



Van Keuren





Van Keuren has a long history of excellence in innovation of precision gaging and measurement and is widely recognized as the premier manufacturer of Thread and Gear Measuring Wires, Cylindrical Plug and Ring Gages, and Threaded Plug and Ring Gages.

Van Keuren is now supported by PMC Gage who is known as a trendsetter in our industry. Many improvements in critical areas that benefit you, our trusted customer, have been implemented. Marketing; Customer Support; Quoting; Technical Support and Recalibration are a few of the ways PMC Gage has changed Van Keuren to help move into the future. Installing up-to-date, modern equipment enables Van Keuren to be the most reliable source of your measuring needs.

More than a century of experience combined with ongoing investments and upgrades of our manufacturing capabilities and technical abilities enables us to provide the highest quality and best craftsmanship of each gage. Continuous improvements in the education of our employees and implementing the latest technology ensure that we meet our goal of providing you with the highest quality products, service and on-time delivery available in our industry.

Every associate at Van Keuren appreciates the opportunity to service your gaging needs. Put us to the test with your most unique measuring challenge or your most demanding time-sensitive stock needs — we are capable of satisfying all your demands.



Whitehouse, TN



Willoughby, OH

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Visit us on the web at www.vankeuren.com for all Van Keuren products and information!

VAN KEUREN INSTRUMENTS

Monochromatic Lights



Van Keuren Monochromatic Light

Monochromatic Lights detect surface variation or error as small as 0.000001 thus improving the speed of inspection on flat surfaces such as rotary seals and valves where the flatness of the sealing surface is critical. Aerospace, military organizations and laboratories around the world benefit from using Van Keuren Monochromatic Lights.

Van Keuren monochromatic lights use a helium source with a light of 23.13 millionth wavelength (587.6) and are available in three styles. Our lights are made with fine woods.

C&L SERIES LIGHTS

Series Description	Width	Height	Depth	Weight	EDP No.
C-1 Monochromatic Light (Work size up to a full 4" square)	6-1/2"	7-1/2"	9"	7 lbs.	V760100
C-2 Monochromatic Light (Work size to over 6" diameter)	12"	11"	11"	16 lbs.	V760101
C-3 Monochromatic Light (Work capacity of over 12")	22"	16-1/2"	18-1/2"	42 lbs.	V760103
Standard L-1A Monochromatic Light (Work size up to 8")	15"	22-1/2"	17"	50 lbs.	V760200
Standard L-2A Monochromatic Light (Work size up to 12")	15"	22-1/2"	17"	50 lbs.	V760201

Reflex Interference Viewer

For rapid production inspection with maximum precision on polished or lapped work. In the Van Keuren Reflex Viewer, the Optical Flat is secured above the light in a fixed cell; the work is placed on top of the flat and bands noted. Keeping the work on top of the flat avoids serious distortion due to the weight of the flat when the work is small or delicate. Work larger than the flat can be inverted and moved across the flat for two or more observations. Handling of the optical flat is entirely eliminated and risk of accidental damage or excessive wear is greatly diminished.

C&L SERIES LIGHTS

Series Description	Width	Height	Depth	Weight	EDP No.
U-6 Monochromatic Reflex Interference Viewer (For use with 6" flat)	10-1/2"	17"	14"	19 lbs.	V760300
U-12 Monochromatic Reflex Interference Viewer (For use with 12" flat)	24"	48"	24"	46 lbs.	V760302
U-14 Monochromatic Reflex Interference Viewer (For use with 14" flat)	30"	48"	31"	80 lbs.	V760303

HELIUM REPLACEMENT TUBES

Series Description	Size	EDP No.
C-1	5" Square	V760500
C-2	6 Run	V760502
C-3	10 Run	V760501
L-1A	10 Run	V760501
L-2A	10 Run	V760501
U-6	6 Run	V760502
U-12	6 Run	V760502
Small Chart (12" x 17")	-	V980138
Large Wall Chart (38" x 25")	-	V980139
Video on optical flats	-	V980141

VAN KEUREN INSTRUMENTS



Van Keuren Optical Flat

Optical Flats

Van Keuren furnishes optical flats using only the most carefully selected annealed clear fused quartz. Fused quartz possesses a very low coefficient of linear expansion and is resistant to abrasion. All Van Keuren Optical Flats come furnished in a fitted case with a certificate of calibration stating the actual flatness directly traceable to the National Institute of Standards & Technology. Micro-coating is available by request and is applied to the flat to help clarify the image. Coating is available on single surface optical flats only. Your worn, scratched, opaque flats can be resurfaced to any desired accuracy, single or double surface, and will be indistinguishable from new flats. Reworked flats will be certified, showing traceability to the N.I.S.T. with the test number and date.

CALIBRATED QUARTZ OPTICAL FLATS

Size		Working .000004" EDP No.	Master .000002" EDP No.	Reference .000001" EDP No.
Diameter	Thickness			
SINGLE SURFACE				
1"	1/2"	V860101	V860201	V860301
2"	5/8"	V860102	V860202	V860302
3"	11/16"	V860103	V860203	V860303
4"	3/4"	V860104	V860204	V860304
5"	7/8"	V860105	V860205	V860305
6"	1"	V860106	V860206	V860306
8"	1 5/16"	V860108	V860208	V860307
10"	1 11/16"	V860110	V860210	V860310
12"	2"	V860112	V860212	V860312
DOUBLE SURFACE				
1"	1/2"	V860401	V860501	V860601
2"	5/8"	V860402	V860502	V860602
3"	11/16"	V860403	V860503	V860603
4"	3/4"	V860404	V860504	V860604
5"	7/8"	V860405	V860505	V860605
6"	1"	V860406	V860506	V860606
8"	1 5/16"	V860408	V860508	V860607
10"	1 11/16"	V860410	V860510	V860610
12"	2"	V860412	V860512	V860612

Optical Flats Parallel Sets

Flats in optical parallel sets differ in thickness by approximately 0.0125", providing a parallelism check at two spindle positions, each one-half turn apart. For metric micrometers, the difference is 0.25 mm.

OPTICAL FLATS PARALLEL SETS - PARALLEL TO .000004"

Type of Set	Size	EDP No.
Set Op-2AA, two parallels	1" x 1/2"	V839901
Set Op-2B, two parallels	1-1/4" x 1/2"	V839903
Set Op-2C, two parallels	1" x 1"	V839905

VAN KEUREN THREAD MEASURING WIRES



Van Keuren Thread Measuring Wires
(three per set)

It's widely recognized that Van Keuren pioneered the use of Thread Measuring Wires for pitch diameter measurements of gages, parts and taps. With the support of PMC Gage's ongoing investments in quality, continuous improvements are made to ensure the highest quality attainable. Stock wires are shipped from White House, Tennessee within one day of receipt of order.

The roundness of the Thread Measuring Wires is assured by 100% inspection in a specially designed instrument that has the same angles as the thread to be measured. All Van Keuren Thread and Gear Measuring Wires meet the most recent edition of ASME B89.1.17, which for identity of size, taper and roundness requires a tolerance of 0.00001" for Grade A Wires.

Wire sizes are identified as nominal and the calibrated size will show on the label with correct matching constant. The calibrated wire diameter will be with ± 0.000010 of the exact size of each wire and within ± 0.000020 of the nominal best wire diameter (G), as specified for Grade A Wires.

Each comes with three wires per set. Class XX, Extra Length, Solid Carbide, Flatted Wires and other specials are available – please call us at 1-800-825-4272 and we will gladly prepare a quote for you.

