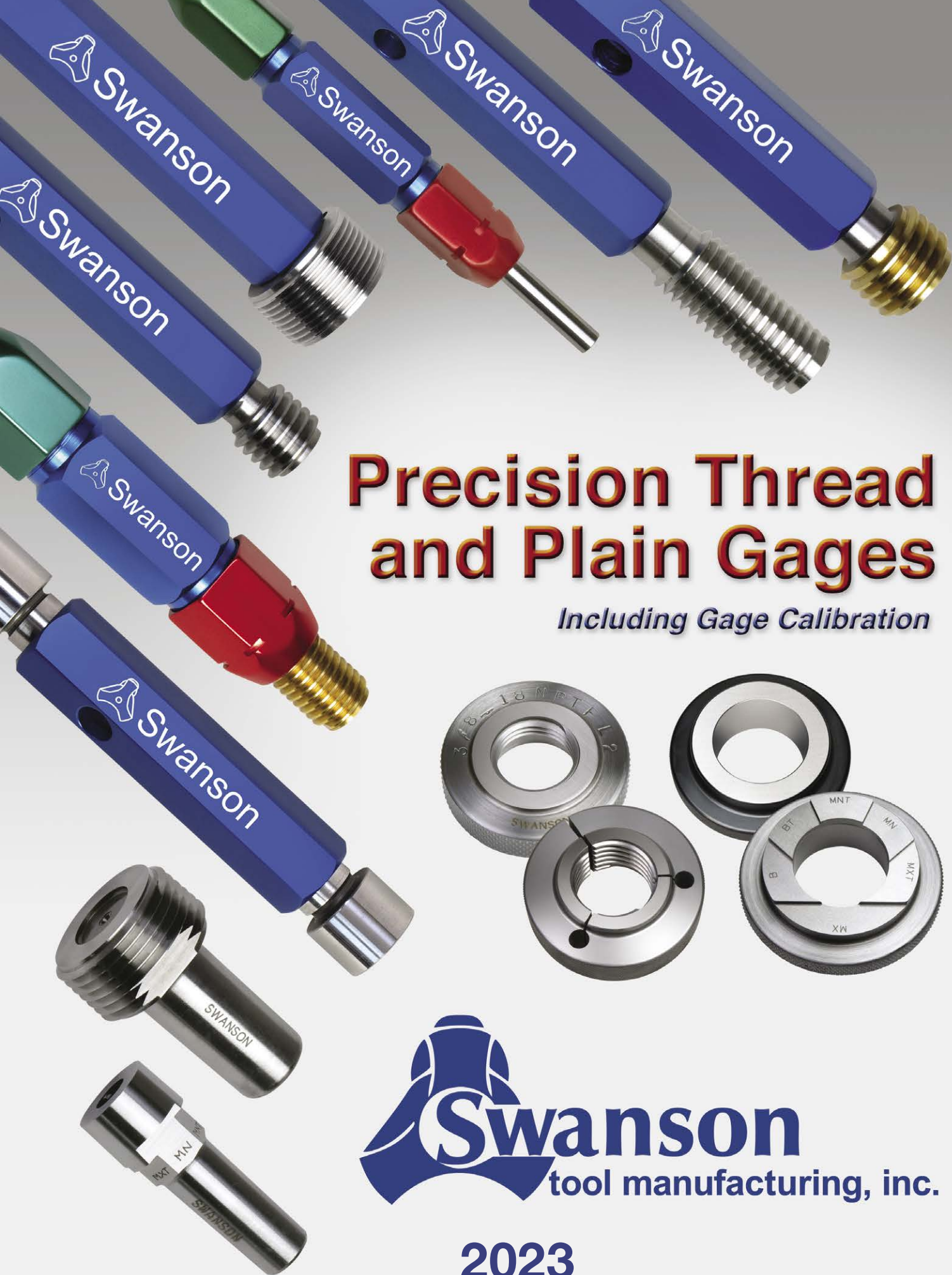




Precision Thread and Plain Gages

Including Gage Calibration



2023

Gage Calibration Service

New Swanson Gages

THREAD GAGES

Certification of Compliance to Class (Short Form)..... No Charge
 Certification of Calibration to Size (Long Form)\$15.00 / member

TAPER PIPE GAGES

Certification of Compliance to Class (Short Form)..... No Charge
 Certification of Calibration to Size (Long Form).....\$25.00 / member

CERTIFICATE OF COMPLIANCE (Short Form)

Certificate indicates the gage complies with applicable H28 and ANSI standards.

CERTIFICATE OF CALIBRATION (Long Form)

Certificate indicates actual measurements of pitch diameter, major diameter, minor diameter, flank angles and lead where they apply.

Customer Supplied Gages

THREAD PLUG GAGES: Work or Setting

Sizes #0 to 1-1/2" (M1.6 to M39)\$25.00 / member
 Sizes 1-9/16" to 8" (M40 to M203).....\$30.00 / member

NOTE: As the centerline (axis) of Trilock plug gages cannot be accurately located, the lead cannot be calibrated and half-angle relation to axis cannot be accurately calibrated. The flank angles can be calibrated for included angle only.

THREAD RING GAGES:

Standard sizes to 1-1/2" (M39)\$35.00 / member
 Non-standard sizes #0 to 5" (M1.6 to M127).....\$45.00 / member
 Non-standard sizes over 5" to 8" (over M127 to M203)\$80.00 / member

NOTE: For non-standard ring sizes where a set plug is not in our stock or is not furnished, a special tooling charge applies and will be quoted prior to processing.

TAPER PIPE GAGES

	<u>Plugs</u>	<u>Rings</u>
Sizes 1/16" to 3"	\$42.00 / member	\$66.00 / member
Sizes 3-1/2" to 6"	\$58.00 / member	\$80.00 / member

CYLINDRICAL GAGES

	<u>Plugs</u>	<u>Rings</u>
Sizes .040" to .060" (M1.016 to M1.524).....	\$88.00 / member	\$88.00 / member
Sizes .061" to .100" (M1.525 to M2.54).....	\$70.00 / member	\$70.00 / member
Sizes .101" to 2.010" (M2.541 to M51.05).....	\$60.00 / member	\$60.00 / member
Sizes 2.011" to 5.510" (M51.06 to M140.0).....	\$70.00 / member	\$70.00 / member
Sizes below .040" and over 5.510" – call for quote		

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PRICES SUBJECT TO CHANGE WITHOUT NOTICE

All sales subject to and governed by the Terms and Conditions of Sale for Swanson Tool Manufacturing, Inc. located at www.swansongage.com/terms.htm



Titanium Nitride Coated HSS Thread Plug Gages



**Class "X" Tolerance
Precision Lapped**

NOMINAL SIZE	THREADS PER INCH			MEMBERS		HANDLES		DOUBLE END
	NC UNC	NF UNF	NEF UNEF	GO	NO GO	NO.	PRICE	2B, 3B
				1, 2, 3 1B, 2B, 3B	2B, 3B			
0		80		117.00	117.00	000	12.00	246.00
1	64	72		117.00	117.00	000	12.00	246.00
2	56	64		102.00	102.00	000	12.00	216.00
3	48	56		102.00	102.00	000	12.00	216.00
4	40	48		92.00	92.00	00	12.00	196.00
5	40	44		92.00	92.00	00	12.00	196.00
6	32	40		81.00	81.00	00	12.00	174.00
8	32	36		81.00	81.00	0	12.00	174.00
10	24	32		81.00	81.00	0	12.00	174.00
12	24	28		81.00	81.00	0	12.00	174.00
12			32	169.00	169.00	0	12.00	350.00
1/4	20	28		69.00	69.00	1	12.00	150.00
1/4			32	169.00	169.00	1	12.00	350.00
5/16	18	24		69.00	69.00	1	12.00	150.00
5/16			32	173.00	173.00	1	12.00	358.00
3/8	16	24		74.00	74.00	2	12.00	160.00
3/8			32	180.00	180.00	2	12.00	372.00
7/16	14	20		74.00	74.00	2	12.00	160.00
7/16			28	166.00	166.00	2	12.00	344.00
1/2	13	20		82.00	82.00	2	12.00	176.00
1/2			28	166.00	166.00	2	12.00	344.00
9/16	12	18		99.00	99.00	3	12.00	210.00
9/16			24	176.00	176.00	3	12.00	364.00
5/8	11	18		105.00	105.00	3	12.00	222.00
5/8			24	189.00	189.00	3	12.00	390.00
11/16			24	202.00	202.00	3	12.00	416.00
3/4	10	16		122.00	122.00	3	12.00	256.00
3/4			20	202.00	202.00	3	12.00	416.00
13/16			20	211.00	211.00	3	12.00	434.00
7/8	9	14		132.00	132.00	4	12.00	276.00
7/8			20	221.00	221.00	4	12.00	454.00
15/16			20	232.00	232.00	4	12.00	476.00
1"	8	12	14NS	171.00	171.00	4	12.00	354.00
1"			20	232.00	232.00	4	12.00	476.00
1-1/16		12	18	222.00	222.00	4	12.00	456.00
1-1/8	7	12		222.00	222.00	4	12.00	456.00
1-1/8			18	238.00	238.00	4	12.00	488.00
1-3/16		12	18	254.00	254.00	5	13.00	521.00
1-1/4	7	12		254.00	254.00	5	13.00	521.00
1-1/4			18	275.00	275.00	5	13.00	563.00
1-5/16		12	18	278.00	278.00	5	13.00	569.00
1-3/8	6	12		288.00	288.00	5	13.00	589.00
1-3/8			18	311.00	311.00	5	13.00	635.00
1-7/16		12	18	297.00	297.00	5	13.00	607.00
1-1/2	6	12		297.00	297.00	5	13.00	607.00
1-1/2			18	330.00	330.00	5	13.00	673.00

For TiN coated METRIC PLUGS (see pg. 12), HELICAL COIL PLUGS (see pg. 9).
For TiN coated PIPE PLUGS & SPECIALS call Swanson

Advantages of TiN Coating:

- Greatly increased tool life
- Surface hardness greater than HSS
- Greater corrosion resistance
- Greater abrasion resistance
- Increased lubricity
- Visible sign of gage wear
- Lower gaging cost
- Increased productivity

Taperlock Thread Plug Gages



**Class "X" Tolerance
Precision Lapped**

NOMINAL SIZE	THREADS PER INCH			MEMBERS		HANDLES		DOUBLE END
	NC UNC	NF UNF	NEF UNEF	GO	NO GO	NO.	PRICE	2B, 3B
				1, 2, 3 1B, 2B, 3B	2B, 3B			
0		80		55.00	55.00	000	12.00	122.00
1	64	72		55.00	55.00	000	12.00	122.00
2	56	64		53.00	53.00	000	12.00	118.00
3	48	56		48.00	48.00	000	12.00	108.00
4	40	48		45.00	45.00	00	12.00	102.00
5	40	44		45.00	45.00	00	12.00	102.00
6	32	40		40.00	40.00	00	12.00	92.00
8	32	36		40.00	40.00	0	12.00	92.00
10	24	32		40.00	40.00	0	12.00	92.00
12	24	28		40.00	40.00	0	12.00	92.00
12			32	61.00	61.00	0	12.00	134.00
1/4	20	28		36.00	36.00	1	12.00	84.00
1/4			32	65.00	65.00	1	12.00	142.00
5/16	18	24		36.00	36.00	1	12.00	84.00
5/16			32	65.00	65.00	1	12.00	142.00
3/8	16	24		37.00	37.00	2	12.00	86.00
3/8			32	74.00	74.00	2	12.00	160.00
7/16	14	20		37.00	37.00	2	12.00	86.00
7/16			28	74.00	74.00	2	12.00	160.00
1/2	13	20		40.00	40.00	2	12.00	92.00
1/2			28	77.00	77.00	2	12.00	166.00
9/16	12	18		50.00	50.00	3	12.00	112.00
9/16			24	85.00	85.00	3	12.00	182.00
5/8	11	18		50.00	50.00	3	12.00	112.00
5/8			24	85.00	85.00	3	12.00	182.00
11/16			24	86.00	86.00	3	12.00	184.00
3/4	10	16		55.00	55.00	3	12.00	122.00
3/4			20	88.00	88.00	3	12.00	188.00
13/16			20	99.00	99.00	3	12.00	210.00
7/8	9	14		61.00	61.00	4	12.00	134.00
7/8			20	99.00	99.00	4	12.00	210.00
15/16			20	100.00	100.00	4	12.00	212.00
1"	8	12	14NS	70.00	70.00	4	12.00	152.00
1"			20	114.00	114.00	4	12.00	240.00
1-1/16		12	18	120.00	120.00	4	12.00	252.00
1-1/8	7	12		88.00	88.00	4	12.00	188.00
1-1/8			18	115.00	115.00	4	12.00	242.00
1-3/16		12	18	124.00	124.00	5	13.00	261.00
1-1/4	7	12		95.00	95.00	5	13.00	203.00
1-1/4			18	119.00	119.00	5	13.00	251.00
1-5/16		12	18	135.00	135.00	5	13.00	283.00
1-3/8	6	12		104.00	104.00	5	13.00	221.00
1-3/8			18	142.00	142.00	5	13.00	297.00
1-7/16		12	18	146.00	146.00	5	13.00	305.00
1-1/2	6	12		117.00	117.00	5	13.00	247.00
1-1/2			18	154.00	154.00	5	13.00	321.00

For chrome plate – add 30%.

