

# PIPE THREADS WHERE PRESSURE TIGHT JOINTS ARE MADE ON THREADS. (R)

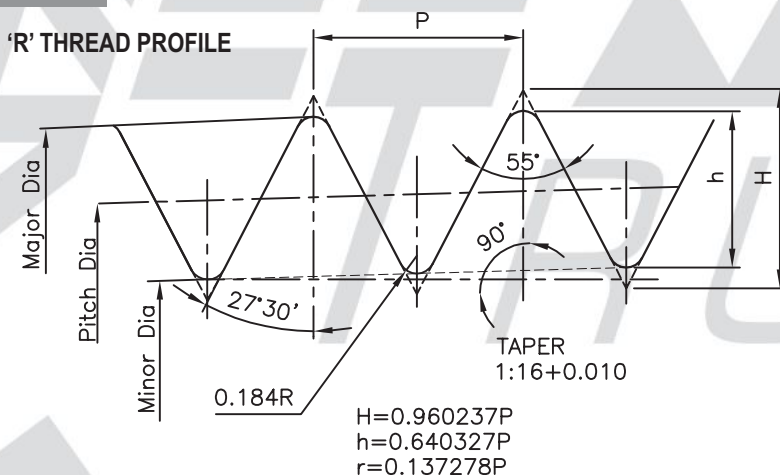
Application : Used for fastening of pipe threads, where pressure tight joints are required on threads.

## SPECIFICATION :

Basic Dimensions: ISO 7/1 - 1994 / IS 554 - 1999,  
Gauging Practice : ISO 7/2 - 2000 / IS 8999-2003.  
BS EN 10226-3-2005.

\*See foot note 1 on page 23 for gauges as per ISO 7/2-1982

\$ See foot note 2 on page 23 for gauges as per JIS B 0253-1985.



## MANUFACTURING RANGE.

Diameter (Inch)	TPI	Type of Gauges used for checking					
1/16" & 1/8"	28	Taper Full form Thread Plug Gauge	Taper Full form Thread Plug Gauge with relief	Parallel Full form Thread Ring Gauge	Taper Plain Ring Gauge	Taper modified Thread form Check Plug Gauge	Parallel Modified Thread form Check Ring Gauge
1/4" & 3/8"	19						
1/2" & 3/4"	14						
1", 1.1/4", 1.1/2", 2", 2.1/2", 3", 4", 5", 6" *	11						

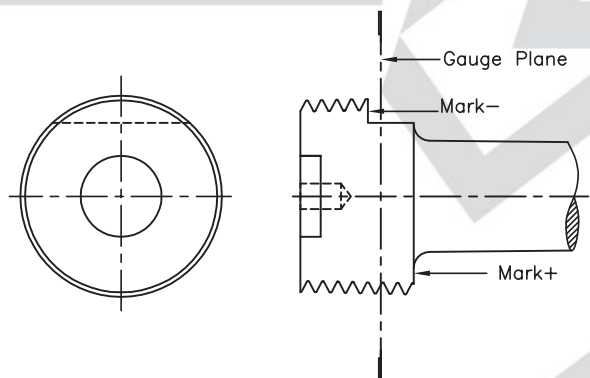
Sizes from 6" - 12" Pipe Diameter are covered in JIS B 0253-1985 specification, PT thread gauges. For details refer \$ foot note 2.

Internal Threads	Parameters to be checked →	Pitch Dia. with Major Diameter	Accommodation Length	
Taper Rc	Gauges required -	Gauge No.1 and/or 2	Gauge No.2	
Parallel Rp		Gauge No.1 and/or 2	Gauge No.2	
External Threads	Parameters to be checked →	Pitch & Minor Diameters.	Accommodation Length	Major Diameter
Always Taper 'R'	Gauges required -	Gauge No.3	Gauge No.4	Gauge No.4

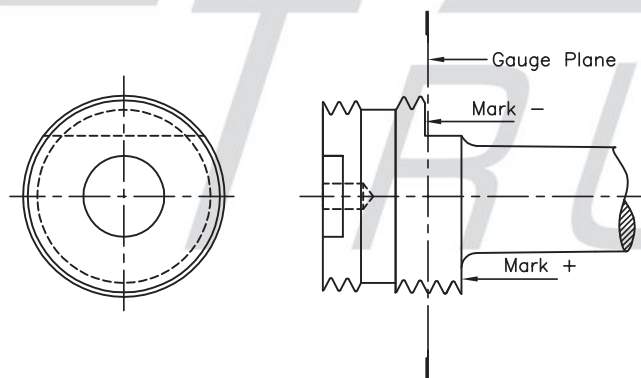
Details of Gauges as per ISO 7/2-2000

## GAUGES FOR CHECKING WORKPIECE THREADS.

To check Major Diameter & Pitch Diameter of Internal workpiece Threads Taper OR Parallel at the Gauge plane & the accommodation length.