60 DEGREE THREADS

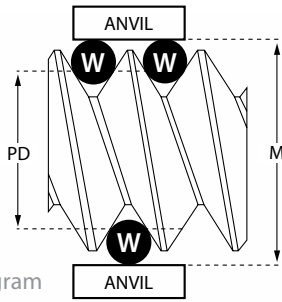
Threads Per Inch	Nominal Best Wire Diameter (Inches)	EDP
120	0.00481	60D120
100	0.00577	60D100
96	0.00601	60D96
90	0.00642	60D90
80	0.00722	60D80
72	0.00802	60D72
64	0.00902	60D64
56	0.01031	60D56
50	0.01155	60D50
48	0.01203	60D48
44	0.01312	60D44
40	0.01443	60D40
36	0.01604	60D36
32	0.01804	60D32
30	0.01925	60D30
28	0.02062	60D28
27	0.02138	60D27
26	0.02221	60D26
24	0.02406	60D24
22	0.02624	60D22
20	0.02887	60D20
18	0.03208	60D18

60 DEGREE THREADS (CONTINUED)

Threads Per Inch	Nominal Best Wire Diameter (Inches)	EDP
16	0.03608	60D16
14	0.04124	60D14
13	0.04441	60D13
12	0.04811	60D12
11 1/2	0.05020	60D11-1/2
11	0.05249	60D11
10	0.05774	60D10
9	0.06415	60D9
8	0.07217	60D8
7 1/2	0.07698	60D7-1/2
7	0.08248	60D7
6	0.09623	60D6
5 1/2	0.10497	60D5-1/2
5	0.11547	60D5
4 1/2	0.12830	60D4-1/2
4	0.14434	60D4
3 1/2	0.16496	60D3-1/2
3 1/4	0.17765	60D3-1/4
3	0.19245	60D3
2 3/4	0.20995	60D2-3/4
2 1/2	0.23094	60D2-1/2
2	0.28868	60D2

VAN KEUREN THREAD MEASURING WIRES

60 Degree Metric Threads



Wire Diagram

W = Wire

M = Measurement over Wires

PD = Pitch Diameter

Van Keuren 60 Degree Metric Thread Measuring wires are the best sizes for metric threads. They may be used with other forms or with special pitches, constants for which may be calculated from the formula provided below. Our wires (three per set) are made from selected high-speed steel, are extremely accurate in roundness and straightness and are within 0.000020" (20 millionths) of exact size.

The formula for determining wire constants for all 60° threads = $3W - 0.866025P$.
Where W=actual average wire size and P=Pitch (1/TPI).

The most accurate and universally recognized method of obtaining pitch diameter measurements of thread plug or setting plug gages is by means of using three hardened steel measuring wires laid into opposite sides of the thread. Please reference Van Keuren Handbook #37 for additional information.

60 DEGREE METRIC THREADS

Pitch 00	Nominal Best Wire Diameter (mm)	EDP No.
0.20 mm	0.1155	60D0020MM
0.225 mm	0.1299	60D00225MM
0.25 mm	0.1443	60D0025MM
0.30 mm	0.1732	60D0030MM
0.35 mm	0.2021	60D0035MM
0.40 mm	0.2309	60D0040MM
0.45 mm	0.2598	60D0045MM
0.50 mm	0.2887	60D0050MM
0.60 mm	0.3464	60D0060MM
0.70 mm	0.4041	60D0070MM
0.75 mm	0.4330	60D0075MM
0.80 mm	0.4619	60D0080MM
0.90 mm	0.5196	60D0090MM
1.00 mm	0.5774	60D1000MM
1.25 mm	0.7217	60D1025MM
1.50 mm	0.8660	60D1050MM
1.75 mm	1.0104	60D1075MM
2.00 mm	1.1547	60D2000MM
2.50 mm	1.4434	60D2050MM
3.00 mm	1.7321	60D3000MM
3.50 mm	2.0207	60D3050MM
4.00 mm	2.3094	60D4000MM
4.50 mm	2.5981	60D4050MM
5.00 mm	2.8868	60D5000MM
5.50 mm	3.1754	60D5050MM
6.00 mm	3.4641	60D6000MM
7.00 mm	4.0415	60D7000MM
8.00 mm	4.6188	60D8000MM
9.00 mm	5.1962	60D9000MM
10.00 mm	5.7735	60D10000MM

VAN KEUREN THREAD MEASURING WIRES

3-Wire Thread Measuring System

The 3-Wire Thread Measuring System is the fastest and most accurate thread measurement system for a variety of measuring instruments.

New and Improved

The traditional three-wire method is the most accurate method of measuring the effective or pitch diameter of an external screw thread. Unfortunately in the past, holding and correctly positioning three wires against a thread while simultaneously taking an accurate measurement had been an extremely difficult task. Now, we have a 3-Wire Thread Measuring System that provides a simple and precise way for determining the pitch diameter for threaded parts and thread plug gages.



3-Wire Thread Measuring System
(with bolt being measured)

Special Design

We offer specially designed wire holders and wires, base assemblies, and vertically adjustable off-set platforms that make thread measurement fast and accurate.

Our holders are fitted with certified full length thread measuring wires that meet or exceed the requirements of the ASME/ANSI B1.2, B89.1.17-2001, and B1.16M, thread standards as well as Federal Spec. GGG-W-366b and ISO standards. All wire holder sets include the actual wire size, N.I.S.T. traceable number, and the constant required for determining the pitch diameter.

Thread Measuring Holders

Thread measuring holders are precision made to predetermined thread pitches. Thread measuring wires are held in a predetermined position by light pressure clips. The holders rotate freely on the spindle/anvil of the measuring instrument so as to engage the lead angle of a thread. Holders for finer pitches have wires positioned off center to allow for measurement at the back of a thread and closer to the shoulder of certain parts. Holders can be purchased without wires for companies that have existing wires. Wires can be easily installed. Thread measuring holders are available in a full range of Standard, Metric, and Acme sizes. Our engineering department can design wire holders for multiple start threads, helical gears, worms, and other special thread measurement applications. Micrometers sold separately.

Applications:

- Certify set plug gages and working thread plug gages
- Monitor the wear on working thread plug gages
- Monitor and control pitch diameter variation during thread fabrication
- Use in conjunction with "GO" and "NOT GO" ring gages to control thread size to the most demanding specifications
- Determine out of roundness and taper that may exist in threaded parts
- Applications for preplating and postplating thread measurement
- Eliminate the cost and time involved in using outside calibration services
- Reduce measurement time to a fraction of the time normally taken using the traditional three-wire method

VAN KEUREN THREAD MEASURING WIRES



Van Keuren Thread Measuring Wires in Holders

3-Wire Thread Measuring System

Wire Holders: The wire holders are fitted on anvils of the micrometer allowing the single and double measuring wires to accurately position in relation to each other. The extra length of the wire enables them to be adjusted up or down in the holders. This extends the life of the wires substantially. The holders rotate freely on the spindle/anvil of the measuring instrument so as to engage the lead angle of a thread.

Measuring Wires: Measuring wires are certified to meet these specifications: Diameter: $\pm 0.000020''$ Roundness: $\pm 0.000010''$ Surface Finish: 2 Micro Inches

Wires and holders are shipped unassembled for your convenience (two holders per set). Please specify Threads Per Inch and Anvil Size when ordering.