Adjustable Thread Ring Gages



**Class "X"
Tolerance**

**Precision
Lapped**

NOMINAL SIZE	THREADS PER INCH			MEMBERS		(SET)	HOLDERS	
	NC UNC	NF UNF	NEF UNEF	GO	NO GO	GO / NO GO	NO.	PRICE
				2, 3 1A, 2A, 3A	2A, 3A			
0		80		163.00	163.00	326.00	1	21.00
1	64	72		149.00	149.00	298.00	1	21.00
2	56	64		134.00	134.00	268.00	1	21.00
3	48	56		134.00	134.00	268.00	1	21.00
4	40	48		124.00	124.00	248.00	1	21.00
5	40	44		109.00	109.00	218.00	1	21.00
6	32	40		109.00	109.00	218.00	1	21.00
8	32	36		106.00	106.00	212.00	1	21.00
10	24	32		106.00	106.00	212.00	1	21.00
12	24	28		106.00	106.00	212.00	1	21.00
12			32	146.00	146.00	292.00	1	21.00
1/4	20	28		105.00	105.00	210.00	2	22.00
1/4			32	146.00	146.00	292.00	2	22.00
5/16	18	24		105.00	105.00	210.00	2	22.00
5/16			32	146.00	146.00	292.00	2	22.00
3/8	16	24		115.00	115.00	230.00	3	23.00
3/8			32	150.00	150.00	300.00	3	23.00
7/16	14	20		115.00	115.00	230.00	3	23.00
7/16			28	150.00	150.00	300.00	3	23.00
1/2	13	20		119.00	119.00	238.00	3	23.00
1/2			28	152.00	152.00	304.00	3	23.00
9/16	12	18		135.00	135.00	270.00	4	28.00
9/16			24	160.00	160.00	320.00	4	28.00
5/8	11	18		135.00	135.00	270.00	4	28.00
5/8			24	185.00	185.00	370.00	4	28.00
11/16			24	180.00	180.00	360.00	4	28.00
3/4	10	16		168.00	168.00	336.00	4	28.00
3/4			20	209.00	209.00	418.00	4	28.00
13/16			20	213.00	213.00	426.00	4	28.00
7/8	9	14		182.00	182.00	364.00	5	39.00
7/8			20	221.00	221.00	442.00	5	39.00
15/16			20	222.00	222.00	444.00	5	39.00
1"	8	12	14NS	226.00	226.00	452.00	5	39.00
1"			20	253.00	253.00	506.00	5	39.00
1-1/16		12	18	275.00	275.00	550.00	5	39.00
1-1/8	7	12		280.00	280.00	560.00	5	39.00
1-1/8			18	290.00	290.00	580.00	5	39.00
1-3/16		12	18	300.00	300.00	600.00	6	50.00
1-1/4	7	12		300.00	300.00	600.00	6	50.00
1-1/4			18	305.00	305.00	610.00	6	50.00
1-5/16		12	18	306.00	306.00	612.00	6	50.00
1-3/8	6	12		305.00	305.00	610.00	6	50.00
1-3/8			18	326.00	326.00	652.00	6	50.00
1-7/16		12	18	327.00	327.00	654.00	6	50.00
1-1/2	6	12		335.00	335.00	670.00	6	50.00
1-1/2			18	350.00	350.00	700.00	6	50.00

Chrome Plate for 1/4" and larger – add 50%.

For "J" Conversion – Add \$50.00 to GO ring price.

Truncated Setting Plug Gages



**Class "X" Pitch Diameters
"W" Lead & Angles
Precision Lapped**

NOMINAL SIZE	THREADS PER INCH			MEMBERS		HANDLES		DOUBLE
	NC UNC	NF UNF	NEF UNEF	GO	NO GO	NO.	PRICE	END
				2, 3 1A, 2A, 3A	2A, 3A			2A, 3A
0		80		116.00	116.00	000	12.00	244.00
1	64	72		116.00	116.00	000	12.00	244.00
2	56	64		116.00	116.00	000	12.00	244.00
3	48	56		110.00	110.00	000	12.00	232.00
4	40	48		105.00	105.00	00	12.00	222.00
5	40	44		99.00	99.00	00	12.00	210.00
6	32	40		99.00	99.00	00	12.00	210.00
8	32	36		99.00	99.00	0	12.00	210.00
10	24	32		99.00	99.00	0	12.00	210.00
12	24	28		105.00	105.00	0	12.00	222.00
12			32	128.00	128.00	0	12.00	268.00
1/4	20	28		90.00	90.00	1	12.00	192.00
1/4			32	126.00	126.00	1	12.00	264.00
5/16	18	24		90.00	90.00	1	12.00	192.00
5/16			32	126.00	126.00	1	12.00	264.00
3/8	16	24		91.00	91.00	2	12.00	194.00
3/8			32	147.00	147.00	2	12.00	306.00
7/16	14	20		95.00	95.00	2	12.00	202.00
7/16			28	149.00	149.00	2	12.00	310.00
1/2	13	20		101.00	101.00	2	12.00	214.00
1/2			28	162.00	162.00	2	12.00	336.00
9/16	12	18		116.00	116.00	3	12.00	244.00
9/16			24	174.00	174.00	3	12.00	360.00
5/8	11	18		120.00	120.00	3	12.00	252.00
5/8			24	180.00	180.00	3	12.00	372.00
11/16			24	192.00	192.00	3	12.00	396.00
3/4	10	16		140.00	140.00	3	12.00	292.00
3/4			20	185.00	185.00	3	12.00	382.00
13/16			20	198.00	198.00	3	12.00	408.00
7/8	9	14		161.00	161.00	4	12.00	334.00
7/8			20	202.00	202.00	4	12.00	416.00
15/16			20	204.00	204.00	4	12.00	420.00
1"	8	12	14NS	185.00	185.00	4	12.00	382.00
1"			20	214.00	214.00	4	12.00	440.00
1-1/16		12	18	210.00	210.00	4	12.00	432.00
1-1/8	7	12		210.00	210.00	4	12.00	432.00
1-1/8			18	230.00	230.00	4	12.00	472.00
1-3/16		12	18	230.00	230.00	5	13.00	473.00
1-1/4	7	12		235.00	235.00	5	13.00	483.00
1-1/4			18	262.00	262.00	5	13.00	537.00
1-5/16		12	18	268.00	268.00	5	13.00	549.00
1-3/8	6	12		270.00	270.00	5	13.00	553.00
1-3/8			18	279.00	279.00	5	13.00	571.00
1-7/16		12	18	290.00	290.00	5	13.00	593.00
1-1/2	6	12		292.00	292.00	5	13.00	597.00
1-1/2			18	299.00	299.00	5	13.00	611.00

For class "W" pitch diameters – add 25%.

"8, 12 & 16" Pitch Thread Plug Gages



**"UN" Class 2B & 3B
Class "X" Tolerance**

NOMINAL SIZE & PITCH				MEMBERS		HANDLES		DOUBLE END
				GO 2B, 3B	NO GO 2B, 3B	NO.	PRICE	
11/16			16	117.00	117.00	3	12.00	246.00
13/16			16	120.00	120.00	3	12.00	252.00
7/8			16	120.00	120.00	4	12.00	252.00
15/16			16	120.00	120.00	4	12.00	252.00
1"	**	**	16	120.00	120.00	4	12.00	252.00
1-1/16		**	16	120.00	120.00	4	12.00	252.00
1-1/8	8	**	16	120.00	120.00	4	12.00	252.00
1-3/16		**	16	127.00	127.00	5	13.00	267.00
1-1/4	8	**	16	127.00	127.00	5	13.00	267.00
1-5/16		**	16	142.00	142.00	5	13.00	297.00
1-3/8	8	**	16	142.00	142.00	5	13.00	297.00
1-7/16		**	16	147.00	147.00	5	13.00	307.00
1-1/2	8	**	16	147.00	147.00	5	13.00	307.00
1-5/8	8	12	16	163.00	163.00	5-1/2	19.00	345.00
1-3/4	8	12	16	165.00	165.00	5-1/2	19.00	349.00
1-7/8	8	12	16	167.00	167.00	5-1/2	19.00	353.00
2"	8	12	16	197.00	197.00	5-1/2	19.00	413.00
2-1/8	8	12	16	204.00	204.00	6	19.00	427.00
2-1/4	8	12	16	204.00	204.00	6	19.00	427.00
2-3/8	8	12	16	226.00	226.00	6	19.00	471.00
2-1/2	8	12	16	226.00	226.00	6	19.00	471.00
2-5/8	8	12	16	236.00	236.00	7	22.00	494.00
2-3/4	8	12	16	236.00	236.00	7	22.00	494.00
2-7/8	8	12	16	255.00	255.00	7	22.00	532.00
3"	8	12	16	255.00	255.00	7	22.00	554.00*
3-1/4	8	12	16	277.00	277.00	7	22.00	598.00*
3-1/2	8	12	16	305.00	305.00	7	22.00	654.00*
3-3/4	8	12	16	313.00	313.00	7	22.00	670.00*
4"	8	12	16	335.00	335.00	7	22.00	714.00*

* 2 handles

** 8 & 12 pitch for these sizes are standard – see page 4.

Sizes 11/16" to 1-1/2" are Taperlock.

Sizes 1-5/8" to 4" are Trilock.

For plug gages over 4" diameter – call Swanson.

For TiN coated thread plug gages – call Swanson.

"8, 12 & 16" Pitch Thread Ring Gages



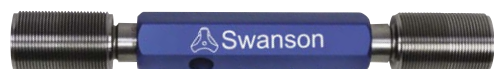
**"UN" Class 2A & 3A
Class "X" Tolerance
Precision Lapped**

For ring gages over
2-1/2" – call Swanson.

NOMINAL SIZE & PITCH				RING MEMBERS		SET GO / NO GO	HOLDER	
				GO 2A, 3A	NO GO 2A, 3A		NO.	PRICE
11/16			16	306.00	306.00	612.00	4	28.00
13/16			16	311.00	311.00	622.00	4	28.00
7/8			16	311.00	311.00	622.00	5	39.00
15/16			16	313.00	313.00	626.00	5	39.00
1"	**	**	16	313.00	313.00	626.00	5	39.00
1-1/16		**	16	318.00	318.00	636.00	5	39.00
1-1/8	8	**	16	318.00	318.00	636.00	5	39.00
1-3/16		**	16	330.00	330.00	660.00	6	50.00
1-1/4	8	**	16	330.00	330.00	660.00	6	50.00
1-5/16		**	16	343.00	343.00	686.00	6	50.00
1-3/8	8	**	16	343.00	343.00	686.00	6	50.00
1-7/16		**	16	366.00	366.00	732.00	6	50.00
1-1/2	8	**	16	366.00	366.00	732.00	6	50.00
1-5/8	8	12	16	381.00	381.00	762.00		
1-3/4	8	12	16	404.00	404.00	808.00		
1-7/8	8	12	16	419.00	419.00	838.00		
2"	8	12	16	444.00	444.00	888.00		
2-1/8	8	12	16	473.00	473.00	946.00		
2-1/4	8	12	16	473.00	473.00	946.00		
2-3/8	8	12	16	500.00	500.00	1000.00		
2-1/2	8	12	16	500.00	500.00	1000.00		

** 8 & 12 pitch for these sizes are standard – see page 5.

"8, 12 & 16" Pitch Truncated Setting Plug Gages



**"UN" Class 2A & 3A
Class "X" Pitch Diameters
"W" Lead & Angles
Precision Lapped**

Sizes 11/16" to 1-1/2" are Taperlock.

Sizes 1-5/8" to 2-1/2" are Trilock.

For class "W" pitch diameters –
call Swanson.

For Setting Plug Gages over
2-1/2" – call Swanson.

