform TPI Series) like 8, 12, 16, etc.

UNS Unified National Special. In case of diameter and TPI combination not covered in given table & when diameter is above 6".

Note :

1. Diameter – TPI combination not covered in this table use "UNS"
2. For all diameters above 6", use "UNS" series irrespective of TPI.

* 2nd choice of Diameter.