60 DEGREE THREAD 3-WIRE SETS WITH HOLDERS

Threads Per Inch	Nominal Diameter	Holder With Wires			Holder Only		
		.250 Anvil	.300 Anvil	.375 Anvil	.250 Anvil	.300 Anvil	.375 Anvil
120	0.00481	60D120ANV250	60D120ANV300	60D120ANV375	HLD120ANV250	HLD120ANV300	HLD120ANV375
100	0.00577	60D100ANV250	60D100ANV300	60D100ANV375	HLD100ANV250	HLD100ANV300	HLD100ANV375
96	0.00601	60D96ANV250	60D96ANV300	60D96ANV375	HLD96ANV250	HLD96ANV300	HLD96ANV375
90	0.00642	60D90ANV250	60D90ANV300	60D90ANV375	HLD90ANV250	HLD90ANV300	HLD90ANV375
80	0.00722	60D80ANV250	60D80ANV300	60D80ANV375	HLD80ANV250	HLD80ANV300	HLD80ANV375
72	0.00802	60D72ANV250	60D72ANV300	60D72ANV375	HLD72ANV250	HLD72ANV300	HLD72ANV375
64	0.00902	60D64ANV250	60D64ANV300	60D64ANV375	HLD64ANV250	HLD64ANV300	HLD64ANV375
56	0.01031	60D56ANV250	60D56ANV300	60D56ANV375	HLD56ANV250	HLD56ANV300	HLD56ANV375
50	0.01155	60D50ANV250	60D50ANV300	60D50ANV375	HLD50ANV250	HLD50ANV300	HLD50ANV375
48	0.01203	60D48ANV250	60D48ANV300	60D48ANV375	HLD48ANV250	HLD48ANV300	HLD48ANV375
44	0.01312	60D44ANV250	60D44ANV300	60D44ANV375	HLD44ANV250	HLD44ANV300	HLD44ANV375
40	0.01443	60D40ANV250	60D40ANV300	60D40ANV375	HLD40ANV250	HLD40ANV300	HLD40ANV375
36	0.01604	60D36ANV250	60D36ANV300	60D36ANV375	HLD36ANV250	HLD36ANV300	HLD36ANV375
32	0.01804	60D32ANV250	60D32ANV300	60D32ANV375	HLD32ANV250	HLD32ANV300	HLD32ANV375
30	0.01925	60D30ANV250	60D30ANV300	60D30ANV375	HLD30ANV250	HLD30ANV300	HLD30ANV375
28	0.02062	60D28ANV250	60D28ANV300	60D28ANV375	HLD28ANV250	HLD28ANV300	HLD28ANV375
27	0.02138	60D27ANV250	60D27ANV300	60D27ANV375	HLD27ANV250	HLD27ANV300	HLD27ANV375
26	0.02221	60D26ANV250	60D26ANV300	60D26ANV375	HLD26ANV250	HLD26ANV300	HLD26ANV375
24	0.02406	60D24ANV250	60D24ANV300	60D24ANV375	HLD24ANV250	HLD24ANV300	HLD24ANV375
22	0.02624	60D22ANV250	60D22ANV300	60D22ANV375	HLD22ANV250	HLD22ANV300	HLD22ANV375
20	0.02887	60D20ANV250	60D20ANV300	60D20ANV375	HLD20ANV20	HLD20ANV300	HLD20ANV375
18	0.03208	60D18ANV250	60D18ANV300	60D18ANV375	HLD18ANV250	HLD18ANV300	HLD18ANV375
16	0.03608	60D16ANV250	60D16ANV300	60D16ANV375	HLD16ANV250	HLD16ANV300	HLD16ANV375
14	0.04124	60D14ANV250	60D14ANV300	60D14ANV375	HLD14ANV250	HLD14ANV300	HLD14ANV375
13	0.04441	60D13ANV250	60D13ANV300	60D13ANV375	HLD13ANV250	HLD13ANV300	HLD13ANV375
12	0.04811	60D12ANV250	60D12ANV300	60D12ANV375	HLD12ANV250	HLD12ANV300	HLD12ANV375
11 1/2	0.05020	60D11-1/2ANV250	60D11-1/2ANV300	60D11-1/2ANV375	HLD11-1/2ANV250	HLD11-1/2ANV300	HLD11-1/2ANV375
11	0.05249	60D11ANV250	60D11ANV300	60D11ANV375	HLD11ANV250	HLD11ANV300	HLD11ANV375
10	0.05774	60D10ANV250	60D10ANV300	60D10ANV375	HLD10ANV250	HLD10ANV300	HLD10ANV375
9	0.06415	60D9ANV250	60D9ANV300	60D9ANV375	HLD9ANV250	HLD9ANV300	HLD9ANV375
8	0.07217	60D8ANV250	60D8ANV300	60D8ANV375	HLD8ANV250	HLD8ANV300	HLD8ANV375

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60 DEGREE THREAD 3-WIRE SETS WITH HOLDERS (CONTINUED)

Threads Per Inch	Nominal Diameter	Holder With Wires			Holder Only		
		.250 Anvil	.300 Anvil	.375 Anvil	.250 Anvil	.300 Anvil	.375 Anvil
7 1/2	0.07698	60D7-1/2ANV250	60D7-1/2ANV300	60D7-1/2ANV375	HLD7-1/2ANV250	HLD7-1/2ANV300	HLD7-1/2ANV375
7	0.08248	60D7ANV250	60D7ANV300	60D7ANV375	HLD7ANV250	HLD7ANV300	HLD7ANV375
6	0.09623	60D6ANV250	60D6ANV300	60D6ANV375	HLD6ANV250	HLD6ANV300	HLD6ANV375
5 1/2	0.10497	60D5-1/2ANV250	60D5-1/2ANV300	60D5-1/2ANV375	HLD5-1/2ANV250	HLD5-1/2ANV300	HLD5-1/2ANV375
5	0.11547	60D5ANV250	60D5ANV300	60D5ANV375	HLD5ANV250	HLD5ANV300	HLD5ANV375
4 1/2	0.12830	60D4-1/2ANV250	60D4-1/2ANV300	60D4-1/2ANV375	HLD4-1/2ANV250	HLD4-1/2ANV300	HLD4-1/2ANV375
4	0.14434	60D4ANV250	60D4ANV300	60D4ANV375	HLD4ANV250	HLD4ANV300	HLD4ANV375
3 1/2	0.16496	60D3-1/2ANV250	60D3-1/2ANV300	60D3-1/2ANV375	HLD3-1/2ANV250	HLD3-1/2ANV300	HLD3-1/2ANV375
3 1/4	0.17765	60D3-1/4ANV250	60D3-1/4ANV300	60D3-1/4ANV375	HLD3-1/4ANV250	HLD3-1/4ANV300	HLD3-1/4ANV375
3	0.19245	60D3ANV250	60D3ANV300	60D3ANV375	HLD3ANV250	HLD3ANV300	HLD3ANV375
2 3/4	0.20995	60D2-3/4ANV250	60D2-3/4ANV300	60D2-3/4ANV375	HLD2-3/4ANV250	HLD2-3/4ANV300	HLD2-3/4ANV375
2 1/2	0.23094	60D2-1/2ANV250	60D2-1/2ANV300	60D2-1/2ANV375	HLD2-1/2ANV250	HLD2-1/2ANV300	HLD2-1/2ANV375
2	0.28868	60D2ANV250	60D2ANV300	60D2ANV375	HLD2ANV250	HLD2ANV300	HLD2ANV375