NOMINAL SIZE & PITCH				MEMBERS		HOLDER		DOUBLE END
				GO 2A, 3A	NO GO 2A, 3A	NO.	PRICE	
11/16			16	158.00	158.00	3	12.00	328.00
13/16			16	172.00	172.00	3	12.00	356.00
7/8			16	172.00	172.00	4	12.00	356.00
15/16			16	192.00	192.00	4	12.00	396.00
1"	**	**	16	192.00	192.00	4	12.00	396.00
1-1/16		**	16	202.00	202.00	4	12.00	416.00
1-1/8	8	**	16	202.00	202.00	4	12.00	416.00
1-3/16		**	16	231.00	231.00	5	13.00	475.00
1-1/4	8	**	16	231.00	231.00	5	13.00	475.00
1-5/16		**	16	251.00	251.00	5	13.00	515.00
1-3/8	8	**	16	251.00	251.00	5	13.00	515.00
1-7/16		**	16	262.00	262.00	5	13.00	537.00
1-1/2	8	**	16	262.00	262.00	5	13.00	537.00
1-5/8	8	12	16	268.00	268.00	5-1/2	19.00	555.00
1-3/4	8	12	16	270.00	270.00	5-1/2	19.00	559.00
1-7/8	8	12	16	278.00	278.00	5-1/2	19.00	575.00
2"	8	12	16	285.00	285.00	5-1/2	19.00	589.00
2-1/8	8	12	16	294.00	294.00	6	19.00	607.00
2-1/4	8	12	16	294.00	294.00	6	19.00	607.00
2-3/8	8	12	16	327.00	327.00	6	19.00	673.00
2-1/2	8	12	16	327.00	327.00	6	19.00	673.00

** 8 & 12 pitch for these sizes are standard – see page 6.

Helical Coil (STI) Thread Plug Gages



Class "X" Tolerance Precision Lapped

NOMINAL SIZE	REGULAR TOOL STEEL			TiN COATED HIGH SPEED STEEL			HANDLES	
	MEMBERS		DOUBLE END 2B & 3B	MEMBERS		DOUBLE END 2B & 3B		
	GO 2B, 3B	NO GO 2B, 3B		GO 2B, 3B	NO GO 2B, 3B		NO.	PRICE
2-56	67.00	67.00	146.00	130.00	130.00	272.00	00	12.00
4-40	60.00	60.00	132.00	114.00	114.00	240.00	00	12.00
4-48	60.00	60.00	132.00	179.00	179.00	370.00	00	12.00
5-40	60.00	60.00	132.00	179.00	179.00	370.00	0	12.00
6-32	60.00	60.00	132.00	114.00	114.00	240.00	0	12.00
6-40	60.00	60.00	132.00	182.00	182.00	376.00	0	12.00
8-32	56.00	56.00	124.00	111.00	111.00	234.00	0	12.00
8-36	56.00	56.00	124.00	169.00	169.00	350.00	0	12.00
10-24	56.00	56.00	124.00	169.00	169.00	350.00	0	12.00
10-32	56.00	56.00	124.00	111.00	111.00	234.00	0	12.00
12-24	56.00	56.00	124.00	166.00	166.00	344.00	1	12.00
1/4-20	56.00	56.00	124.00	166.00	166.00	344.00	1	12.00
1/4-28	56.00	56.00	124.00	109.00	109.00	230.00	1	12.00
5/16-18	56.00	56.00	124.00	166.00	166.00	344.00	2	12.00
5/16-24	56.00	56.00	124.00	109.00	109.00	230.00	1	12.00
3/8-16	58.00	58.00	128.00	166.00	166.00	344.00	2	12.00
3/8-24	58.00	58.00	128.00	111.00	111.00	234.00	2	12.00
7/16-14	60.00	60.00	132.00	166.00	166.00	344.00	3	12.00
7/16-20	60.00	60.00	132.00	166.00	166.00	344.00	2	12.00
1/2-13	64.00	64.00	140.00	166.00	166.00	344.00	3	12.00
1/2-20	64.00	64.00	140.00	166.00	166.00	344.00	3	12.00
9/16-12	74.00	74.00	160.00	172.00	172.00	356.00	3	12.00
9/16-18	74.00	74.00	160.00	172.00	172.00	356.00	3	12.00
5/8-11	74.00	74.00	160.00	185.00	185.00	382.00	3	12.00
5/8-18	74.00	74.00	160.00	185.00	185.00	382.00	3	12.00
3/4-10	80.00	80.00	172.00	203.00	203.00	418.00	4	12.00
3/4-16	80.00	80.00	172.00	203.00	203.00	418.00	3	12.00

For class "W" pitch diameters – call Swanson.

For chrome plate (on regular steel only) – add 30%.

Left Hand Thread Work Plugs 2B & 3B



NOMINAL SIZE	THREADS PER INCH		MEMBERS		HANDLES		DOUBLE END
	UNC	UNF	GO 2B, 3B	NO GO 2B, 3B	NO.	PRICE	
4	40	48	119.00	119.00	00	12.00	250.00
5	40	44	119.00	119.00	00	12.00	250.00
6	32	40	119.00	119.00	00	12.00	250.00
8	32	36	110.00	110.00	0	12.00	232.00
10	24	32	110.00	110.00	0	12.00	232.00
12	24	28	110.00	110.00	0	12.00	232.00
1/4	20	28	108.00	108.00	1	12.00	228.00
5/16	18	24	108.00	108.00	1	12.00	228.00
3/8	16	24	108.00	108.00	2	12.00	228.00
7/16	14	20	108.00	108.00	2	12.00	228.00
1/2	13	20	108.00	108.00	2	12.00	228.00
9/16	12	18	108.00	108.00	3	12.00	228.00
5/8	11	18	110.00	110.00	3	12.00	232.00
3/4	10	16	117.00	117.00	3	12.00	246.00

For chrome plate – add 30%.

For TiN coated prices – call Swanson.

Left Hand Thread Rings 2A & 3A



NOMINAL SIZE	THREADS PER INCH		MEMBERS		SET PRICE	HOLDERS	
	UNC	UNF	GO 2A, 3A	NO GO 2A, 3A		NO.	PRICE
4	40	48	288.00	288.00	576.00	1	21.00
5	40	44	276.00	276.00	552.00	1	21.00
6	32	40	265.00	265.00	530.00	1	21.00
8	32	36	245.00	245.00	490.00	1	21.00
10	24	32	245.00	245.00	490.00	1	21.00
12	24	28	245.00	245.00	490.00	1	21.00
1/4	20	28	288.00	288.00	576.00	2	22.00
5/16	18	24	288.00	288.00	576.00	2	22.00
3/8	16	24	290.00	290.00	580.00	3	23.00
7/16	14	20	290.00	290.00	580.00	3	23.00
1/2	13	20	290.00	290.00	580.00	3	23.00
9/16	12	18	299.00	299.00	598.00	4	28.00
5/8	11	18	306.00	306.00	612.00	4	28.00
3/4	10	16	306.00	306.00	612.00	4	28.00

Left Hand Thread Setting Plugs 2A & 3A



NOMINAL SIZE	THREADS PER INCH		MEMBERS		HANDLES		DOUBLE END
	UNC	UNF	GO 2A, 3A	NO GO 2A, 3A	NO.	PRICE	
4	40	48	172.00	172.00	00	12.00	356.00
5	40	44	172.00	172.00	00	12.00	356.00
6	32	40	172.00	172.00	00	12.00	356.00
8	32	36	158.00	158.00	0	12.00	328.00
10	24	32	158.00	158.00	0	12.00	328.00
12	24	28	158.00	158.00	0	12.00	328.00
1/4	20	28	148.00	148.00	1	12.00	308.00
5/16	18	24	148.00	148.00	1	12.00	308.00
3/8	16	24	148.00	148.00	2	12.00	308.00
7/16	14	20	148.00	148.00	2	12.00	308.00
1/2	13	20	148.00	148.00	2	12.00	308.00
9/16	12	18	148.00	148.00	3	12.00	308.00
5/8	11	18	154.00	154.00	3	12.00	320.00
3/4	10	16	158.00	158.00	3	12.00	328.00

For class "W" pitch diameters – add 25%.

Reversible Thread Plug Gages



**Class "X" Tolerance
Precision Lapped**

NOMINAL SIZE	THREADS PER INCH		MEMBERS		HANDLES		DOUBLE END 2B, 3B
	NC UNC	NF UNF	GO	NO GO	NO.	PRICE	
			1, 2, 3 1B, 2B 3B	2B, 3B			
0		80	88.00	88.00	1W	14.00	190.00
1	64	72	88.00	88.00	1W	14.00	190.00
2	56	64	80.00	80.00	2W	14.00	174.00
3	48	56	78.00	78.00	2W	14.00	170.00
4	40	48	72.00	72.00	2W	14.00	158.00
5	40	44	65.00	65.00	2W	14.00	144.00
6	32	40	65.00	65.00	2W	14.00	144.00
8	32	36	65.00	65.00	2W	14.00	144.00
10	24	32	65.00	65.00	3W	15.00	145.00
12	24	28	65.00	65.00	3W	15.00	145.00
1/4	20	28	60.00	60.00	3W	15.00	135.00
5/16	18	24	60.00	60.00	4W	17.00	137.00
3/8	16	24	65.00	65.00	4W	17.00	147.00
7/16	14	20	65.00	65.00	5W	17.00	147.00
1/2	13	20	65.00	65.00	5W	17.00	147.00
9/16	12	18	76.00	76.00	6W	18.00	170.00
5/8	11	18	76.00	76.00	6W	18.00	170.00
3/4	10	16	85.00	85.00	7W	20.00	190.00

For chrome plate – add 30%.

TiN coated available for #4 and larger.

Metric Reversible Thread Plug Gages



**Class "X" Tolerance
Precision Lapped**

METRIC SIZE AND PITCH					MEMBERS		HANDLES		DOUBLE END
					6H GO	6H NO GO	NO.	PRICE	
M1.6	0.35				99.00	99.00	1W	14.00	212.00
M2	0.40				93.00	93.00	2W	14.00	200.00
M2.5	0.45				93.00	93.00	2W	14.00	200.00
M3	0.50				80.00	80.00	2W	14.00	174.00
M3.5	0.60				72.00	72.00	2W	14.00	158.00
M4	0.70				72.00	72.00	2W	14.00	158.00
M5	0.80				72.00	72.00	3W	15.00	159.00
M6	1.00				63.00	63.00	3W	15.00	141.00
M8	1.25	1.00			63.00	63.00	4W	17.00	143.00
M10	1.50	1.25			64.00	64.00	4W	17.00	145.00
M12	1.75	1.50	1.25	1.00	67.00	67.00	5W	17.00	151.00
M14	2.00	1.50			77.00	77.00	6W	18.00	172.00
M16	2.00	1.50			80.00	80.00	7W	20.00	180.00
M18	1.50				88.00	88.00	7W	20.00	196.00

For chrome plate – add 30%.

TiN coated available for M3 and larger.

Metric Thread Plug Gages – Regular & TiN Coated



**Class "X" Tolerance
Precision Lapped**

METRIC SIZE AND PITCH					REGULAR TOOL STEEL			TIN COATED HIGH SPEED STEEL			HANDLES	
					MEMBERS		DOUBLE END	MEMBERS		DOUBLE END		
					6H GO	6H NO GO		6H GO	6H NO GO		NO.	PRICE
M1.6	0.35				65.00	65.00	142.00	137.00	137.00	286.00	000	12.00
M1.8	0.35				65.00	65.00	142.00	211.00	211.00	434.00	000	12.00
M2	0.40				65.00	65.00	142.00	129.00	129.00	270.00	000	12.00
M2.2	0.45				65.00	65.00	142.00	211.00	211.00	434.00	000	12.00
M2.5	0.45				59.00	59.00	130.00	121.00	121.00	254.00	000	12.00
M3	0.50				59.00	59.00	130.00	121.00	121.00	254.00	00	12.00
M3.5	0.60				51.00	51.00	114.00	179.00	179.00	370.00	00	12.00
M4	0.70				51.00	51.00	114.00	104.00	104.00	220.00	0	12.00
M4.5	0.75				51.00	51.00	114.00	169.00	169.00	350.00	0	12.00
M5	0.80				51.00	51.00	114.00	104.00	104.00	220.00	0	12.00
M6	1.00				42.00	42.00	96.00	92.00	92.00	196.00	1	12.00
M7	1.00				42.00	42.00	96.00	166.00	166.00	344.00	1	12.00
M8	1.25	1.00			42.00	42.00	96.00	92.00	92.00	196.00	1	12.00
M10	1.50	1.25	1.00	0.75	45.00	45.00	102.00	102.00	102.00	216.00	2	12.00
M12	1.75	1.50	1.25	1.00	50.00	50.00	112.00	111.00	111.00	234.00	2	12.00
M14	2.00	1.50			54.00	54.00	120.00	166.00	166.00	344.00	3	12.00
M15	1.00				59.00	59.00	130.00	189.00	189.00	390.00	3	12.00
M16	2.00	1.50			56.00	56.00	124.00	172.00	172.00	356.00	3	12.00
M17	1.00				61.00	61.00	134.00	202.00	202.00	416.00	3	12.00
M18	2.50	1.50			64.00	64.00	140.00	185.00	185.00	382.00	3	12.00
M20	2.50	1.50	1.00		68.00	68.00	148.00	193.00	193.00	398.00	3	12.00
M22	2.50	1.50			68.00	68.00	148.00	203.00	203.00	418.00	4	12.00
M24	3.00	2.00			78.00	78.00	168.00	212.00	212.00	436.00	4	12.00
M27	3.00	2.00			102.00	102.00	216.00	222.00	222.00	456.00	4	12.00
M30	3.50	2.00	1.50		132.00	132.00	277.00	254.00	254.00	521.00	5	13.00
M33	3.50	2.00			132.00	132.00	277.00	283.00	283.00	579.00	5	13.00
M35	1.50				140.00	140.00	293.00	297.00	297.00	607.00	5	13.00
M36	4.00	3.00	2.00		148.00	148.00	309.00	297.00	297.00	607.00	5	13.00
M39	4.00	3.00	2.00		165.00	165.00	349.00	315.00	315.00	649.00	5-1/2	19.00

Metric gages made to ANSI B1.16 dimensions.

