

TUBING & CASING THREAD INSPECTION - External Crest Diameter



GAGEMAKER®



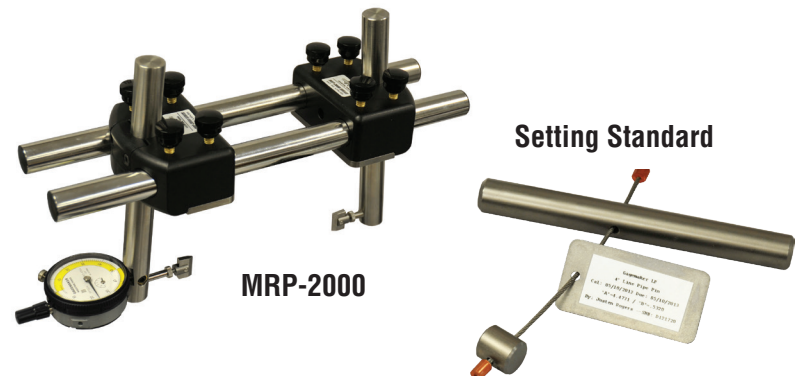
Crest Diameter Gage - MRP 1000/2000/3000

Crest Diameter:

Crest diameter is the most critical measurement in machining threads. Since pipe is not perfectly round, measuring dimensional changes across the face of connectors is critical in determining the proper fit of the connector.

Gage Description:

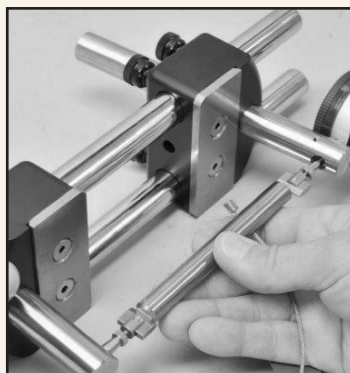
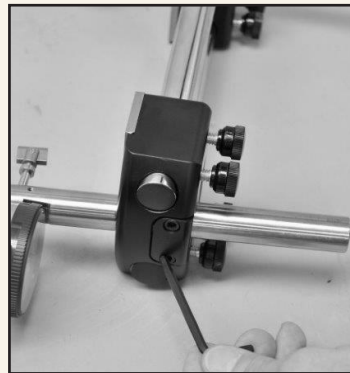
The MRP® gages inspect the crest diameter and ovality of internal and external tapered threads ranging from 1 ½”-20”. The MRP® gage includes three models, which gives the gage its versatility. The gage uses two pivoting shoes that rest on the crests of the threads during inspection. Any variations in pitch diameter detected during inspection are shown on the gage's indicator.



Crest Diameter Inspection with MRP® Gage

Zeroing the Gage

1. Loosen the set screws on the upper and lower blocks of the gage with a hex wrench and loosen all locking knobs.
2. Place the B rod on the gage's wear pad and move the upper arm until the pivot shoe contacts the standard. Tighten the two locking knobs.
3. Place the A standard between the pivot shoes and adjust the lower arm until the shoes contact the standard.
4. Slide the lower block .050” or one indicator revolution away from the upper block to provide preload. Tighten the locking knobs.
5. Sweep the standard from side to side to find the smallest indicator reading.
6. Turn the indicator dial to align the needle with zero and tighten the indicator clamp.



Inspecting a Part

