

TAPER PIPE THREAD GAGES

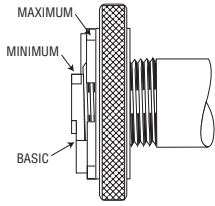


Fig. 8 Checking major diameter truncation with 6 step plain ring gage.

The L2 ring is used to gage the effective external threads beyond the L1 location length. It is relieved by counterboring at the small end to a depth equal to L1 minus 1P. The L2 is used like the thin L1 gage is used with a count of the number of turns by which the product over travels or fails to reach basic. The two gages together inspect the lead, pitch diameter, taper, and minor diameter. When both the L1 and L2 rings are used, the relative position of the small end of the pipe and the basic gaging face of the rings may not vary more than 1/2 turn.

The 6 step plain taper ring gage checks the truncation of the crest at the major diameter. Three of the steps represent the minimum truncation for the basic, maximum and minimum thread sizes – B, MN, MX. The other three represent the corresponding maximum truncation.

The 6 step plain ring is used similar to the 6 step plain plug. The ring is always used with a limit type thin L1 ring gage.



TAPER PIPE THREAD GAGES - NPT AND NPTF

NPT(ANSI/ASME B1.20.1)

NPTF(ANSI/ASME B1.20.5)



SIZE	NPT PLUG	NPT RING	NPTF PLUGS L1 or L3	NPTF PLUGS 6 STEP PLAIN	NPTF RINGS L1	NPTF RINGS L2	NPTF RINGS 6 STEP PLAIN	HANDLES
1/16-27	\$68.00	\$129.00	\$86.00	\$139.00	\$139.00	\$191.00	\$219.00	\$10.00
1/8-27	50.00	91.00	63.00	139.00	97.00	185.00	219.00	10.00
1/4-18	56.00	99.00	73.00	139.00	115.00	191.00	219.00	10.00
3/8-18	62.00	109.00	86.00	139.00	120.00	185.00	219.00	11.00
1/2-14	69.00	121.00	100.00	139.00	127.00	193.00	219.00	11.00
3/4-14	80.00	139.00	109.00	146.00	141.00	218.00	244.00	11.00
1-11 1/2	89.00	160.00	120.00	158.00	164.00	238.00	244.00	11.00
1 1/4-11 1/2	99.00	175.00	132.00	168.00	176.00	258.00	262.00	11.00
1 1/2-11 1/2	112.00	206.00	154.00	184.00	210.00	283.00	299.00	11.00
2-11 1/2	136.00	252.00	181.00	255.00	283.00	328.00	341.00	11.00
2 1/2-8	165.00	293.00	265.00	393.00	316.00	393.00	405.00	14.00
3-8	191.00	372.00	297.00	425.00	365.00	464.00	495.00	14.00
3 1/2-8	295.00	473.00						16.00
4-8	320.00	540.00						16.00
5-8	430.00	645.00						16.00
6-8	535.00	761.00						16.00

Master gages priced on request.

Long form calibration - add \$30. per gage.

TAPER PIPE THREADS - ANPT - WORKING & INSPECTION

SAE AS71051 and MIL-G-10944



SIZE	L-1 RING GAGE BASIC STEP	L-2 RING GAGE BASIC STEP	PLAIN TAPER RING 6 STEP	L-1 PLUG GAGE BASIC STEP	L-3 PLUG GAGE BASIC STEP	PLAIN TAPER PLUG 6 STEP	HANDLE
1/16-27	\$210.00	\$245.00	\$260.00	\$145.00	\$175.00	\$165.00	\$10.00
1/8-27	185.00	225.00	260.00	145.00	175.00	165.00	10.00
1/4-18	180.00	230.00	255.00	145.00	140.00	165.00	10.00
3/8-18	180.00	225.00	255.00	135.00	135.00	165.00	10.00
1/2-14	165.00	235.00	255.00	130.00	145.00	165.00	10.00
3/4-14	175.00	255.00	285.00	140.00	145.00	175.00	10.00
1-11 1/2	225.00	280.00	285.00	155.00	175.00	185.00	12.00
1 1/4-11 1/2	225.00	295.00	315.00	170.00	175.00	195.00	12.00
1 1/2-11 1/2	245.00	330.00	355.00	175.00	185.00	215.00	12.00
2-11 1/2	345.00	380.00	398.00	215.00	215.00	298.00	12.00
2 1/2-8	375.00	455.00	470.00	325.00	325.00	455.00	15.00
3-8	430.00	539.00	575.00	365.00	365.00	490.00	15.00

Long form calibration - add \$30. per gage.