Blanks conform to ANSI B47.1 dimensions.

For chrome plate (on regular steel) – add 30%.

Metric Thread Ring Gages



**Class "X" Tolerance
Precision Lapped**

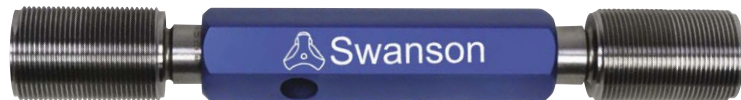
METRIC SIZE AND PITCH					MEMBERS		SET	HOLDER	
					6g GO	6g NO GO	GO / NO GO	NO.	PRICE
M1.6	0.35				190.00	190.00	380.00	1	21.00
M1.8	0.35				190.00	190.00	380.00	1	21.00
M2	0.40				171.00	171.00	342.00	1	21.00
M2.2	0.45				171.00	171.00	342.00	1	21.00
M2.5	0.45				171.00	171.00	342.00	1	21.00
M3	0.50				147.00	147.00	294.00	1	21.00
M3.5	0.60				147.00	147.00	294.00	1	21.00
M4	0.70				136.00	136.00	272.00	1	21.00
M4.5	0.75				136.00	136.00	272.00	1	21.00
M5	0.80				136.00	136.00	272.00	1	21.00
M6	1.00				126.00	126.00	252.00	2	22.00
M7	1.00				126.00	126.00	252.00	2	22.00
M8	1.25	1.00			126.00	126.00	252.00	2	22.00
M10	1.50	1.25	1.00	0.75	136.00	136.00	272.00	3	23.00
M12	1.75	1.50	1.25	1.00	146.00	146.00	292.00	3	23.00
M14	2.00	1.50			163.00	163.00	326.00	4	28.00
M15	1.00				163.00	163.00	326.00	4	28.00
M16	2.00	1.50			163.00	163.00	326.00	4	28.00
M17	1.00				212.00	212.00	424.00	4	28.00
M18	2.50	1.50			218.00	218.00	436.00	4	28.00
M20	2.50	1.50	1.00		264.00	264.00	528.00	4	28.00
M22	2.50	1.50			269.00	269.00	538.00	5	39.00
M24	3.00	2.00			311.00	311.00	622.00	5	39.00
M27	3.00	2.00			324.00	324.00	648.00	5	39.00
M30	3.50	2.00	1.50		328.00	328.00	656.00	6	50.00
M33	3.50	2.00			362.00	362.00	724.00	6	50.00
M35	1.50				383.00	383.00	766.00	6	50.00
M36	4.00	3.00	2.00		403.00	403.00	806.00	6	50.00
M39	4.00	3.00	2.00		412.00	412.00	824.00	6	50.00

Metric gages made to ANSI B1.16 dimensions.

Blanks conform to ANSI B47.1 dimensions.

For chrome plate for M6 and larger – add 50%.

Metric Truncated Setting Plug Gages



**Class "X" Pitch Diameters
"W" Lead & Angles
Precision Lapped**

METRIC SIZE AND PITCH					MEMBERS		HANDLES		DOUBLE END
					6g GO	6g NO GO	NO.	PRICE	
M1.6	0.35				135.00	135.00	000	12.00	282.00
M1.8	0.35				135.00	135.00	000	12.00	282.00
M2	0.40				127.00	127.00	000	12.00	266.00
M2.2	0.45				127.00	127.00	000	12.00	266.00
M2.5	0.45				127.00	127.00	000	12.00	266.00
M3	0.50				122.00	122.00	00	12.00	256.00
M3.5	0.60				122.00	122.00	00	12.00	256.00
M4	0.70				120.00	120.00	0	12.00	252.00
M4.5	0.75				120.00	120.00	0	12.00	252.00
M5	0.80				120.00	120.00	0	12.00	252.00
M6	1.00				111.00	111.00	1	12.00	234.00
M7	1.00				111.00	111.00	1	12.00	234.00
M8	1.25	1.00			111.00	111.00	1	12.00	234.00
M10	1.50	1.25	1.00	0.75	118.00	118.00	2	12.00	248.00
M12	1.75	1.50	1.25	1.00	122.00	122.00	2	12.00	256.00
M14	2.00	1.50			144.00	144.00	3	12.00	300.00
M15	1.00				144.00	144.00	3	12.00	300.00
M16	2.00	1.50			144.00	144.00	3	12.00	300.00
M17	1.00				156.00	156.00	3	12.00	324.00
M18	2.50	1.50			150.00	150.00	3	12.00	312.00
M20	2.50	1.50	1.00		158.00	158.00	3	12.00	328.00
M22	2.50	1.50			207.00	207.00	4	12.00	426.00
M24	3.00	2.00			211.00	211.00	4	12.00	434.00
M27	3.00	2.00			226.00	226.00	4	12.00	468.00
M30	3.50	2.00	1.50		229.00	229.00	5	13.00	471.00
M33	3.50	2.00			248.00	248.00	5	13.00	509.00
M35	1.50				262.00	262.00	5	13.00	537.00
M36	4.00	3.00	2.00		274.00	274.00	5	13.00	566.00
M39	4.00	3.00	2.00		304.00	304.00	5-1/2	19.00	627.00

Metric gages made to ANSI B1.16 dimensions.

Blanks conform to ANSI B47.1 dimensions.

For class "W" pitch diameters – add 25%.

Taper Pipe Plug Gages



SIZE	NPT L1	NPTF L1	NPTF L3	NPTF 6-STEP PLAIN	ANPT L1	ANPT L3	ANPT 6-STEP PLAIN	HANDLE	
								NO.	PRICE
1/16-27	104.00	135.00	141.00	208.00	155.00	162.00	202.00	1	12.00
1/8-27	82.00	108.00	114.00	208.00	111.00	117.00	202.00	2	12.00
1/4-18	86.00	113.00	118.00	208.00	129.00	135.00	202.00	3	12.00
3/8-18	94.00	135.00	142.00	208.00	155.00	160.00	202.00	3	12.00
1/2-14	107.00	155.00	160.00	208.00	167.00	173.00	202.00	4	12.00
3/4-14	122.00	171.00	179.00	222.00	182.00	188.00	212.00	4	12.00
1"-11 1/2	136.00	189.00	198.00	240.00	208.00	213.00	242.00	5	13.00
1 1/4-11 1/2	151.00	213.00	213.00	264.00	226.00	226.00	256.00	5	13.00
1 1/2-11 1/2	171.00	242.00	242.00	298.00	254.00	254.00	279.00	5	13.00
2"-11 1/2	208.00	281.00	281.00	402.00	296.00	296.00	390.00	5	13.00
2 1/2-8	256.00	446.00	446.00	618.00	474.00	474.00	598.00	6	19.00
3"-8	309.00	502.00	502.00	678.00	559.00	559.00	713.00	6	19.00
3 1/2-8	457.00							7	22.00
4"-8	524.00							7	22.00
5"-8	716.00							7	22.00
6"-8	854.00							7	22.00

NPT and NPTF plug gages are single step.

For NPT or NPTF 2-step or 3-step design – add \$35.00 per step.

ANPT L1 & L3 plug gages are 1-step design per SAE AS71051.

For TiN coated Pipe Plug prices – call Swanson.

Taper Pipe Ring Gages



SIZE	NPT L1	NPTF L1 THIN	NPTF L2 THICK	NPTF 6-STEP PLAIN	ANPT L1 THIN	ANPT L2 THICK	ANPT 6-STEP PLAIN
1/16-27	216.00	226.00	314.00	384.00	336.00	394.00	445.00
1/8-27	164.00	197.00	293.00	384.00	293.00	357.00	445.00
1/4-18	164.00	187.00	314.00	384.00	286.00	369.00	445.00
3/8-18	174.00	184.00	306.00	384.00	286.00	360.00	445.00
1/2-14	197.00	204.00	319.00	384.00	258.00	374.00	445.00
3/4-14	220.00	227.00	354.00	428.00	280.00	411.00	498.00
1"-11 1/2	251.00	265.00	385.00	428.00	361.00	447.00	498.00
1 1/4-11 1/2	278.00	282.00	418.00	467.00	361.00	483.00	543.00
1 1/2-11 1/2	329.00	339.00	457.00	537.00	394.00	531.00	622.00
2"-11 1/2	393.00	479.00	528.00	600.00	568.00	614.00	695.00
2 1/2-8	460.00	519.00	632.00	709.00	605.00	735.00	823.00
3"-8	579.00	590.00	748.00	869.00	690.00	872.00	1006.00
3 1/2-8	813.00						
4"-8	932.00						
5"-8	1118.00						
6"-8	1324.00						

N.P.T. – American National Pipe Thread Series

N.P.T.F. – National Taper Pipe Dryseal Series

A.N.P.T. – Aeronautical Tapered Pipe Thread Series

For Master Plug and Ring prices – call Swanson.

NPSM Straight Pipe Thread Gages



SIZE	WORK PLUGS NPSM-2B				SET PLUGS NPSM-2A				RINGS NPSM-2A	
	GO or NO GO	HANDLE		DOUBLE END	GO or NO GO	HANDLE		DOUBLE END	GO or NO GO	SET GO & NO GO
		NO.	PRICE			NO.	PRICE			
1/8-27	108.00	2	12.00	228.00	148.00	2	12.00	308.00	290.00	580.00
1/4-18	108.00	3	12.00	228.00	148.00	3	12.00	308.00	299.00	598.00
3/8-18	117.00	3	12.00	246.00	158.00	3	12.00	328.00	306.00	612.00
1/2-14	120.00	4	12.00	252.00	172.00	4	12.00	356.00	311.00	622.00
3/4-14	120.00	4	12.00	252.00	202.00	4	12.00	416.00	318.00	636.00
1"-11 1/2	142.00	5	13.00	297.00	251.00	5	13.00	515.00	343.00	686.00
1 1/4-11 1/2	165.00	5-1/2	19.00	349.00	270.00	5-1/2	19.00	559.00	404.00	808.00
1 1/2-11 1/2	197.00	5-1/2	19.00	413.00	285.00	5-1/2	19.00	589.00	444.00	888.00
2"-11 1/2	226.00	6	19.00	471.00	327.00	6	19.00	673.00	500.00	1000.00
2 1/2-8	255.00	7	22.00	506.00*	371.00	7	22.00	718.00*	591.00	1182.00
3"-8	313.00	7	22.00	612.00*	459.00	7	22.00	878.00*	737.00	1474.00

For chrome plate: work plugs – add 30%.
rings – add 50%.

* 2 Handles

For TiN coated thread work plugs – call Swanson.

NPSF Straight Pipe Thread Plug Gages



SIZE	GO or NO GO	HANDLE		DOUBLE END
		NO.	PRICE	
1/16-27	108.00	1	12.00	228.00
1/8-27	108.00	2	12.00	228.00
1/4-18	108.00	3	12.00	228.00
3/8-18	117.00	3	12.00	246.00
1/2-14	120.00	4	12.00	252.00
3/4-14	120.00	4	12.00	252.00
1"-11 1/2	142.00	5	13.00	297.00

For chrome plate – add 30%.

For TiN coated thread plug gages – call Swanson.

British Standard Pipe – BSPP "Modified" (Non-Pressure Tight Joints)



SIZE	WORK PLUGS "G" (BSPP)				SET PLUGS "G" (BSPP) Class "B"				RINGS "G" (BSPP) Class "B"	
	GO or NO GO	HANDLE		DOUBLE END	GO or NO GO	HANDLE		DOUBLE END	GO or NO GO	SET GO & NO GO
		NO.	PRICE			NO.	PRICE			
1/16-28	108.00	1	12.00	228.00	148.00	1	12.00	308.00	288.00	576.00
1/8-28	108.00	2	12.00	228.00	148.00	2	12.00	308.00	290.00	580.00
1/4-19	108.00	3	12.00	228.00	148.00	3	12.00	308.00	316.00	632.00
3/8-19	119.00	3	12.00	250.00	180.00	3	12.00	372.00	318.00	636.00
1/2-14	120.00	4	12.00	252.00	172.00	4	12.00	356.00	311.00	622.00
3/4-14	120.00	4	12.00	252.00	202.00	4	12.00	416.00	318.00	636.00
1"-11	142.00	5	13.00	297.00	251.00	5	13.00	515.00	343.00	686.00
1 1/4-11	165.00	5-1/2	19.00	349.00	270.00	5-1/2	19.00	559.00	404.00	808.00
1 1/2-11	197.00	5-1/2	19.00	413.00	285.00	5-1/2	19.00	589.00	444.00	888.00
2"-11	226.00	6	19.00	471.00	327.00	6	19.00	673.00	500.00	1000.00
2 1/2-11	255.00	7	22.00	506.00*	371.00	7	22.00	718.00*	591.00	1182.00
3"-11	313.00	7	22.00	612.00*	459.00	7	22.00	878.00*	737.00	1474.00

Note:

* 2 Handles

- 55° Whitworth thread form, modified with truncated crest and cleared root, for the inspection of product threads to ISO228-1 or BS2779.
- G (internal and external straight).
- There are two classes of external threads: "A" (close fit) and "B" (free fit). Class "B" is used unless Class "A" is specified. Call for Class "A" ring and set plug gage pricing.