60 DEGREE METRIC THREAD WIRE SETS WITH HOLDERS

Wire Size			Holder With Wires			Holder Only		
Pitch mm	Best mm	Inch Equiv.	.250" Anvil	.300" Anvil	.375" Anvil	.250" Anvil	.300" Anvil	.375" Anvil
0.225 mm	0.1299	0.00511	60D00225MMV250	60D00225MMV300	60D00225MMV375	HLD00225MMV250	HLD00225MMV300	HLD00225MMV375
0.25 mm	0.1443	0.00568	60D0025MMV250	60D0025MMV300	60D0025MMV375	HLD0025MMV250	HLD0025MMV300	HLD0025MMV375
0.30 mm	0.1732	0.00682	60D0030MMV250	60D0030MMV300	60D0025MMV375	HLD0030MMV250	HLD0030MMV300	HLD0030MMV375
0.35 mm	0.2021	0.00796	60D0035MMV250	60D0035MMV300	60D0035MMV375	HLD0035MMV250	HLD0035MMV300	HLD0035MMV375
0.40 mm	0.2309	0.00909	60D0040MMV250	60D0040MMV300	60D0040MMV375	HLD0040MMV250	HLD0040MMV300	HLD0040MMV375
0.45 mm	0.2598	0.01023	60D0045MMV250	60D0045MMV300	60D0045MMV375	HLD0045MMV250	HLD0045MMV300	HLD0045MMV375
0.50 mm	0.2887	0.01137	60D0050MMV250	60D0050MMV300	60D0050MMV375	HLD0050MMV250	HLD0050MMV300	HLD0050MMV375
0.60 mm	0.3464	0.01364	60D0060MMV250	60D0060MMV300	60D0060MMV375	HLD0060MMV250	HLD0060MMV300	HLD0060MMV375
0.70 mm	0.4041	0.01591	60D0070MMV250	60D0070MMV300	60D0070MMV375	HLD0070MMV250	HLD0070MMV300	HLD0070MMV375
0.75 mm	0.4330	0.01705	60D0075MMV250	60D0075MMV300	60D0075MMV375	HLD0075MMV250	HLD0075MMV300	HLD0075MMV375
0.80 mm	0.4619	0.01818	60D0080MMV250	60D0080MMV300	60D0080MMV375	HLD0080MMV250	HLD0080MMV300	HLD0080MMV375
0.90 mm	0.5196	0.02046	60D0090MMV250	60D0090MMV300	60D0090MMV375	HLD0090MMV250	HLD0090MMV300	HLD0090MMV375
1.00 mm	0.5774	0.02273	60D1000MMV250	60D1000MMV300	60D1000MMV375	HLD1000MMV250	HLD1000MMV300	HLD1000MMV375
1.25 mm	0.7217	0.02841	60D1025MMV250	60D1025MMV300	60D1025MMV375	HLD1025MMV250	HLD1025MMV300	HLD1025MMV375
1.50 mm	0.8660	0.03410	60D1050MMV250	60D1050MMV300	60D1050MMV375	HLD1050MMV250	HLD1050MMV300	HLD1050MMV375
1.75 mm	1.0104	0.03978	60D1075MMV250	60D1075MMV300	60D1075MMV375	HLD1075MMV250	HLD1075MMV300	HLD1075MMV375
2.00 mm	1.1547	0.04546	60D2000MMV250	60D2000MMV300	60D2000MMV375	HLD200MMV250	HLD200MMV300	HLD200MMV375
2.50 mm	1.4434	0.05683	60D2050MMV250	60D2050MMV300	60D2050MMV375	HLD2050MMV250	HLD2050MMV300	HLD2050MMV375
3.00 mm	1.7321	0.06819	60D3000MMV250	60D3000MMV300	60D3000MMV375	HLD3000MMV250	HLD3000MMV300	HLD3000MMV375
3.50 mm	2.0270	0.07956	60D3050MMV250	60D3050MMV300	60D3050MMV375	HLD3050MMV250	HLD3050MMV300	HLD3050MMV375
4.00 mm	2.3094	0.09092	60D4000MMV250	60D4000MMV300	60D4000MMV375	HLD4000MMV250	HLD4000MMV300	HLD4000MMV375
4.50 mm	2.5981	0.10229	60D4050MMV250	60D4050MMV300	60D4050MMV375	HLD4050MMV250	HLD4050MMV300	HLD4050MMV375
5.00 mm	2.8868	0.11365	60D5000MMV250	60D5000MMV300	60D5000MMV375	HLD5000MMV250	HLD5000MMV300	HLD5000MMV375
5.50 mm	3.1754	0.12502	60D5050MMV250	60D5050MMV300	60D5050MMV375	HLD5050MMV250	HLD5050MMV300	HLD5050MMV375
6.00 mm	3.4641	0.13638	60D6000MMV250	60D6000MMV300	60D6000MMV375	HLD6000MMV250	HLD6000MMV300	HLD6000MMV375
7.00 mm	4.0415	0.15911	60D7000MMV250	60D7000MMV300	60D7000MMV375	HLD7000MMV250	HLD7000MMV300	HLD7000MMV375
8.00 mm	4.6188	0.18184	60D8000MMV250	60D8000MMV300	60D8000MMV375	HLD8000MMV250	HLD8000MMV300	HLD8000MMV375
9.00 mm	5.1962	0.20457	60D9000MMV250	60D9000MMV300	60D9000MMV375	HLD9000MMV250	HLD9000MMV300	HLD9000MMV375
10.0 mm	5.7735	0.22730	60D10000MMV250	60D10000MMV300	60D10000MMV375	HLD10000MMV250	HLD10000MMV300	HLD10000MMV375

VAN KEUREN THREAD MEASURING WIRES

Thread Measuring Wire Sets



Van Keuren Thread Measuring Wires in Wooden Case

Wire Holders and Thread Measuring Wires are shipped from our factory unassembled for your convenience. Each Thread Measuring Wire Set comes in a wooden case with customizable labels. Please specify Threads Per Inch and Anvil Size when ordering.

THREAD MEASURING WIRE SETS (WITH WOODEN CASE)

Set No.	Sizes	EDP No.
60 Degree Thread Measuring Wires		
30 HS*	30 sizes (5 to 80 TPI), with case	60D5-80TPI
34 HS	34 sizes (4 to 80 TPI), with case	60D4-80TPI
20 HS*	20 sizes (6 to 36 TPI), with case	60D6-36TPI
60 Degree Metric Thread Measuring Wires		
30M	30 sizes (.2 pitch to 10 pitch), with case	60D.2-10.0P
23M	23 sizes (.3 pitch to 6 pitch), with case	60D.3-6.0P
29 Degree Acme Best Threads		
22AB	22 sizes (1 to 20 TPI), with case	29D1-20TPI
16AB	16 sizes (3 1/2 to 20 TPI), with case	29D3-1/2-20

*7 1/2 & 22 TPI not included in these sets. Cases and vials are available.

VAN KEUREN HANDBOOK #37



VK Handbook #37 features over 200 pages of detailed information on wire type plug gages, thread and gear wire measurement, application techniques for optical and monochromatic lights and more. It is the definitive source for the use of fixed gaging techniques.

Our Handbook is the number one resource for everything you need to know about Thread Measuring Wires and is a great reference guide for any shop or laboratory. Tables, specifications and examples of gears including external gear, internal gear with varying pressure angles are referenced in the Handbook.

EDP No. VKHANDBOOK37

VAN KEUREN THREAD MEASURING WIRES



Van Keuren Thread Measuring Wires (three per set)

29 Degree Acme and Special Thread Measuring Wires

Van Keuren's capabilities of making special Thread Measuring Wires is unsurpassed for speed and our inventory of materials ensures delivery on special size wires is prompt. 29 Degree Acme Thread Measuring Wires are in stock for immediate delivery. Unlike 60 Degree Thread Measuring Wires, there is no constant available for 29 Degree Acme Thread Measuring Wires as it changes with every diameter change.

Special Thread Measuring Wires are made to ± 0.000020 (20 millionths) and are available in XX tolerance as well as flatted. Special Wires are made to order and are not returnable. Each set contains three wires. Long Form certification traceable to N.I.S.T. is available, please call 1-800-825-4272 and we will gladly prepare a quote.

29 DEGREE ACME BEST THREADS

Threads Per Inch	Diameter Best Size Wire	EDP No.
1	0.51645 inches	29D1
1 1/3	0.38734 inches	29D1-1/3
1 1/2	0.34430 inches	29D1-1/2
1 3/4	0.29511 inches	29D1-3/4
2	0.25823 inches	29D2
2 1/2	0.20658 inches	29D2-1/2
3	0.17215 inches	29D3
3 1/2	0.14756 inches	29D3-1/2
4	0.12911 inches	29D4
4 1/2	0.11477 inches	29D4-1/2
5	0.10329 inches	29D5
5 1/2	0.09390 inches	29D5-1/2
6	0.08608 inches	29D6
7	0.07378 inches	29D7
8	0.06456 inches	29D8
9	0.05738 inches	29D9
10	0.05164 inches	29D10
12	0.04304 inches	29D12
14	0.03689 inches	29D14
16	0.03228 inches	29D16
18	0.02869 inches	29D18
20	0.02582 inches	29D20

SPECIAL THREAD MEASURING WIRES

Range	
Inches	mm
0.004" - 0.005"	0.1016 mm - 0.1270 mm
0.005" - 0.007"	0.1270 mm - 0.1778 mm
0.007" - 0.010"	0.1778 mm - 0.2540 mm
0.010" - 0.135"	0.2540 mm - 3.429 mm
0.135" - 0.260"	3.429 mm - 6.604 mm
0.260" - 0.385"	6.604 mm - 9.779 mm
0.385" - 0.510"	9.779 mm - 12.954 mm
0.510" - 0.635"	12.954 mm - 16.129 mm
0.635" - 0.760"	16.129 mm - 19.304 mm
0.760" - 1.010"	19.304 mm - 25.654 mm

Special Thread Measuring Wires are made to order. Please call 1-800-825-4272 for a quote.

