

# Thread Ring & Setting Plug Gages

HEMCO

- ❑ HemcoChrome Process on thread rings, set plugs are 0-1 tool steel unless otherwise specified.
- ❑ All gages are made to ANSI B47.1 and Screw Thread Standards for Federal Services: Federal Std. H28 and ANSI B1.2.
- ❑ All thread ring gages are root relieved for adjustability and longer life. NoGo rings are identified by a groove around the outside diameter.
- ❑ Setting plugs should be ordered at the same time as ring gages to assure perfect adjustment and provide for inspection of rings once in use.
- ❑ Set plugs are built to "X" tolerance on pitch diameter "W" tolerance on lead and flank angles standard.
- ❑ "W" tolerance on pitch diameter is optional and must be specified.



Standard Inch Nominal Range		Metric Nominal Range		Set Plug Dimensions (refer to Figure 1 on page 11)				Ring Dimensions			
Above	To and Including	Above	To and Including	Style	For Thin Ring "A" Dim.	For Thick Ring "A" Dim.	Handle Size	Ring Size	Ring Outside Dia.	Thin Ring Width	Thick Ring Width
.059	.090	1.50	2.29	Taperlock	7/32	-	000	1-T	1	1/4	-
.090	.105	2.29	2.67	Taperlock	3/8	-	000	1-T	1	1/4	-
.105	.150	2.67	3.81	Taperlock	3/8	-	00	1-T	1	1/4	-
.150	.230	3.81	5.84	Taperlock	13/32	-	0	1-T	1	1/4	-
.230	.365	5.84	9.27	Taperlock	3/4	-	1	2-T	1-3/8	11/32	-
.365	.510	9.27	12.95	Taperlock	1	-	2	3-T	1-3/4	7/16	-
.510	.825	12.95	20.96	Taperlock	1-1/4	1-7/8	3	4-T	2-3/16	9/16	3/4
.825	1.135	20.96	28.83	Taperlock	1-1/2	2-1/8	4	5-T	2-5/8	11/16	15/16
1.135	1.510	28.83	38.35	Taperlock	1-5/8	2-3/8	5	6-T	3-1/4	3/4	1-1/8
1.510	2.010	38.35	51.05	Trilock	1-7/8	2-7/8	5 1/2	7-T	3-3/4	13/16	1-1/4
2.010	2.510	51.05	63.75	Trilock	2	3	6	8-T	4-1/2	7/8	1-5/16
2.510	3.010	63.75	76.45	Trilock	2	3-1/8	7	9-T	5	7/8	1-3/8
3.010	3.510	76.45	89.15	Trilock	2	3-1/8	7	10-T	5-1/2	15/16	1-7/16
3.510	4.010	89.15	101.85	Trilock	2-1/8	3-1/4	7	11-T	6-3/8	15/16	1-1/2
4.010	4.760	101.85	120.90	Trilock	2-1/8	3-1/4	7	12-T	7-1/4	1	1-1/2
4.760	5.510	120.90	139.95	Trilock	2-1/8	3-1/4	7	13-T	8-1/4	1	1-1/2
5.510	6.260	139.95	159.00	Trilock	2-1/8	3-1/4	7	14-T	9-1/4	1	1-1/2
6.260	7.010	159.00	178.05	Trilock	2-1/8	3-1/4	7	15-T	10-1/4	1	1-1/2
7.010	7.760	178.05	197.10	Trilock	2-1/8	3-1/4	7	16-T	11-1/4	1	1-1/2
7.760	8.510	197.10	216.15	Annular	2-1/8	3-1/4	Ball	17-T	12-1/4	1	1-1/2
8.510	9.260	216.15	235.20	Annular	2-1/8	3-1/4	Ball	18-T	13-1/4	1	1-1/2
9.260	10.010	235.20	254.25	Annular	2-1/8	3-1/4	Ball	19-T	14-1/4	1	1-1/2
10.010	10.760	254.25	273.30	Annular	2-1/8	3-1/4	Ball	20-T	15-1/4	1	1-1/2
10.760	11.510	273.30	292.35	Annular	2-1/8	3-1/4	Ball	21-T	16-1/4	1	1-1/2
11.510	12.260	292.35	311.40	Annular	2-1/8	3-1/4	Ball	22-T	17-1/4	1	1-1/2

Diameter  
From No.0 to 1/2" Inclusive  
From 1/2" to 1-1/8" inclusive  
Above 1-1/8"

Thin Blank  
All Pitches  
12 TPI and finer except 9/16-12  
10 TPI and finer

Thick Blank  
Not Applicable  
12 TPI and coarser  
10 TPI and coarser

Thread Rings & Master Setting Plugs.	Qty.	Nominal Size & T.P.I.	Select One						Pitch Diameter	Ring Options	Set Plug Options
			Series		Class	Condition	Tolerance	Certifications			
			UNC UNF UNEF UNS UNJ	Acme Buttress Mod. Acme Mod. Buttress British Whitworth DIN/JIS	1, 1A 2, 2A 3, 3A 2C, 3C 2G, 3G	Go or NoGo (Lo)	"X" "W"	Short Form Long Form			
Example	1	3/8-16	UNC		2A	Go		Long Form	.3331		
							Note 5	Note 6	Note 2	Note 4	Note 4

- Notes: 1. Unless specified, standard gage handles are black anodized. Metric gage handles are yellow anodized.  
 2. For Standard Pitch Diameters, consult charts on page 19 & 20.  
 3. Specify if you wish to have rings set to master setting plugs.  
 4. Drawings must accompany orders for specials where applicable.  
 5. Made to "X" tolerance unless specified.  
 6. See Page 3 for explanation of Short & Long Form Certifications.