For TiN coated thread work plugs – call Swanson.

British Standard Pipe – BSPT "Modified" (Pressure Tight Joints)



SIZE	WORK PLUGS "Rc" or "Rp" System "A"			RINGS "R" System "A" (BSPT)	
	WORK PLUG ONLY (BSPT)	HANDLE			WORKPLUG WITH HANDLE
		NO.	PRICE		
1/16-28	197.00	1	12.00	209.00	871.00
1/8-28	197.00	2	12.00	209.00	871.00
1/4-19	197.00	3	12.00	209.00	904.00
3/8-19	214.00	3	12.00	226.00	916.00
1/2-14	215.00	4	12.00	227.00	921.00
3/4-14	215.00	4	12.00	227.00	943.00
1"-11	248.00	5	13.00	261.00	1059.00
1 1/4-11	283.00	5	13.00	296.00	1151.00
1 1/2-11	331.00	5	13.00	344.00	1249.00
2"-11	374.00	5	13.00	387.00	1471.00
2 1/2-11	418.00	6	19.00	437.00	1735.00
3"-11	505.00	6	19.00	524.00	1999.00

Note:

- 55° Whitworth thread form, modified with truncated crest and cleared root, to BS21. For the inspection of product threads to BS21, BS EN10226-1, and ISO7-1.
- Rc (internal taper), Rp (internal straight) and R (external taper).
- Call for system "B" gage pricing.
- Plug gages have one step at basic gage plane.

For TiN coated thread work plugs – call Swanson.

Flexible Hole Location Gages



Hole Location Gages (also referred to as Centerline Hole Location Plugs, or Flex Plugs) are used to measure the location of a tapped hole in a part, typically with a CMM. They are also used to determine centerline to centerline distances of threaded holes.

- Slotted at 90° increments to ensure positive location on the thread flanks, regardless of hole size (sizes over #10 or M5)
- Sizes #10 (M5) and smaller are solid with a front tapered thread section to cover the entire product tolerance (class 2B or 6H)
- The .2500" +/- .0001" (6.35mm +/- .0025mm) shank is concentric to the threaded section within .0002 T.I.R. prior to slotting
- For inspecting the location of a threaded hole in a part
- For determining centerline to centerline distances of threaded holes

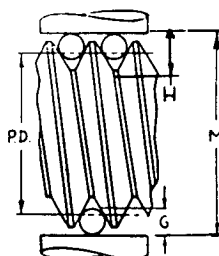
Inch

SIZE	PRICE	SIZE	PRICE
0-80 UNF	189.00	1/4-28 UNF	128.00
1-64 UNC	179.00	5/16-18 UNC	125.00
1-72 UNF	187.00	5/16-24 UNF	128.00
2-56 UNC	174.00	3/8-16 UNC	138.00
2-64 UNF	179.00	3/8-24 UNF	139.00
3-48 UNC	167.00	7/16-14 UNC	134.00
3-56 UNF	174.00	7/16-20 UNF	139.00
4-40 UNC	145.00	1/2-13 UNC	142.00
4-48 UNF	153.00	1/2-20 UNF	147.00
5-40 UNC	155.00	9/16-12 UNC	139.00
5-44 UNF	147.00	9/16-18 UNF	147.00
6-32 UNC	157.00	5/8-11 UNC	145.00
6-40 UNF	159.00	5/8-18 UNF	152.00
8-32 UNC	148.00	3/4-10 UNC	152.00
8-36 UNF	155.00	3/4-16 UNF	155.00
10-24 UNC	147.00	7/8-9 UNC	177.00
10-32 UNF	148.00	7/8-14 UNF	187.00
12-24 UNC	145.00	1"-8 UNC	252.00
12-28 UNF	147.00	1"-12 UNF	252.00
1/4-20 UNC	125.00		

Metric

SIZE	PRICE
M1.6 x 0.35	205.00
M2 x 0.4	197.00
M2.5 x 0.45	197.00
M3 x 0.5	192.00
M3.5 x 0.6	192.00
M4 x 0.7	187.00
M5 x 0.8	172.00
M6 x 1.0	153.00
M8 x 1.25	152.00
M8 x 1.0	152.00
M10 x 1.5	158.00
M10 x 1.25	159.00
M10 x 0.75	214.00
M12 x 1.75	167.00
M12 x 1.5	167.00
M12 x 1.25	172.00
M12 x 1.0	172.00
M14 x 2.0	177.00
M14 x 1.5	177.00
M15 x 1.0	177.00
M16 x 2.0	177.00
M16 x 1.5	187.00
M17 x 1.0	189.00
M18 x 1.5	189.00
M20 x 2.5	189.00
M20 x 1.5	192.00
M20 x 1.0	192.00
M22 x 2.5	209.00
M22 x 1.5	209.00
M24 x 3.0	228.00
M24 x 2.0	228.00

Calibrated Thread Measuring Wires



Measured Pitch Diameter (PD) =
Measurement over Wires (M) -
Constant (C)

60° Threads

(n) THREADS PER INCH	(G) NOMINAL BEST WIRE DIAMETER	(C) NOMINAL CONSTANT	PRICE SET OF THREE
120	.00481"	.00722"	166.00
100	.00577	.00866	166.00
96	.00601	.00902	166.00
90	.00642	.00962	166.00
80	.00722	.01083	166.00
72	.00802	.01203	166.00
64	.00902	.01353	166.00
56	.01031	.01546	166.00
50	.01155	.01732	166.00
48	.01203	.01804	103.00
44	.01312	.01968	103.00
40	.01443	.02165	103.00
36	.01604	.02406	103.00
32	.01804	.02706	103.00
30	.01925	.02887	103.00
28	.02062	.03093	103.00
27	.02138	.03208	103.00
26	.02221	.03331	103.00
24	.02406	.03608	103.00
22	.02624	.03936	103.00
20	.02887	.04330	103.00
18	.03208	.04811	103.00
16	.03608	.05413	103.00
14	.04124	.06186	103.00
13	.04441	.06662	103.00
12	.04811	.07217	103.00
11-1/2	.05020	.07531	103.00
11	.05249	.07873	103.00
10	.05774	.08660	103.00
9	.06415	.09623	103.00
8	.07217	.10825	103.00
7-1/2	.07698	.11547	103.00
7	.08248	.12372	103.00
6	.09623	.14434	103.00
5-1/2	.10497	.15746	166.00
5	.11547	.17321	166.00
4-1/2	.12830	.19245	166.00
4	.14434	.21651	166.00
3-1/2	.16496	.24744	166.00
3-1/4	.17765	.26647	166.00
3	.19245	.28868	166.00
2-3/4	.20995	.31492	166.00
2	.28868	.43301	166.00

60° Metric Threads

PITCH mm	NOMINAL BEST WIRE DIAMETER mm	NOMINAL CONSTANT mm	PRICE SET OF THREE
.2	.1155	.1732	166.00
.225	.1299	.1949	166.00
.25	.1443	.2165	166.00
.3	.1732	.2598	166.00
.35	.2021	.3031	166.00
.4	.2309	.3464	166.00
.45	.2598	.3897	166.00
.5	.2887	.4330	166.00
.6	.3464	.5196	166.00
.7	.4041	.6062	166.00
.75	.4330	.6495	146.00
.8	.4619	.6928	146.00
.9	.5196	.7794	146.00
1.0	.5774	.8660	103.00
1.25	.7217	1.0825	103.00
1.5	.8660	1.2990	103.00
1.75	1.0104	1.5155	103.00
2.0	1.1547	1.7321	103.00
2.5	1.4434	2.1651	103.00
3.0	1.7321	2.5981	103.00
3.5	2.0207	3.0311	103.00
4.0	2.3094	3.4641	103.00
4.5	2.5981	3.8971	129.00
5.0	2.8868	4.3301	166.00
5.5	3.1754	4.7631	166.00
6.0	3.4641	5.1962	166.00
7.0	4.0415	6.0622	166.00
8.0	4.6188	6.9282	166.00
9.0	5.1962	7.7942	166.00
10.0	5.7735	8.6603	166.00

**CERTIFICATE OF ACCURACY
INCLUDED WITH EACH SET**

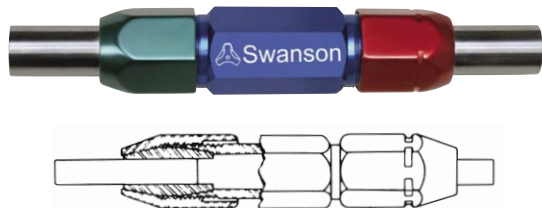
Special Thread Measuring Wires +/- 20 millionths

ABOVE - INCLUDING	SET OF 3
.004 - .005" .1016mm - .1270mm	CALL FOR PRICES
.005 - .007" .1270mm - .1778mm	
.007 - .010" .1778mm - .2540mm	
.010 - .0135" .2540mm - 3.429mm	
.135 - .260" 3.429mm - 6.604mm	
.260 - .385" 6.604mm - 9.779mm	
.385 - .510" 9.779mm - 12.954mm	
.510 - .635" 12.954mm - 16.129mm	
.635 - .760" 16.129mm - 19.304mm	
.760 - 1.010" 19.304mm - 25.654mm	

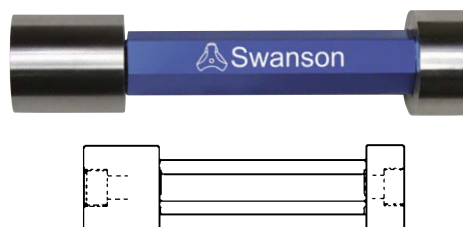
29° Acme Best Threads

THREADS PER INCH (n)	DIAMETER BEST SIZE WIRE	PRICE SET OF THREE
1	.51645"	192.00
1-1/3	.38734	192.00
1-1/2	.34430	192.00
1-3/4	.29511	192.00
2	.25823	192.00
2-1/2	.20658	192.00
3	.17215	192.00
3-1/2	.14756	154.00
4	.12911	154.00
4-1/2	.11477	154.00
5	.10329	154.00
5-1/2	.09390	154.00
6	.08608	154.00
7	.07378	154.00
8	.06456	154.00
9	.05738	154.00
10	.05164	154.00
12	.04304	154.00
14	.03689	154.00
16	.03228	154.00
18	.02869	154.00
20	.02582	154.00

Cylindrical Plug Gages



Reversible Style



Trilock Style

SIZE ABOVE – INCLUDING	CLASS	TOL.	GO OR NO GO LENGTH	HANDLE #
.010 to .075 .254mm to 1.91mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	1W 1W 1W 1W
.075 to .180 1.91mm to 4.57mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	2W 2W 2W 2W
.180 to .281 4.57mm to 7.14mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	3W 3W 3W 3W
.281 to .406 7.14mm to 10.31mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	4W 4W 4W 4W
.406 to .510 10.31mm to 12.95mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	5W 5W 5W 5W
.510 to .635 12.95mm to 16.13mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	6W 6W 6W 6W
.635 to .760 16.13mm to 19.30mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	7W 7W 7W 7W
.760 to .825 19.30mm to 20.96mm	XX X Y Z	.00002 .00004 .00007 .00010	2"	8W 8W 8W 8W
.825 to 1.010 20.96mm to 25.65mm	XX X Y Z	.00003 .00006 .00009 .00012	2"	8W 8W 8W 8W

SIZE ABOVE – INCLUDING	CLASS	TOL.	GO LENGTH	NO GO LENGTH	HANDLE #
.760 to .947 19.30mm to 24.05mm	XX X Y Z	.00003 .00006 .00009 .00012	1-1/4"	3/4"	2-1/2 2-1/2 2-1/2 2-1/2
.947 to 1.135 24.05mm to 28.83mm	XX X Y Z	.00003 .00006 .00009 .00012	1-3/8"	3/4"	3-1/2 3-1/2 3-1/2 3-1/2
1.135 to 1.510 28.83mm to 38.35mm	XX X Y Z	.00003 .00006 .00009 .00012	1-1/2"	3/4"	4-1/2 4-1/2 4-1/2 4-1/2
1.510 to 2.010 38.35mm to 51.05mm	XX X Y Z	.00004 .00008 .00012 .00016	1-7/8"	7/8"	5-1/2 5-1/2 5-1/2 5-1/2
2.010 to 2.510 51.05mm to 63.75mm	XX X Y Z	.00004 .00008 .00012 .00016	2"	7/8"	6 6 6 6
2.510 to 3.510 63.75mm to 89.15mm	XX X Y Z	.00005 .00010 .00015 .00020	2"	1"	7 7 7 7
3.510 to 4.510 89.15mm to 114.55mm	XX X Y Z	.00005 .00010 .00015 .00020	2-1/8"	1"	7 7 7 7
4.510 to 6.510 114.55mm to 165.35mm	XX X Y Z	.000065 .00013 .00019 .00025	2-1/8"	1"	7 7 7 7
6.510 to 8.010 165.35mm to 203.45mm	XX X Y Z	.00008 .00016 .00024 .00032	2-1/8"	1"	7 7 7 7

Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

Chrome and Carbide
also available

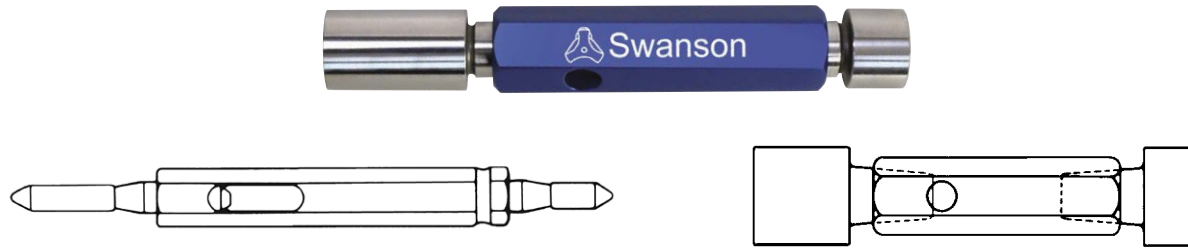
How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. GO or NO GO.
5. Handles (Single or Double End).
6. Marking.