Grand Master Calibration Set

GRAND MASTER CALIBRATION SETS

Set No.	Sizes	EDP No.
20 HSC	20 sizes (6 to 36 TPI)	V396930
30 HSC	30 sizes (5 to 80 TPI)	V396950
34 HSC	34 sizes (4 to 80 TPI)	V396970
30 MC	30 sizes (.2 to 10 mm pitch)	V396960
23 MC	23 sizes (.3 to 6 mm pitch)	V396940
22 ABC	22 sizes (1 to 20 TPI)	V397010

Van Keuren Grand Master Calibration Sets are supplied in durable corrosion resistant containers in fitted cases and are identified by serial numbers. Our Grand Master Sets include Certificate of Calibration traceable to N.I.S.T.. Grand Master Calibration Sets are made to order and are not returnable. One master wire for each pitch is included in the set. Please call 1-800-825-4272 and we will gladly prepare a quote.

VAN KEUREN THREAD AND GEAR MEASURING WIRES

Gear Measuring Wires Master Sets



Van Keuren Gear Measuring Wires
(two sizes per set)

All gear measuring wires meet or exceed Fed. Spec. B89 for Grade AM.G.W. Long Form certification traceable to N.I.S.T. is available, please call us at 1-800-825-4272 and we will gladly prepare a quote. Metric Module Sets also available on request.

*Wires of like diameter are interchangeable within series sets and not duplicated in sets of #84, #71EX, and #48G.

GEAR MEASURING WIRES MASTER SETS

Set No.	Includes (all sets also include a fitted case)	EDP No.
84*	Includes 2 wires each of 84 sizes from 1.92", 1.728", 1.44", and 1.68" series for measuring tooth thickness and checking involute profiles of external and internal gears from 2 to 80 P	V710004
71EX*	Includes 2 wires each of 71 sizes from 1.92", 1.728", 1.44", and 1.68" series for measuring tooth thickness and checking involute profiles of external from 2 to 80 P	V710003
48G*	Includes 2 wires each of 48 sizes (excluding duplicates) from 1.728" and 1.44" series for measuring external and internal gears from 2 to 80 P	V710005
26EX*	Includes 2 wires each of 26 sizes from 1.728" series for measuring external gears from 2 to 80 P	V710002
26IN	Includes 2 wires each of 26 sizes from 1.44" series for measuring internal gears from 2 to 80 P	V710006
26	Includes 2 wires each of 26 sizes from 1.68" alternate series for measuring external and internal gears from 2 to 80 P	V710007
15	Includes 2 wires each of 15 sizes from 1.92" series for 2.5, 3, 4, 5, 6, 8, 10, 12, 16, 20, 24, 32, 40, 48, and 64 P, external 30 degree splines	V710000
15IN	Includes 2 wires each of 15 sizes from 1.92" series for 2.5, 3, 4, 5, 6, 8, 10, 12, 16, 20, 24, 32, 40, 48, and 64 P, with flats for 30 degree internal splines	V710001
9	Includes 2 wires each of 15 sizes from 1.92" series for 10, 16, 24, 32, 40, 48, 64, 80, and 128 P, external and internal 45 degree serrated shafts	V710008

Special Gear Measuring Wires

Van Keuren Special Gear Measuring Wires are made to class X with a tolerance of ± 0.000020 and a roundness to ± 0.000010 . Special Gear Measuring Wires are manufactured as two per set.

Class XX and Flatted Gear Measuring Wires are available. Flatted Gear Wires have a pitch that ranges from 2 thru 28. If interested please call us at 1-800-825-4272 and we will gladly prepare a quote.



Van Keuren Gear Measuring Wires

SPECIAL GEAR MEASURING WIRES

Range	
Inches	mm
0.004" - 0.005"	0.1016 - 0.1270 mm
0.005" - 0.007"	0.1270 - 0.1778 mm
0.007" - 0.010"	0.1778 - 0.2540 mm
0.010" - 0.135"	0.2540 - 3.429 mm
0.135" - 0.260"	3.429 - 6.604 mm
0.260" - 0.385"	6.604 - 9.779 mm
0.385" - 0.510"	9.779 - 12.954 mm
0.510" - 0.635"	12.954 - 16.129 mm
0.635" - 0.760"	16.129 - 19.304 mm
0.760" - 1.010"	19.304 - 25.654 mm

VAN KEUREN GEAR MEASURING WIRES

Gear Measuring Wires



Van Keuren Gear Measuring Wires (two per set)

Van Keuren Gear Measuring Wires ensure accurate and simple measurement of tooth thickness of spur gears. Our Gear Measuring Wires are made by the same methods and to the same high quality as our Thread Measuring Wires but are furnished in sets of two identical wires per set, rather than three, and have larger diameters with specifications suited to their size. Our Gear Measuring Wires are lapped to 2 RMS micro inch finish or less and measure to exacting specifications. Van Keuren Gear Measuring Wires meet or exceed Fed. Spec. B89 for Grade AMGW. Our standard is Grade A. Three wire sets, modified Gear Wires, Carbide and Metric Module are available upon request. Please specify TPI and series (external or internal) when ordering.

GRADE A MASTER GEAR WIRES

P	Wire Diameter for Enlarged Pinions 1.92"		Wire Diameter for External Gears 1.728"		Alternate Series 1.68"		Wire Diameter for Internal Gears 1.44"	
	P	EDP No.	P	EDP No.	P	EDP No.	P	EDP No.
2	0.96000	GM2-192	0.86400	GM2-1728	0.84000	GM2-168	0.72000	GM2-144
2 1/2	0.76800	GM2-1/2-192	0.69120	GM2-1/2-1728	0.67200	GM2-1/2-168	0.57600	GM2-1/2-144
3	0.64000	GM3-192	0.57600	GM3-1728	0.56000	GM3-168	0.48000	GM3-144
4	0.48000	GM4-192	0.43200	GM4-1728	0.42000	GM4-168	0.36000	GM4-144
5	0.38400	GM5-192	0.34560	GM5-1728	0.33600	GM5-168	0.28800	GM5-144
6	0.32000	GM6-192	0.28800	GM6-1728	0.28000	GM6-168	0.24000	GM6-144
7	0.27428	GM7-192	0.24686	GM7-1728	0.24000	GM7-168	0.20571	GM7-144
8	0.24000	GM8-192	0.21600	GM8-1728	0.21000	GM8-168	0.18000	GM8-144
9	0.21333	GM9-192	0.19200	GM9-1728	0.18666	GM9-168	0.16000	GM9-144
10	0.19200	GM10-192	0.17280	GM10-1728	0.16800	GM10-168	0.14400	GM10-144
11	0.17454	GM11-192	0.15709	GM11-1728	0.15273	GM11-168	0.13091	GM11-144
12	0.16000	GM12-192	0.14400	GM12-1728	0.14000	GM12-168	0.12000	GM12-144
14	0.13714	GM14-192	0.12343	GM14-1728	0.12000	GM14-168	0.10286	GM14-144
16	0.12000	GM16-192	0.10800	GM16-1728	0.10500	GM16-168	0.09000	GM16-144
18	0.10667	GM18-192	0.09600	GM18-1728	0.09333	GM18-168	0.08000	GM18-144
20	0.09600	GM20-192	0.08640	GM20-1728	0.08400	GM20-168	0.07200	GM20-144
22	0.08727	GM22-192	0.07855	GM22-1728	0.07636	GM22-168	0.06545	GM22-144
24	0.08000	GM24-192	0.07200	GM24-1728	0.07000	GM24-168	0.06000	GM24-144
28	0.06857	GM28-192	0.06171	GM28-1728	0.06000	GM28-168	0.05143	GM28-144
32	0.06000	GM32-192	0.05400	GM32-1728	0.05250	GM32-168	0.04500	GM32-144
36	0.05333	GM36-192	0.04800	GM36-1728	0.04667	GM36-168	0.04000	GM36-144
40	0.04800	GM40-192	0.04320	GM40-1728	0.04200	GM40-168	0.03600	GM40-144
48	0.04000	GM48-192	0.03600	GM48-1728	0.03500	GM48-168	0.03000	GM48-144
64	0.03000	GM64-192	0.02700	GM64-1728	0.02625	GM64-168	0.02250	GM64-144
72	0.02667	GM72-192	0.02400	GM72-1728	0.02333	GM72-168	0.02000	GM72-144
80	0.02400	GM80-192	0.02160	GM80-1728	0.02100	GM80-168	0.01800	GM80-144
96	0.02000	GM96-192	0.01800	GM96-1728	0.01750	GM96-168	0.01500	GM96-144
100	0.01920	GM100-192	0.01728	GM100-1728	0.01680	GM100-168	0.01440	GM100-144
120	0.01600	GM120-192	0.01440	GM120-1728	0.01400	GM120-168	0.01200	GM120-144
128	0.01500	GM128-192	0.01350	GM128-1728	0.01312	GM128-168	0.01125	GM128-144
200	0.00960	GM200-192	0.00864	GM200-1728	0.00840	GM200-168	0.00720	GM200-144

VAN KEUREN PLAIN CYLINDRICAL GAGES

Van Keuren Plain Cylindrical Gages are custom made-to-order using American Gage Design standards and are used in quality processes of laboratories and shops to gage parts being manufactured as well as calibrating equipment. Selection of gage tolerance should be in relation to the amount of tolerance on the product being gaged. The normal practice is that the gage tolerance should not exceed 10% of the product tolerance. Gages are furnished in four classes of tolerance, XX, X, Y and Z.

