

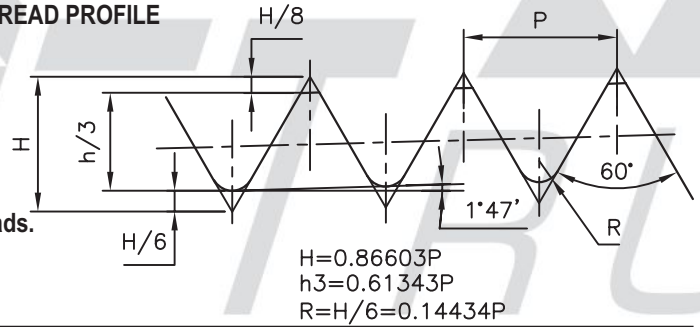
M KEG METRIC TAPER THREADS

Application: These taper threads are used for Oil and Grease Nipples where self sealing connection cannot be obtained by parallel thread connections, with sealing washer.

SPECIFICATION:

Basic Dimensions : DIN 158 Part 1 – 1997/IS 8788 – 2002,
Gauging Practice: DIN 158 Part 2 -1997.

M KEG THREAD PROFILE



External Threads are Taper & Internal Threads are parallel.

For Internal threads, Thread profile is similar to ISO Metric Threads.

MANUFACTURING RANGE

Diameter	Pitch (mm)	Type of Gauges				
M5	0.8	PARALLEL Ring Gauge	Taper Check Plug to check Parallel Rings.	Taper Rings Gauge	Taper Check Plug to check Taper Rings.	Parallel Plug Gauge to check Parallel Internal Threads.
M6, M8, M10, M12	1					
M10, M12	1.25					
M12, M14, M16, M18, M20, M22, M24, M26, M27, M30, M33, M36,	1.5	a) Normal b) Short	a) Normal b) For Short rings	a) Normal b) Short	Common for Normal & Short rings	Tolerance 4H5H
M38, M39, M42, M45, M48, M52, M27, M30, M33,						
M36, M39, M42, M45, M48, M52, M56, M60.	2					

GAUGING.

External Taper Threads of work piece can be checked by either,

1) Parallel Thread Ring Gauge (Normal/ Short).

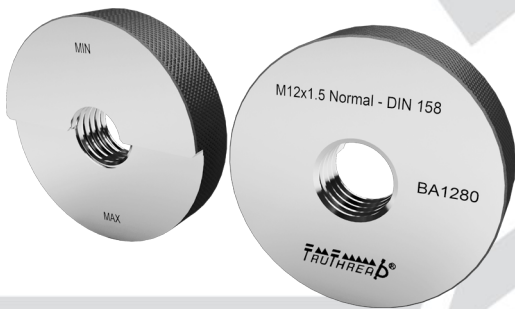
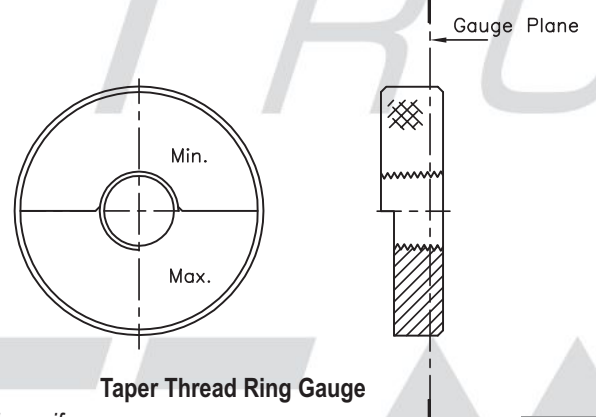
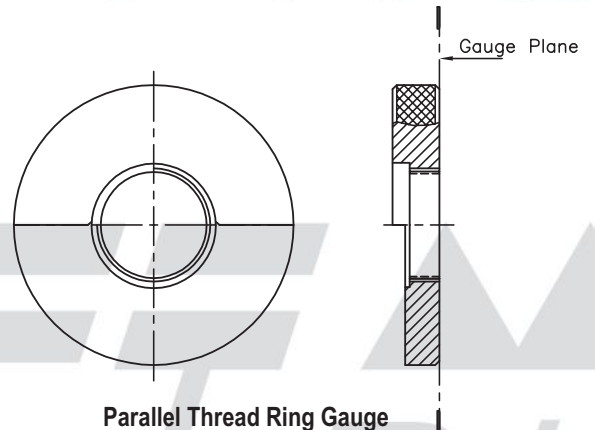
The design of this ring is specified in DIN 158 Part2 – 1997 standard. The limitation of parallel ring gauge is, it checks only the function of the thread at the gauge plane.

In this case however, errors of taper angle, pitch & thread angle can not be detected.

OR

2) Taper Thread Ring Gauge (Normal/Short)

Taper Thread ring gauge checks all Thread parameters. In addition to pitch diameter it also checks the errors of taper angle, pitch & thread angle.



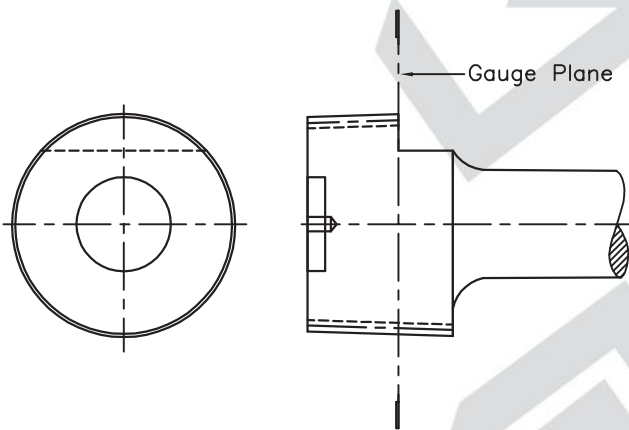
While requesting quotation or placing the Purchase order, the customer should specify the type of Ring Parallel - Normal / Short OR Taper Normal OR Short) required.

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Taper Check Plug Gauge (Normal/Short)

- 3) Taper Check Plug Gauge is used to check NEW or worn out parallel Thread Ring Gauge.



Taper Check Plug Gauge

Internal parallel Threads of work piece can be checked by,

- 4) Parallel Plug Gauge of tolerance class '4H5H'.
The Gauging practice of ISO Metric Thread Gauges is used for calculating Gauge size.