CALL SWANSON FOR PRICING

Taperlock Cylindrical Plug Gages



SIZE ABOVE - INCLUDING	CLASS	TOL.	GO LENGTH	NO GO LENGTH	HANDLE #
.059 to .105 1.50mm to 2.67mm	XX	.00002	3/8"	3/16"	000
	X	.00004			000
	Y	.00007			000
	Z	.00010			000
.105 to .150 2.67mm to 3.81mm	XX	.00002	3/8"	7/32"	00
	X	.00004			00
	Y	.00007			00
	Z	.00010			00
.150 to .230 3.81mm to 5.84mm	XX	.00002	13/32"	9/32"	0
	X	.00004			0
	Y	.00007			0
	Z	.00010			0
.230 to .365 5.84mm to 9.27mm	XX	.00002	3/4"	5/16"	1
	X	.00004			1
	Y	.00007			1
	Z	.00010			1
.365 to .510 9.27mm to 12.95mm	XX	.00002	1"	3/8"	2
	X	.00004			2
	Y	.00007			2
	Z	.00010			2
.510 to .825 12.95mm to 20.96mm	XX	.00002	1-1/4"	1/2"	3
	X	.00004			3
	Y	.00007			3
	Z	.00010			3
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	1-1/2"	5/8"	4
	X	.00006			4
	Y	.00009			4
	Z	.00012			4
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-5/8"	3/4"	5
	X	.00006			5
	Y	.00009			5
	Z	.00012			5

Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

Chrome and Carbide
also available

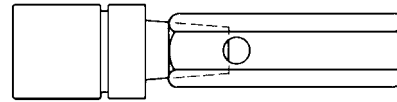
CALL SWANSON FOR PRICING

How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. GO or NO GO.
5. Handles (Single or Double End).
6. Marking.

Progressive Cylindrical Plug Gages



Taperlock Style

SIZE ABOVE - INCLUDING	CLASS	TOL.	MEMBER LENGTH	GO PORTION	NO GO PORTION	HANDLE #
.105 to .150 2.67mm to 3.81mm	XX	.00002	23/32"	3/8"	7/32"	00
	X	.00004				00
	Y	.00007				00
	Z	.00010				00
.150 to .230 3.81mm to 5.84mm	XX	.00002	13/16"	13/32"	9/32"	0
	X	.00004				0
	Y	.00007				0
	Z	.00010				0
.230 to .365 5.84mm to 9.27mm	XX	.00002	1-3/16"	3/4"	5/16"	1
	X	.00004				1
	Y	.00007				1
	Z	.00010				1
.365 to .510 9.27mm to 12.95mm	XX	.00002	1-1/2"	1"	3/8"	2
	X	.00004				2
	Y	.00007				2
	Z	.00010				2
.510 to .825 12.95mm to 20.96mm	XX	.00002	1-7/8"	1-1/4"	1/2"	3
	X	.00004				3
	Y	.00007				3
	Z	.00010				3
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	2-1/8"	1-3/8"	5/8"	4
	X	.00006				4
	Y	.00009				4
	Z	.00012				4
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	2-3/8"	1-1/2"	3/4"	5
	X	.00006				5
	Y	.00009				5
	Z	.00012				5

The Progressive Style is a Single End Gage having GO and NO GO members combined to make complete inspection of a hole possible with one insertion.

Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. Handles.
5. Marking.

Chrome and Carbide
also available

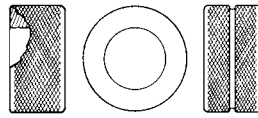
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Trilock Style

SIZE ABOVE - INCLUDING	CLASS	TOL.	MEMBER LENGTH	GO PORTION	NO GO PORTION	HANDLE #
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	2-7/8"	1-7/8"	7/8"	5-1/2
	X	.00008				5-1/2
	Y	.00012				5-1/2
	Z	.00016				5-1/2
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	3"	2"	7/8"	6
	X	.00008				6
	Y	.00012				6
	Z	.00016				6
2.510 to 3.510 63.75mm to 89.15mm	XX	.00005	3"	2"	7/8"	7
	X	.00010				7
	Y	.00015				7
	Z	.00020				7
3.510 to 4.510 89.15mm to 114.55mm	XX	.00005	3-1/8"	2-1/8"	7/8"	7
	X	.00010				7
	Y	.00015				7
	Z	.00020				7

Cylindrical Ring Gages

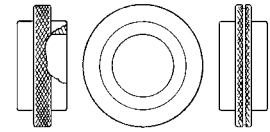
Solid Type



Sizes .040" - 1.510" (1.02mm-38.35mm)

SIZE ABOVE – INCLUDING	CLASS	TOL.	WIDTH	O.D.
.040 to .150 1.02mm to 3.81mm	XX	.00002	3/16"	15/16"
	X	.00004		
	Y	.00007		
	Z	.00010		
.150 to .230 3.81mm to 5.84mm	XX	.00002	3/8"	15/16"
	X	.00004		
	Y	.00007		
	Z	.00010		
.230 to .365 5.84mm to 9.27mm	XX	.00002	9/16"	1-1/8"
	X	.00004		
	Y	.00007		
	Z	.00010		
.365 to .510 9.27mm to 12.95mm	XX	.00002	3/4"	1-3/8"
	X	.00004		
	Y	.00007		
	Z	.00010		
.510 to .825 12.95mm to 20.96mm	XX	.00002	15/16"	1-3/4"
	X	.00004		
	Y	.00007		
	Z	.00010		
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	1-1/8"	2-1/8"
	X	.00006		
	Y	.00009		
	Z	.00012		
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-5/16"	2-1/2"
	X	.00006		
	Y	.00009		
	Z	.00012		

Flanged Type



Sizes Above 1.510" (38.35mm)

SIZE ABOVE – INCLUDING	CLASS	TOL.	WIDTH	O.D.
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	1-1/2"	4"
	X	.00008		
	Y	.00012		
	Z	.00016		
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	1-1/2"	4-1/2"
	X	.00008		
	Y	.00012		
	Z	.00016		
2.510 to 3.010 63.75mm to 76.45mm	XX	.00005	1-1/2"	5"
	X	.00010		
	Y	.00015		
	Z	.00020		
3.010 to 3.510 76.45mm to 89.15	XX	.00005	1-1/2"	5-1/2"
	X	.00010		
	Y	.00015		
	Z	.00020		
3.510 to 4.010 89.15mm to 101.85mm	XX	.00005	1-1/2"	6-3/8"
	X	.00010		
	Y	.00015		
	Z	.00020		
4.010 to 4.760 101.85mm to 120.90mm	XX	.00005	1-1/2"	7-1/4"
	X	.00010		
	Y	.00015		
	Z	.00020		
4.760 to 5.510 120.90mm to 139.95mm	XX	.000065	1-1/2"	8-1/4"
	X	.00013		
	Y	.00019		
	Z	.00025		
5.510 to 6.260 139.95mm to 159.00mm	XX	.000065	1-1/2"	9-1/4"
	X	.00013		
	Y	.00019		
	Z	.00025		
6.260 to 7.010 159.00mm to 178.05mm	XX	.00008	1-1/2"	10-1/4"
	X	.00016		
	Y	.00024		
	Z	.00032		
7.010 to 7.760 178.05mm to 197.10mm	XX	.00008	1-1/2"	11-1/4"
	X	.00016		
	Y	.00024		
	Z	.00032		
7.760 to 8.510 197.10mm to 216.15mm	XX	.00008	1-1/2"	12-1/4"
	X	.00016		
	Y	.00024		
	Z	.00032		

Plain Cylindrical Ring Gages conform to established AGD specifications. GO and NO GO Rings are made from blanks of the same dimension. An annular groove in the periphery of the NO GO ring distinguishes it from the GO Ring.

Direction of Tolerances

MASTER – Bilateral (Split)
GO – Unilateral (Minus)
NO GO – Unilateral (Plus)

Chrome and Carbide
also available

How to Order

Please specify:
1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. GO or NO GO or MASTER.
5. Marking.

CALL SWANSON FOR PRICING

Master Setting Discs

Style #1



Style #2



Style #3



Master Setting Discs are used for setting comparators, snap gages and other precision gages and are furnished with insulating grips to prevent heat distortion.

Direction of Tolerances

Unless otherwise specified, the gagemaker's tolerance will be applied bilaterally (split 1/2 plus 1/2 minus) on Styles #1 and #3. On Style #2 tolerances will be unilateral, minus on the "GO" section and plus on the "NO GO" section.

How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).*
3. Style.
4. Tolerance and direction.
5. Marking.

* Two diameters on Style #2

Chrome and Carbide
also available

SIZE ABOVE - INCLUDING	CLASS	TOL.	STYLE 1 LENGTH	STYLE 2 LENGTH	STYLE 3 LENGTH
.105 to .150 2.67mm to 3.81mm	XX X Y Z	.00002 .00004 .00007 .00010	3/4"	3/4"	3/8"
.150 to .230 3.81mm to 5.84mm	XX X Y Z	.00002 .00004 .00007 .00010	7/8"	7/8"	7/16"
.230 to .365 5.84mm to 9.27mm	XX X Y Z	.00002 .00004 .00007 .00010	1"	1"	1/2"
.365 to .510 9.27mm to 12.95mm	XX X Y Z	.00002 .00004 .00007 .00010	1-1/8"	1-1/8"	9/16"
.510 to .825 12.95mm to 20.96mm	XX X Y Z	.00002 .00004 .00007 .00010	1-1/4"	1-1/4"	5/8"
.825 to 1.135 20.96mm to 28.83mm	XX X Y Z	.00003 .00006 .00009 .00012	1-3/8"	1-3/8"	11/16"
1.135 to 1.510 28.83mm to 38.35mm	XX X Y Z	.00003 .00006 .00009 .00012	1-5/8"	1-5/8"	13/16"
1.510 to 2.010 38.35mm to 51.05mm	XX X Y Z	.00004 .00008 .00012 .00016	1-7/8"	1-7/8"	7/8"
2.010 to 2.510 51.05mm to 63.75mm	XX X Y Z	.00004 .00008 .00012 .00016	2"	2"	7/8"
2.510 to 3.010 63.75mm to 76.45mm	XX X Y Z	.00005 .00010 .00015 .00020	2-1/8"	2-1/8"	1"
3.010 to 4.510 76.45mm to 114.55mm	XX X Y Z	.00005 .00010 .00015 .00020	2-1/4"	2-1/4"	1"
4.510 to 6.510 114.55mm to 165.35mm	XX X Y Z	.000065 .00013 .00019 .00025	2-1/4"	2-1/4"	1"
6.510 to 8.010 165.35mm to 203.45mm	XX X Y Z	.00008 .00016 .00024 .00032	2-1/4"	2-1/4"	1"