Plain Reversible Plug Gages



Van Keuren Go/Not Go plain reversible plug gage in double end handle.

Van Keuren Plain Cylindrical Reversible Plug Gages, also known as Pin Gages or Wire Type Gages are precision lapped for best accuracy and finish and are held to size their entire length which permits use of both ends of the gage. Van Keuren Plain Plug gages are available in inch or metric and finishes of steel, chrome or solid carbide. Plain Reversible Plug Gages are made to order. Please specify diameter in inch or metric, tolerance class, and application of tolerance - Go (plus), Not Go (minus) or Master (bilateral or split). Handles are not included with single members. Please specify with handle if required. Size, tolerance and tool number are permanently marked on the handle at no extra cost. Chrome, Depth steps, Air Grooves, Carbide, and special sizes are available – please call 1-800-825-4272 and we will gladly prepare a quote. Premium three and five day delivery available.

Wire type or reversible plug gages were originated by Van Keuren in 1923. The wire type design is extremely efficient and economical because the entire surface of the gage may be used and can be reversed or cut-off to increase gage life. Van Keuren plug gages are a highly accurate, economical and convenient tool for hole inspection where a determination is made of compliance within design limits. Close accuracies can be obtained for laboratories and quality departments requiring precise inspection without the lengthy and expensive set-up time of measuring instruments. The fixed dimension of a plug gage eliminates out-of-calibration and cumulative errors. We suggest using plugs gages as Go/Not Go combinations to ensure the hole meets the low and upper limits of the specified design dimensions. Standard practices indicate that 10% of your product tolerance is divided between the Go/Not Go gages. Go gages are plus tolerance and not go gages are minus tolerance. Our gages are available in four classes of tolerance as standard and may be quoted as Class ZZ.

Ordering Information: Locate your size and tolerance. Go is Plus; Not go is minus and Master is split (bilateral). Specify if you require a member only; member with one single-end handle or a Go/Not Go assembly in a double end handle. Available in Chrome – please call for a quote. Handles will be marked with size, Go/Not Go and your tool number if provided. Gages are shipped in clear vials. Certificate of Conformance or Long Form N.I.S.T. Traceable Certificates are available.

REVERSIBLE PLAIN PLUG GAGES

Size Range (From - To)		Classes	Handle No.	Length of Member (Inches)	Useful Gaging Depth
Inches	mm				
0.0030" - 0.0100"	0.0762 mm - 0.2540 mm	Z	1W	1.00"	1/2
0.0101" - 0.0299"	0.254 mm - 0.75946 mm	XX, X, Y, Z	1W	2.00"	1 1/2
0.0300" - 0.0749"	0.762 mm - 1.90246 mm	XX, X, Y, Z	1W	2.00"	1 1/2
0.0750" - 0.1799"	1.905 mm - 4.56946 mm	XX, X, Y, Z	2W	2.00"	1 1/2
0.1800" - 0.2809"	4.572 mm - 7.13486 mm	XX, X, Y, Z	3W	2.00"	1 1/2
0.2810" - 0.4059"	7.1374 mm - 10.309 mm	XX, X, Y, Z	4W	2.00"	1 1/2
0.4060" - 0.5099"	10.312 mm - 12.952 mm	XX, X, Y, Z	5W	2.00"	1 1/2
0.5100" - 0.6349"	12.954 mm - 16.126 mm	XX, X, Y, Z	6W	2.00"	1 1/2
0.6350" - 0.7609"	16.129 mm - 19.304 mm	XX, X, Y, Z	7W	2.00"	1 1/2
0.7610" - 1.0000"	19.329 mm - 25.400 mm	XX, X, Y, Z	8W	2.00"	1 1/2

Class XX: Used where product limits are extremely close or for master gages.

Class X: Used where product limits are relatively close, or occasionally for master gages.

Class Y: Used where product limits are normal to liberal.

Class Z: Used where product limits are quite liberal.

VAN KEUREN PLAIN CYLINDRICAL GAGES

Extra Length Plain Reversible Gages

Extra Length Plain Reversible Plug Gages are also available in chrome and solid carbide. Please call 1-800-825-4272 and we will gladly prepare a quote.



Van Keuren Extra long reversible plain plug gage (member only)

EXTRA LENGTH PLAIN REVERSIBLE PLUG GAGES

Size Range (From - To)		Available Gage Member Lengths (inches)	
Inches	mm	Class XX and X	Class Y and Z
0.0300" - 0.059"	0.07620 mm - 1.4986 mm	3"	3", 4", 5", and 6"
0.0591" - 0.100"	1.50114 mm - 2.5400 mm	3"	3", 4", 5", and 6"
0.1001" - 0.180"	2.54254 mm - 4.5720 mm	3"	3", 4", 5", and 6"
0.1801" - 0.250"	4.57454 mm - 6.3500 mm	3"	3", 4", 5", and 6"
0.2501" - 0.365"	6.35255 mm - 9.2710 mm	3"	3", 4", 5", and 6"
0.3651" - 0.510"	9.27355 mm - 12.9540 mm	3"	3", 4", 5", and 6"
0.5101" - 0.635"	12.95656 mm - 16.1290 mm	3"	3", 4", 5", and 6"
0.6351" - 0.760"	16.13157 mm - 19.3040 mm	3"	3", 4", 5", and 6"

Class Z English and Metric Gage Sets and Libraries

We now offer a variety of Class Z pin gage sets and libraries. Our Class Z pins have a close tolerance of 0.0001 mm which is the most accurate of the Z pin — it's the better pin gage to use for inspection on the shop floor where quick and accurate measurements are required. Multiple uses include setting micrometers and snap gages, measuring hole sizes and depth and Go/Not Go gaging. All sets and libraries are traceable to N.I.S.T. Boxes and gages are clearly marked with the size and serial number on each piece (M-O is not etched). All gage members are 2.000" long. Each gage is centerless lapped to an 8 microfinish or better. We offer Gage sets from 50 pieces to 250 pieces and Library Series Sets from 250 gages to 980 pin gages. Metric libraries and sets have 0.02 mm increments and have 0.0025 mm tolerance limits.

Please call us at 1-800-825-4272 and we will gladly prepare a quote.



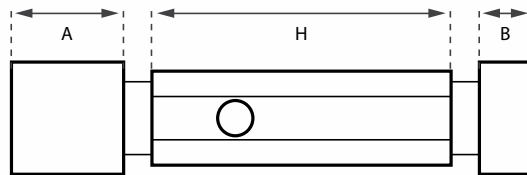
VAN KEUREN PLAIN CYLINDRICAL GAGES

Taperlock Plain Plug Gages

Van Keuren Taperlock Plain Plug Gages are precision lapped for best accuracy and finish and are available in inch or metric and finishes of steel, chrome or solid carbide. Taperlock Plain Plug Gages are made to order. Please specify diameter in inch or metric, tolerance class, and application of tolerance - Go (plus), Not Go (minus) or Master (bilateral or split). Handles are not included with single members. Please specify with handle if required. Size, tolerance and tool number are permanently marked on the handle at no extra cost. Chrome, Depth steps, Air Grooves, Carbide, ZZ and special sizes are available. Premium three and five day delivery available.