Taper Full form Thread Plug. **Gauge No.1**

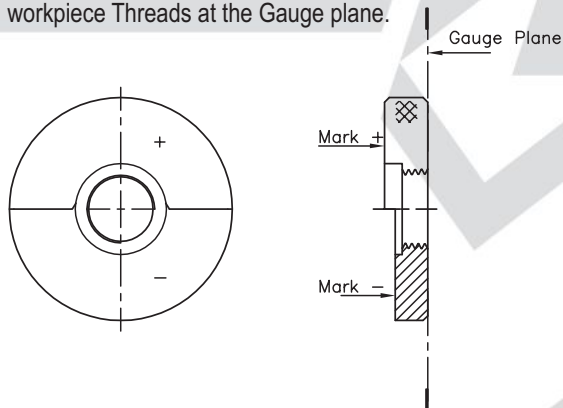


Taper Full form Thread Plug with relief. **Gauge No.2**

• The use of Gauge 2, may be omitted when the design of the work piece ensures availability of adequate accommodation length, but it should be noted that malformed threads may not be detected if Gauge No.2 is not used.

## PIPE THREADS WHERE PRESSURE TIGHT JOINTS ARE MADE ON THREADS. (R)

To check Minor Diameter & Pitch Diameter of External Taper workpiece Threads at the Gauge plane.

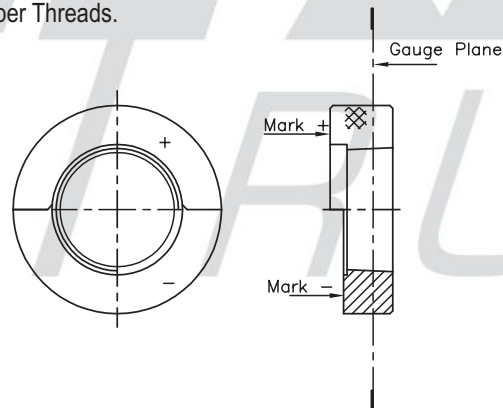


Parallel Full form Thread Ring Gauge. **Gauge No.3**



Application : Used for fastening of pipe threads, where pressure tight joints are required on threads.

To check Major Diameter & the related useful thread length of External Taper Threads.

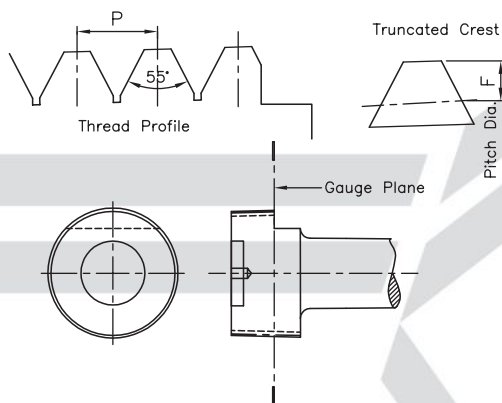


Taper Plain Ring Gauge (without threads) **Gauge No.4**



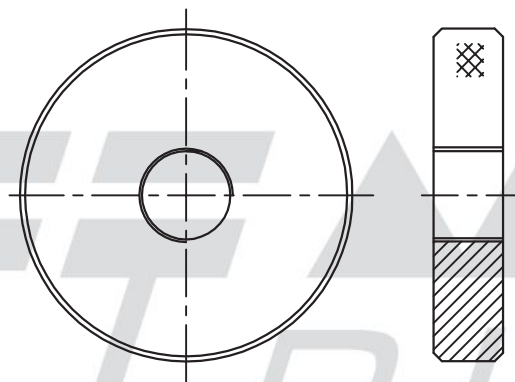
### MASTER GAUGES TO CHECK GAUGES (CALIBRATION & CONTROL PURPOSE)

To check Pitch Diameter of Parallel Full form Ring **Gauge No.4** during manufacturing & calibration (wear during usage)



Taper Modified Thread form Check Plug Gauge **Gauge No.5**

To check dimensions of Taper Thread Plug Gauges (**Gauge No.1 & 2**) during manufacturing & calibration. (wear during usage)



Parallel Modified Thread form Check Ring Gauge **Gauge No.6**

#### Notes:

1. We manufacture gauges as per old / obsolete ISO 7/2 - 1982, based on specific customer request. This specification recommends,

- Taper Full-form Plug Gauge to check Parallel as well as Taper Internal Threads (Rc).
- Taper Full-form Ring Gauge to check Taper external Threads (R).
- Taper Modified form Check Plug to check Taper Ring Gauges / (R) (calibration of new & used rings)

2. Inspection Plug as per JIS B 0253-1985 spec.

We manufacture Gauges as per JIS B 0253 -1985 , This specification specifies 2 Types of Gauges.

Design & dimensions of Taper Thread Plug Gauge (Rc), Taper Thread Ring Gauge (R) & Inspection Plug (R) are same as gauges as per ISO 7/2-1982 specification.

3. PT Gauges-The PT Taper Plug & Taper Ring gauges specified in Appendix of JIS B 0253-1985, covers pipe sizes from 1/8 to 12".

Dimensions of PT Taper thread gauges are different than R/Rc gauges.

We manufacture PT gauges as per JIS B 0253-1985 standard.