CALL SWANSON FOR PRICING

Pitch Diameters – Thread Plug Gages



Table I
Classes 2B, 3B

Nominal Size	Go Basic All Classes All Series	UNIFIED PITCH DIAMETERS					Nominal Size	Go Basic All Classes All Series	UNIFIED PITCH DIAMETERS				
		No Go		X Tol. Go = + No Go = -	X Lead Tol.	X ± Half Angle Tol.			No Go		X Tol. Go = + No Go = -	X Lead Tol.	X ± Half Angle Tol.
#0-80 UNF	.0519	.0542	.0536	.0002	.0002	0°30'	9/16-24 UNEF	.5354	.5405	.5392	.0003	.0003	0°15'
#1-64 UNC	.0629	.0655	.0648	.0002	.0002	0°30'	5/8-11 UNC	.5660	.5732	.5714	.0003	.0003	0°10'
#1-72 UNF	.0640	.0665	.0659	.0002	.0002	0°30'	5/8-18 UNF	.5889	.5949	.5934	.0003	.0003	0°10'
#2-56 UNC	.0744	.0772	.0765	.0002	.0002	0°30'	5/8-24 UNEF	.5979	.6031	.6018	.0003	.0003	0°15'
#2-64 UNF	.0759	.0786	.0779	.0002	.0002	0°30'	11/16-24 UNEF	.6604	.6656	.6643	.0003	.0003	0°15'
#3-48 UNC	.0855	.0885	.0877	.0002	.0002	0°30'	3/4-10 UNC	.6850	.6927	.6907	.0003	.0003	0°10'
#3-56 UNF	.0874	.0902	.0895	.0002	.0002	0°30'	3/4-16 UNF	.7094	.7159	.7143	.0003	.0003	0°10'
#4-40 UNC	.0958	.0991	.0982	.0002	.0002	0°20'	3/4-20 UNEF	.7175	.7232	.7218	.0003	.0003	0°15'
#4-48 UNF	.0985	.1016	.1008	.0002	.0002	0°30'	13/16-20 UNEF	.7800	.7857	.7843	.0003	.0003	0°15'
#5-40 UNC	.1088	.1121	.1113	.0002	.0002	0°20'	7/8-9 UNC	.8028	.8110	.8089	.0003	.0003	0°10'
#5-44 UNF	.1102	.1134	.1126	.0002	.0002	0°20'	7/8-14 UNF	.8286	.8356	.8339	.0003	.0003	0°10'
#6-32 UNC	.1177	.1214	.1204	.0003	.0003	0°15'	7/8-20 UNEF	.8425	.8482	.8468	.0003	.0003	0°15'
#6-40 UNF	.1218	.1252	.1243	.0002	.0002	0°20'	15/16-20 UNEF	.9050	.9109	.9094	.0003	.0003	0°15'
#8-32 UNC	.1437	.1475	.1465	.0003	.0003	0°15'	1"-8 UNC	.9188	.9276	.9254	.0004	.0004	0°05'
#8-36 UNF	.1460	.1496	.1487	.0002	.0002	0°20'	1"-12 UNF	.9459	.9535	.9516	.0003	.0003	0°10'
#10-24 UNC	.1629	.1672	.1661	.0003	.0003	0°15'	1"-14 UNS	.9536	.9609	.9590	.0003	.0003	0°10'
#10-32 UNF	.1697	.1736	.1726	.0003	.0003	0°15'	1"-20 UNEF	.9675	.9734	.9719	.0003	.0003	0°15'
#12-24 UNC	.1889	.1933	.1922	.0003	.0003	0°15'	11/16-12 UN	1.0084	1.0158	1.0139	.0003	.0003	0°10'
#12-28 UNF	.1928	.1970	.1959	.0003	.0003	0°15'	11/16-18 UNEF	1.0264	1.0326	1.0310	.0003	.0003	0°10'
#12-32 UNEF	.1957	.1998	.1988	.0003	.0003	0°15'	11/8-7 UNC	1.0322	1.0416	1.0393	.0004	.0004	0°05'
1/4-20 UNC	.2175	.2224	.2211	.0003	.0003	0°15'	1 1/8-12 UNF	1.0709	1.0787	1.0768	.0003	.0003	0°10'
1/4-28 UNF	.2268	.2311	.2300	.0003	.0003	0°15'	1 1/8-18 UNEF	1.0889	1.0951	1.0935	.0003	.0003	0°10'
1/4-32 UNEF	.2297	.2339	.2328	.0003	.0003	0°15'	13/16-12 UN	1.1334	1.1409	1.1390	.0003	.0003	0°10'
5/16-18 UNC	.2764	.2817	.2803	.0003	.0003	0°10'	13/16-18 UNEF	1.1514	1.1577	1.1561	.0003	.0003	0°10'
5/16-24 UNF	.2854	.2902	.2890	.0003	.0003	0°15'	1 1/4-7 UNC	1.1572	1.1668	1.1644	.0004	.0004	0°05'
5/16-32 UNEF	.2922	.2964	.2953	.0003	.0003	0°15'	1 1/4-12 UNF	1.1959	1.2039	1.2019	.0003	.0003	0°10'
3/8-16 UNC	.3344	.3401	.3387	.0003	.0003	0°10'	1 1/4-18 UNEF	1.2139	1.2202	1.2186	.0003	.0003	0°10'
3/8-24 UNF	.3479	.3528	.3516	.0003	.0003	0°15'	15/16-12 UN	1.2584	1.2659	1.2640	.0003	.0003	0°10'
3/8-32 UNEF	.3547	.3591	.3580	.0003	.0003	0°15'	15/16-18 UNEF	1.2764	1.2827	1.2811	.0003	.0003	0°10'
7/16-14 UNC	.3911	.3972	.3957	.0003	.0003	0°10'	13/8-6 UNC	1.2667	1.2771	1.2745	.0004	.0004	0°05'
7/16-20 UNF	.4050	.4104	.4091	.0003	.0003	0°15'	13/8-12 UNF	1.3209	1.3291	1.3270	.0003	.0003	0°10'
7/16-28 UNEF	.4143	.4189	.4178	.0003	.0003	0°15'	13/8-18 UNEF	1.3389	1.3452	1.3436	.0003	.0003	0°10'
1/2-13 UNC	.4500	.4565	.4548	.0003	.0003	0°10'	17/16-12 UN	1.3834	1.3910	1.3891	.0003	.0003	0°10'
1/2-20 UNF	.4675	.4731	.4717	.0003	.0003	0°15'	17/16-18 UNEF	1.4014	1.4079	1.4062	.0003	.0003	0°10'
1/2-28 UNEF	.4768	.4816	.4804	.0003	.0003	0°15'	1 1/2-6 UNC	1.3917	1.4022	1.3996	.0004	.0004	0°05'
9/16-12 UNC	.5084	.5152	.5135	.0003	.0003	0°10'	1 1/2-12 UNF	1.4459	1.4542	1.4522	.0003	.0003	0°10'
9/16-18 UNF	.5264	.5323	.5308	.0003	.0003	0°10'	1 1/2-18 UNEF	1.4639	1.4704	1.4687	.0003	.0003	0°10'

Pitch Diameters – Thread Ring & Setting Plug Gages



Table II
Classes 2A, 3A

Nominal Size	UNIFIED PITCH DIAMETERS					Nominal Size	UNIFIED PITCH DIAMETERS				
	Class 2A		Class 3A		X Tol. Go = - No Go = +		Class 2A		Class 3A		X Tol. Go = - No Go = +
	Go	No Go	Go	No Go			Go	No Go	Go	No Go	
#0-80 UNF	.0514	.0496	.0519	.0506	.0002	9/16-24 UNEF	.5342	.5303	.5354	.5325	.0003
#1-64 UNC	.0623	.0603	.0629	.0614	.0002	5/8-11 UNC	.5644	.5589	.5660	.5619	.0003
#1-72 UNF	.0634	.0615	.0640	.0626	.0002	5/8-18 UNF	.5875	.5828	.5889	.5854	.0003
#2-56 UNC	.0738	.0717	.0744	.0728	.0002	5/8-24 UNEF	.5967	.5927	.5979	.5949	.0003
#2-64 UNF	.0753	.0733	.0759	.0744	.0002	11/16-24 UNEF	.6592	.6552	.6604	.6574	.0003
#3-48 UNC	.0848	.0825	.0855	.0838	.0002	3/4-10 UNC	.6832	.6773	.6850	.6806	.0003
#3-56 UNF	.0867	.0845	.0874	.0858	.0002	3/4-16 UNF	.7079	.7029	.7094	.7056	.0003
#4-40 UNC	.0950	.0925	.0958	.0939	.0002	3/4-20 UNEF	.7162	.7118	.7175	.7142	.0003
#4-48 UNF	.0978	.0954	.0985	.0967	.0002	13/16-20 UNEF	.7787	.7743	.7800	.7767	.0003
#5-40 UNC	.1080	.1054	.1088	.1069	.0002	7/8-9 UNC	.8009	.7946	.8028	.7981	.0003
#5-44 UNF	.1095	.1070	.1102	.1083	.0002	7/8-14 UNF	.8270	.8216	.8286	.8245	.0003
#6-32 UNC	.1169	.1141	.1177	.1156	.0003	7/8-20 UNEF	.8412	.8368	.8425	.8392	.0003
#6-40 UNF	.1210	.1184	.1218	.1198	.0002	15/16-20 UNEF	.9036	.8991	.9050	.9016	.0003
#8-32 UNC	.1428	.1399	.1437	.1415	.0003	1"-8 UNC	.9168	.9100	.9188	.9137	.0004
#8-36 UNF	.1452	.1424	.1460	.1439	.0002	1"-12 UNF	.9441	.9382	.9459	.9415	.0003
#10-24 UNC	.1619	.1586	.1629	.1604	.0003	1"-14 UNS	.9519	.9463	.9536	.9494	.0003
#10-32 UNF	.1688	.1658	.1697	.1674	.0003	1"-20 UNEF	.9661	.9616	.9675	.9641	.0003
#12-24 UNC	.1879	.1845	.1889	.1863	.0003	11/16-12 UN	1.0067	1.0010	1.0084	1.0042	.0003
#12-28 UNF	.1918	.1886	.1928	.1904	.0003	11/16-18 UNEF	1.0250	1.0203	1.0264	1.0228	.0003
#12-32 UNEF	.1948	.1917	.1957	.1933	.0003	1 1/8-7 UNC	1.0300	1.0228	1.0322	1.0268	.0004
1/4-20 UNC	.2164	.2127	.2175	.2147	.0003	1 1/8-12 UNF	1.0691	1.0631	1.0709	1.0664	.0003
1/4-28 UNF	.2258	.2225	.2268	.2243	.0003	1 1/8-18 UNEF	1.0875	1.0828	1.0889	1.0853	.0003
1/4-32 UNEF	.2287	.2255	.2297	.2273	.0003	13/16-12 UN	1.1317	1.1259	1.1334	1.1291	.0003
5/16-18 UNC	.2752	.2712	.2764	.2734	.0003	13/16-18 UNEF	1.1499	1.1450	1.1514	1.1478	.0003
5/16-24 UNF	.2843	.2806	.2854	.2827	.0003	1 1/4-7 UNC	1.1550	1.1476	1.1572	1.1517	.0004
5/16-32 UNEF	.2912	.2880	.2922	.2898	.0003	1 1/4-12 UNF	1.1941	1.1879	1.1959	1.1913	.0003
3/8-16 UNC	.3331	.3287	.3344	.3311	.0003	1 1/4-18 UNEF	1.2124	1.2075	1.2139	1.2103	.0003
3/8-24 UNF	.3468	.3430	.3479	.3450	.0003	15/16-12 UN	1.2567	1.2509	1.2584	1.2541	.0003
3/8-32 UNEF	.3537	.3503	.3547	.3522	.0003	15/16-18 UNEF	1.2749	1.2700	1.2764	1.2728	.0003
7/16-14 UNC	.3897	.3850	.3911	.3876	.0003	1 3/8-6 UNC	1.2643	1.2563	1.2667	1.2607	.0004
7/16-20 UNF	.4037	.3995	.4050	.4019	.0003	1 3/8-12 UNF	1.3190	1.3127	1.3209	1.3162	.0003
7/16-28 UNEF	.4132	.4096	.4143	.4116	.0003	1 3/8-18 UNEF	1.3374	1.3325	1.3389	1.3353	.0003
1/2-13 UNC	.4485	.4435	.4500	.4463	.0003	17/16-12 UN	1.3816	1.3757	1.3834	1.3790	.0003
1/2-20 UNF	.4662	.4619	.4675	.4643	.0003	17/16-18 UNEF	1.3999	1.3949	1.4014	1.3977	.0003
1/2-28 UNEF	.4757	.4720	.4768	.4740	.0003	1 1/2-6 UNC	1.3893	1.3812	1.3917	1.3856	.0004
9/16-12 UNC	.5068	.5016	.5084	.5045	.0003	1 1/2-12 UNF	1.4440	1.4376	1.4459	1.4411	.0003
9/16-18 UNF	.5250	.5205	.5264	.5230	.0003	1 1/2-18 UNEF	1.4624	1.4574	1.4639	1.4602	.0003

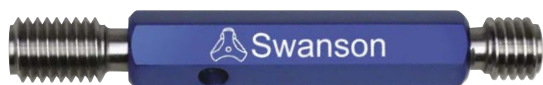
Pitch Diameters – (STI) Screw Thread Insert Plug Gages