Van Keuren Go/Not Go taperlock plug gage in double end handle



A = GO Member
B = NOT GO member
H = Handle

Taperlock Plain Plug Dimensions

All sizes of taperlock plug gages are available in classes - XX, X, Y, Z and ZZ.

TAPERLOCK PLUG GAGES

Size Range (From - To)		GO member Length		NOT GO member Length		Handle No.
Inches	mm	Inches	mm	Inches	mm	
0.105" - 0.1499"	2.67 mm - 3.81 mm	3/8"	9.5 mm	7/32"	5.6 mm	00
0.150" - 0.2299"	3.81 mm - 5.84 mm	13/32"	10.3 mm	9/32"	7.1 mm	0
0.230" - 0.3649"	5.84 mm - 9.27 mm	3/4"	19.1 mm	5/16"	7.9 mm	1
0.365" - 0.5099"	9.27 mm - 12.95 mm	1"	25.4 mm	3/8"	9.5 mm	2
0.510" - 0.8249"	12.95 mm - 20.96 mm	1-1/4"	31.8 mm	1/2"	12.7 mm	3
0.825" - 1.1349"	20.96 mm - 28.83 mm	1-1/2"	38.1 mm	5/8"	15.9 mm	4
1.135" - 1.510"	28.83 mm - 38.35 mm	1-5/8"	41.3 mm	3/4"	19.1 mm	5

GAGEMAKER'S TOLERANCES

Size Range		Class			
From	To (and including)	XX	X	Y	Z
0.021	0.825	0.00002	0.00004	0.00007	0.00010
0.826	1.510	0.00003	0.00006	0.00009	0.00012
1.511	2.510	0.00004	0.00008	0.00012	0.00016
2.511	4.510	0.00005	0.00010	0.00015	0.00020
4.511	6.510	0.000065	0.00013	0.00019	0.00025
6.511	9.010	0.00008	0.00016	0.00024	0.00032
9.011	12.01	0.00010	0.00020	0.00030	0.00040

Class XX: Used where product limits are extremely close or for master gages.

Class X: Used where product limits are relatively close, or occasionally for master gages.

Class Y: Used where product limits are normal to liberal.

Class Z: Used where product limits are quite liberal.

VAN KEUREN PLAIN CYLINDRICAL GAGES

Progressive Taperlock Plug Gages



Van Keuren Progressive Taperlock Gage

Van Keuren Progressive Taperlock Plug Gages are the ideal tool for saving time in any laboratory or manufacturing operation because you can inspect a part in one operation. Both the Go and Not Go members are in line as part of the same gage element.

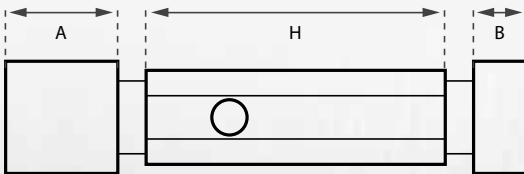
Also available in Trilock Handle Style, metric, special sizes, chrome and solid carbide. Please specify handle style and marking instructions at time of order: Go size, Not Go size and tool number.

General Dimensions

Taperlock and Progressive Taperlock Style

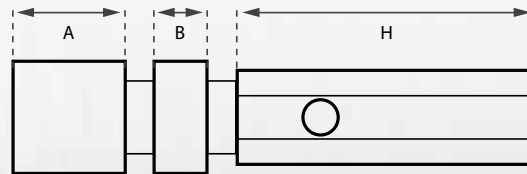
Gaging lengths for progressive style may vary from general taperlock dimensions. The shanks on the gaging member are tapered to fit corresponding taper holes in the handles. Worn members may be removed and the handle salvaged for use with new members.

Taperlock Style



A = GO Member
B = NOT GO member
H = Handle

Progressive Taperlock Style



A = GO Member
B = NOT GO member
H = Handle

All sizes of progressive taperlock plug gages are available in classes XX, X, Y, Z and ZZ.

PROGRESSIVE TAPERLOCK PLUG GAGE

Size Range (From - To)		AGD Progressive member Length		GO member Length		NOT GO member Length		Handle No.
Inches	mm	Inches	mm	Inches	mm	Inches	mm	
0.105" - 0.1499"	2.67 mm - 3.81 mm	23/32"	18.3 mm	3/8"	9.5 mm	7/32"	5.6 mm	00
0.150" - 0.2299"	3.81 mm - 5.84 mm	13/16"	20.6 mm	13/32"	10.3 mm	9/32"	7.1 mm	0
0.230" - 0.3649"	5.84 mm - 9.27 mm	1-3/16"	30.2 mm	3/4"	19.1 mm	5/16"	7.9 mm	1
0.365" - 0.5099"	9.27 mm - 12.95 mm	1-1/2"	38.1 mm	1"	25.4 mm	3/8"	9.5 mm	2
0.510" - 0.8249"	12.95 mm - 20.96 mm	1-7/8"	47.6 mm	1-1/4"	31.8 mm	1/2"	12.7 mm	3
0.825" - 1.1349"	20.96 mm - 28.83 mm	2-1/8"	54.0 mm	1-3/8"	34.9 mm	5/8"	15.9 mm	4
1.135" - 1.5100"	28.83 mm - 38.35 mm	2-3/8"	60.3 mm	1-1/2"	38.1 mm	3/4"	19.1 mm	5

VAN KEUREN PLAIN CYLINDRICAL GAGES

Trilock Plain Plug Gages



Van Keuren Go/Not Go Trilock Plain Plug Gage in double end handle

Van Keuren Trilock Plain Plug Gages are precision lapped for best accuracy and finish and are available in inch or metric and finishes of steel, chrome or solid carbide. These gage members are reversible, so worn out ends may be reversed in the specially designed handle allowing the unused end to be put into use.

Trilock Plain Plug Gages are made to order. Please specify diameter in inch or metric, tolerance class, and application of tolerance - Go (plus), Not Go (minus) or Master (bilateral or split). Handles are not included with single members. Please specify with handle if required. Size, tolerance and tool number are permanently marked on the handle at no extra cost.

Chrome, Depth steps, Air Grooves, Carbide, ZZ, and special sizes are available – please call 1-800-825-4272 and we will gladly prepare a quote. We also can provide premium three and five day delivery if requested for a small increase in price – please call for premium delivery prices.

All sizes of trilock plug gages are available in classes XX, X, Y and Z.

TRILOCK PLUG GAGES

Size Range (From - To)		GO member Length		NOT GO member Length		Handle No.
Inches	mm	Inches	mm	Inches	mm	
0.760" - 0.9469"	19.30 mm - 24.05 mm	1-1/4"	31.8 mm	3/4"	19.1 mm	2 1/2
0.947" - 1.1349"	24.05 mm - 28.83 mm	1-3/8"	34.9 mm	3/4"	19.1 mm	3 1/2
1.135" - 1.5099"	28.83 mm - 38.35 mm	1-1/2"	38.1 mm	3/4"	19.1 mm	4 1/2
1.510" - 2.0099"	38.25 mm - 51.05 mm	1-7/8"	47.6 mm	7/8"	22.2 mm	5 1/2
2.010" - 2.5099"	51.05 mm - 63.75 mm	2"	50.8 mm	7/8"	22.2 mm	6
2.510" - 3.0099"	63.75 mm - 76.45 mm	2"	50.8 mm	1"	25.4 mm	7
3.010" - 3.5099"	76.45 mm - 89.15 mm	2"	50.8 mm	1"	25.4 mm	
3.510" - 4.0099"	89.15 mm - 101.85 mm	2-1/8"	54.0 mm	1"	25.4 mm	
4.010" - 4.5099"	101.85 mm - 114.55 mm	2-1/8"	54.0 mm	1"	25.4 mm	
4.510" - 5.0099"	114.55 mm - 127.25 mm	2-1/8"	54.0 mm	1"	25.4 mm	
5.010" - 5.5099"	127.25 mm - 139.95 mm	2-1/8"	54.0 mm	1"	25.4 mm	
5.510" - 6.0099"	139.95 mm - 152.65 mm	2-1/8"	54.0 mm	1"	25.4 mm	
6.010" - 6.5099"	152.65 mm - 165.35 mm	2-1/8"	54.0 mm	1"	25.4 mm	
6.510" - 8.0100"	165.35 mm - 203.45 mm	2-1/8"	54.0 mm	1"	25.4 mm	

GAGEMAKER'S TOLERANCES

Size Range		Class			
From	To (and including)	XX	X	Y	Z
0.021	0.825	0.00002	0.00004	0.00007	0.00010
0.826	1.510	0.00003	0.00006	0.00009	0.00012
1.511	2.510	0.00004	0.00008	0.00012	0.00016
2.511	4.510	0.00005	0.00010	0.00015	0.00020
4.511	6.510	0.000065	0.00013	0.00019	0.00025
6.511	9.010	0.00008	0.00016	0.00024	0.00032
9.011	12.01	0.00010	0.00020	0.00030	0.00040

Class XX: Used where product limits are extremely close or for master gages.