Table III
Classes 2B, 3B

Nominal Size	PITCH DIAMETERS			X Tol. Go = + No Go = -
	GO	2B NO GO	3B NO GO	
#4-40 UNC	.1283	.1308	.1299	.0002
#4-48 UNF	.1256	.1279	.1271	.0002
#5-40 UNC	.1413	.1438	.1430	.0002
#6-32 UNC	.1583	.1611	.1601	.0003
#6-40 UNF	.1543	.1569	.1560	.0002
#8-32 UNC	.1843	.1872	.1862	.0003
#8-36 UNF	.1821	.1849	.1840	.0002
#10-24 UNC	.2170	.2203	.2192	.0003
#10-32 UNF	.2103	.2133	.2123	.0003
#12-24 UNC	.2430	.2464	.2453	.0003
1/4-20 UNC	.2825	.2864	.2851	.0003
1/4-28 UNF	.2732	.2765	.2754	.0003
5/16-18 UNC	.3486	.3529	.3515	.0003
5/16-24 UNF	.3395	.3433	.3421	.0003
3/8-16 UNC	.4156	.4203	.4189	.0003
3/8-24 UNF	.4020	.4059	.4047	.0003
7/16-14 UNC	.4839	.4890	.4875	.0003
7/16-20 UNF	.4700	.4744	.4731	.0003
1/2-13 UNC	.5499	.5554	.5537	.0003
1/2-20 UNF	.5325	.5371	.5357	.0003
9/16-12 UNC	.6167	.6225	.6208	.0003
9/16-18 UNF	.5986	.6035	.6020	.0003
5/8-11 UNC	.6841	.6903	.6885	.0003
5/8-18 UNF	.6611	.6661	.6646	.0003
3/4-10 UNC	.8149	.8216	.8196	.0003
3/4-16 UNF	.7906	.7961	.7945	.0003

Pitch Diameters – Metric Thread Gages



**Table IV (Internal)
Thread Plug Gages**

SIZE mm	PITCH mm	PITCH DIAMETERS		
		Go (Basic)	No Go 4H	No Go 6H
M1.6	0.35	1.373	1.426	1.458
M1.8	0.35	1.573	1.626	1.658
M2	0.4	1.740	1.796	1.830
M2.2	0.45	1.908	1.968	2.003
M2.5	0.45	2.208	2.268	2.303
M3	0.5	2.675	2.738	2.775
M3.5	0.6	3.110	3.181	3.222
M4	0.7	3.545	3.620	3.663
M4.5	0.75	4.013	4.088	4.131
M5	0.8	4.480	4.560	4.605
M6	1	5.350	5.445	5.500
M7	1	6.350	6.445	6.500
M8	1.25	7.188	7.288	7.348
M8	1	7.350	7.445	7.500
M10	1.5	9.026	9.138	9.206
M10	1.25	9.188	9.288	9.348
M12	1.75	10.863	10.988	11.063
M12	1.25	11.188	11.300	11.368
M14	2	12.701	12.833	12.913
M14	1.5	13.026	13.144	13.216
M16	2	14.701	14.833	14.913
M16	1.5	15.026	15.144	15.216
M18	2.5	16.376	16.516	16.600
M18	1.5	17.026	17.144	17.216
M20	2.5	18.376	18.516	18.600
M20	1.5	19.026	19.144	19.216
M22	2.5	20.376	20.516	20.600
M22	1.5	21.026	21.144	21.216
M24	3	22.051	22.221	22.316
M24	2	22.701	22.841	22.925
M27	3	25.051	25.221	25.316
M27	2	25.701	25.841	25.925
M30	3.5	27.727	27.907	28.007
M30	2	28.701	28.841	28.925
M33	3.5	30.727	30.907	31.007
M33	2	31.701	31.841	31.925
M36	4	33.402	33.592	33.702
M36	3	34.051	34.221	34.316
M39	4	36.402	36.592	36.702
M39	3	37.051	37.221	37.316



**Table V (External)
Thread Ring & Setting Plug Gages**

SIZE mm	PITCH mm	PITCH DIAMETERS		
		Go 4g & 6g	No Go 4g	No Go 6g
M1.6	0.35	1.354	1.314	1.291
M1.8	0.35	1.554	1.514	1.491
M2	0.4	1.721	1.679	1.654
M2.2	0.45	1.888	1.843	1.817
M2.5	0.45	2.188	2.143	2.117
M3	0.5	2.655	2.607	2.580
M3.5	0.6	3.089	3.036	3.004
M4	0.7	3.523	3.467	3.433
M4.5	0.75	3.991	3.935	3.901
M5	0.8	4.456	4.396	4.361
M6	1	5.324	5.253	5.212
M7	1	6.324	6.253	6.212
M8	1.25	7.160	7.085	7.042
M8	1	7.324	7.253	7.212
M10	1.5	8.994	8.909	8.862
M10	1.25	9.160	9.085	9.042
M12	1.75	10.829	10.734	10.679
M12	1.25	11.160	11.075	11.028
M14	2	12.663	12.563	12.503
M14	1.5	12.994	12.904	12.854
M16	2	14.663	14.563	14.503
M16	1.5	14.994	14.904	14.854
M18	2.5	16.334	16.228	16.164
M18	1.5	16.994	16.904	16.854
M20	2.5	18.334	18.228	18.164
M20	1.5	18.994	18.904	18.854
M22	2.5	20.334	20.228	20.164
M22	1.5	20.994	20.904	20.854
M24	3	22.003	21.878	21.803
M24	2	22.663	22.557	22.493
M27	3	25.003	24.878	24.803
M27	2	25.663	25.557	25.493
M30	3.5	27.674	27.542	27.462
M30	2	28.663	28.557	28.493
M33	3.5	30.674	30.542	30.462
M33	2	31.663	31.557	31.493
M36	4	33.342	33.202	33.118
M36	3	34.003	33.878	33.803
M39	4	36.342	36.202	36.118
M39	3	37.003	36.878	36.803

Note: To obtain inch values for pitch diameters multiply by .03937.

Pitch Diameters – Straight Pipe Gages



Table VI

PIPE SIZE	MEMBER	PITCH DIAMETERS FOR STRAIGHT PIPE GAGES						
		THREAD PLUG GAGES					THREAD RING GAGES	
		NPSF	NPSI	NPSL	NPSC	NPSM-2B	NPSM-2A	NPSL
1/16-27	Go	.2768	.2791					
	No Go	.2803	.2826					
1/8-27	Go	.3692	.3715	.3863	.3701	.3736	.3725	.3840
	No Go	.3727	.3750	.3898	.3771	.3783	.3689	.3805
1/4-18	Go	.4852	.4886	.5073	.4864	.4916	.4903	.5038
	No Go	.4904	.4938	.5125	.4968	.4974	.4859	.4986
3/8-18	Go	.6205	.6240	.6444	.6218	.6270	.6256	.6409
	No Go	.6257	.6292	.6496	.6322	.6329	.6211	.6357
1/2-14	Go	.7700	.7745	.8008	.7717	.7784	.7769	.7963
	No Go	.7767	.7812	.8075	.7851	.7851	.7718	.7896
3/4-14	Go	.9805	.9850	1.0112	.9822	.9889	.9873	1.0067
	No Go	.9872	.9917	1.0179	.9956	.9958	.9820	1.0000
1"-11 1/2	Go	1.2284	1.2338	1.2658	1.2305	1.2386	1.2369	1.2604
	No Go	1.2365	1.2420	1.2739	1.2468	1.2462	1.2311	1.2523
1 1/4-11 1/2	Go			1.6106	1.5752	1.5834	1.5816	1.6051
	No Go			1.6187	1.5915	1.5912	1.5756	1.5970
1 1/2-11 1/2	Go			1.8495	1.8142	1.8223	1.8205	1.8441
	No Go			1.8576	1.8305	1.8302	1.8144	1.8360
2"-11 1/2	Go			2.3234	2.2881	2.2963	2.2944	2.3180
	No Go			2.3315	2.3044	2.3044	2.2882	2.3099

NPSM–National Pipe Straight Mechanical–These external and internal threads are intended for free-fitting mechanical joints where there are no internal pressures. The product is gaged with straight Go and No Go plug and ring gages.

NPSL–National Pipe Straight Locknut–These external and internal threads are intended to produce a thread having the largest diameter that is possible to cut on standard pipe. The product is gaged with straight Go and No Go plug and ring gages.

NH–National Fire-Hose Coupling Threads–These external and internal threads are intended for fire hose, garden hose, chemical engine and booster hose. The product is gaged with straight Go and No Go plug and ring gages.

NPSH–National Hose Coupling Threads–These external and internal threads are intended for steam, air, water, and all other hose connections to be made up with standard pipe threads. The product is gaged with straight Go and No Go plug and ring gages.

NPSC–National Pipe Straight Coupling–These internal threads are intended to form low pressure tight joints when assembled with NPT external threads by using a sealer. The product may be gaged with a NPT plug gage or with straight Go and No Go plug gages.

NPSF–Dryseal American Standard Fuel–These internal threads are intended for use in soft or ductile materials for assembly with NPTF external threads without using a sealer. The product may be gaged with NPTF-LI basic notch plug gage or with straight Go and No Go plug gages.

NPSI–Dryseal American Standard Intermediate–These internal threads are intended for use in hard or brittle materials for assembly with PTF-SAE short external threads but may also be assembled with full length NPTF external threads. The product may be gaged with a NPTF-LI basic notch plug gage or with straight Go and No Go plug gages.

NOTE: NPSM and NPSF Series Gages are available from stock.

ANSI Thread Series Designations

DESIGNATIONS	THREAD SERIES
UN	Unified National, Constant Pitch, 60°, Inch
UNC	Unified National Coarse, 60°, Inch
UNF	Unified National Fine, 60°, Inch
UNEF	Unified National Extra Fine, 60°, Inch
UNS	Unified National Special, 60°, Inch
N, NC, NF, NEF, NS	American National, 60°, Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special
UNJ, UNJC, UNJF, UNJEF, UNJS	Unified National, 60° Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special, with .18042P Controlled Root Radius on External Thread
UNR, UNRC, UNRF, UNREF, UNRS	Unified National, 60° Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special, with .144P Controlled Root Radius on External Thread
ACME-G, ACME-C	Acme, General Purpose and Centralizing, 29°
AMO	American Microscopic Objective, 55°, Inch
NC5, NC5HF, NC5CSF, NC5ONF, NC5IF, NC5INF	American National Coarse Interference Fit, 60°, Inch, HF – Hard Ferrous, CSF – Copper or Soft Ferrous, ONF – Other Nonferrous, IF – Entire Ferrous, INF – Entire Nonferrous
M	Metric, 60°
MJ	Metric, 60° with .15P to .18P Controlled Root Radius on External Thread
UNM	Unified National Miniature, 60° Metric
ANPT	Aeronautical National Pipe Taper, 60° Taper, Inch
NPT	National (American) Pipe Taper, 60° Taper, Inch
NPTF	National (American) Pipe Taper Fuel, Dryseal, 60° Taper, Inch
PTF-SAE SHORT	National (American) Pipe Taper Fuel Short, Dryseal, 60° Taper, Inch
F-PTF	National (American) Pipe Taper Fuel Short Fine, Dryseal, 60° Taper, Inch
NPSL	National (American) Pipe Straight Locknut, 60° Taper, Inch
NPSM	National (American) Pipe Straight Mechanical, 60° Taper, Inch
NPSC	National (American) Pipe Straight Coupling, 60° Taper, Inch
NPSF	National (American) Pipe Straight Fuel, 60° Taper, Inch
NPSI	National (American) Pipe Straight Intermediate, 60° Taper, Inch
NPSH	National (American) Pipe Straight Hose, 60° Taper, Inch, for Hose Couplings
NH	National (American) Pipe Straight Hose, 60° Taper, Inch, for Fire Hose Couplings
NHR	National (American) Pipe Straight Hose, 60° Taper, Inch, for Garden Hose Applications
NGT, SGT	National Gas Taper & Special Gas Taper, 60° Taper, Inch
NGO	National Gas Outlet, 60° Straight, Inch
NGS	National Gas Straight, 60° Straight, Inch
SPL-PTF	National (American) Pipe Taper Fuel Short, Special Diameter – Pitch Combination Dryseal, 60° Taper, Inch
STUB ACME	Stub Acme, 29° Inch, reduced thread height of standard Acme
BUTT	Buttress, "PULL" type 45° clearance flank leading / 7° load flank, Inch
PUSH-BUTT	Buttress, "PUSH" type 7° load flank leading / 45° clearance flank, Inch
STI	Helical Coil Screw Thread Insert, Inch and Metric
R (BSPT), Rc (BSPT), Rp	British Standard Pipe For Pressure Tight Joints, - Rc (internal taper), Rp (Internal straight) and R (External taper) 55° Whitworth Form, Inch
G (BSPP)	British Standard Pipe For Non-Pressure Tight Joints, - - G (Internal and external straight) 55° Whitworth Form, Inch
BA	British Association, 47.5°
BSF	British Association Standard Fine Pitch, 55° Whitworth Form, Inch
BSW	British Association Standard Whitworth Coarse Pitch, 55° Whitworth Form, Inch
AWWA	American Water Works Association, for Underground Service Line Fittings, Taper and Straight 60°, Inch
DIN	Deutsches Institut für Normung, German Institute for Standardization
JIS	Japanese Industrial Standard
ISO	International Standards Organization

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