Class X: Used where product limits are relatively close, or occasionally for master gages.

Class Y: Used where product limits are normal to liberal.

Class Z: Used where product limits are quite liberal.

VAN KEUREN PLAIN CYLINDRICAL GAGES

Master Setting Discs



Van Keuren Master Setting Discs are widely used for setting comparators, snap gages and other equipment and are available in three styles: Style Number 1 features bilateral tolerance (plus and minus) and relief on the ends to prevent wear. Style Number 2 features unilateral tolerance (Go and Not Go on one member) and relief on the ends to prevent wear. Style Number 3 features bilateral tolerance and is the most popular style.

Our Master Setting Discs are precision lapped for best accuracy and finish and are available in inch or metric and finishes of steel, chrome or solid carbide. Our Master Setting Discs are made to order. Please specify diameter in inch or metric, tolerance class, and style required. Clear acrylic insulating grips are included at no extra charge for ease of use.

Chrome, Carbide and larger sizes are available – please call 1-800-825-4272 and we will gladly prepare a quote. Premium three and five day delivery available – please call for premium delivery prices.

All sizes of master setting discs are available in classes XX, X, Y, Z and ZZ.

MASTER SETTING DISCS

Size Range (From - To)		Bilateral Tolerance (Style #3) Length		Unilateral Tolerance (Style #2) Length		Bilateral Tolerance (Style #1) Length	
Inches	mm	Inches	mm	Inches	mm	Inches	mm
0.150" - 0.229"	3.810 mm - 5.840 mm	7/16"	11.1 mm	7/8"	22.2 mm	7/8"	22.2 mm
0.230" - 0.364"	5.840 mm - 9.270 mm	1/2"	12.7 mm	1"	25.4 mm	1"	25.4 mm
0.365" - 0.509"	9.270 mm - 12.95 mm	9/16"	14.3 mm	1-1/8"	28.6 mm	1-1/8"	28.6 mm
0.510" - 0.824"	12.95 mm - 20.96 mm	5/8"	15.9 mm	1-1/4"	31.8 mm	1-1/4"	31.8 mm
0.825" - 1.134"	20.96 mm - 28.83 mm	11/16"	17.5 mm	1-3/8"	34.9 mm	1-3/8"	34.9 mm
1.135" - 1.509"	28.83 mm - 38.35 mm	13/16"	20.6 mm	1-5/8"	41.3 mm	1-5/8"	41.3 mm
1.510" - 2.009"	38.35 mm - 51.05 mm	7/8"	22.2 mm	2"	50.8 mm	1-7/8"	47.6 mm
2.010" - 2.509"	51.05 mm - 63.75 mm	7/8"	22.2 mm	2"	50.8 mm	2"	50.8 mm
2.510" - 3.009"	63.75 mm - 76.45 mm	1"	25.4 mm	2-1/4"	57.2 mm	2"	50.8 mm
3.010" - 3.509"	76.45 mm - 89.15 mm	1"	25.4 mm	2-1/4"	57.2 mm	2"	50.8 mm
3.510" - 4.009"	89.15 mm - 101.85 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
4.010" - 4.509"	101.85 mm - 114.55 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
4.510" - 5.009"	114.55 mm - 127.25 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
5.010" - 5.509"	127.25 mm - 139.95 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
5.510" - 6.009"	139.95 mm - 152.65 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
6.010" - 6.509"	152.65 mm - 165.35 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
6.510" - 7.009"	165.35 mm - 178.05 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
7.010" - 7.509"	178.05 mm - 190.75 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
7.510" - 8.009"	190.75 mm - 203.45 mm	1"	25.4 mm	2-1/4"	57.2 mm	2-1/8"	54.0 mm
8.010" - 10.010"	203.45 mm - 254.25 mm	1"	25.4 mm	not available			

VAN KEUREN PLAIN CYLINDRICAL GAGES

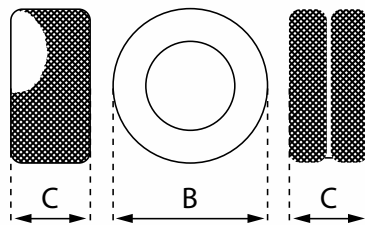
Plain Cylindrical Ring Gages

Van Keuren Cylindrical Ring Gages are used to check external diameters of straight round parts and to set other gages, such as bore gages, internal micrometers and air gages.

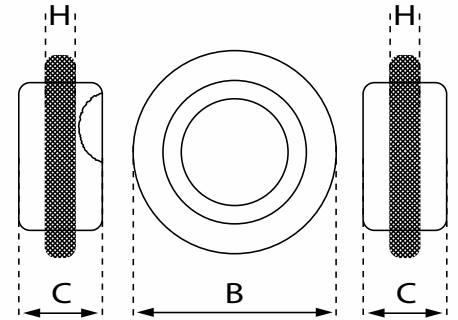


Van Keuren Plain Cylindrical Ring Gages

Plain Cylindrical Ring Gages dimensions



Furnished in sizes up to 1.510" the ring gages are thicker and the Not Go ring is identified by the groove around the outside diameter.



Ring gages above 1.510" are thinner with a flange to reduce weight and increase rigidity.

CYLINDRICAL PLAIN RING GAGES TOLERANCES

Size Range (From - To)		Tolerances (Inches)				Outside Diameter (B)	Thickness (C)	Flange Thickness (H)	Blank No.
Inches	mm	Class XX	Class X	Class Y	Class Z				
0.059" - 0.150"	1.50 mm - 3.81mm	0.00002	0.00004	0.00007	0.00010	15/16	3/16	none	00
0.150" - 0.240"	3.81 mm - 6.10 mm	0.00002	0.00004	0.00007	0.00010	15/16	3/8	none	0
0.240" - 0.365"	6.10 mm - 9.27 mm	0.00002	0.00004	0.00007	0.00010	1 1/8	9/16	none	1
0.365" - 0.510"	9.27 mm - 12.95 mm	0.00002	0.00004	0.00007	0.00010	1 3/8	3/4	none	2
0.510" - 0.825"	12.95 mm - 20.96 mm	0.00002	0.00004	0.00007	0.00010	1 3/4	15/16	none	3
0.825" - 1.135"	20.96 mm - 28.83 mm	0.00003	0.00006	0.00009	0.00012	2 1/8	1 1/8	none	4
1.135" - 1.510"	28.83 mm - 38.35 mm	0.00003	0.00006	0.00009	0.00012	2 1/2	1 5/16	none	5
1.510" - 2.010"	38.35 mm - 51.05 mm	0.00004	0.00008	0.00012	0.00016	4	1 1/2	1/2	6
2.010" - 2.510"	51.05 mm - 63.75 mm	0.00004	0.00008	0.00012	0.00016	4 1/2	1 1/2	9/16	7
2.510" - 3.010"	63.75 mm - 76.45 mm	0.00005	0.00010	0.00015	0.00020	5	1 1/2	5/8	8
3.010" - 3.510"	76.45 mm - 89.15 mm	0.00005	0.00010	0.00015	0.00020	5 1/2	1 1/2	11/16	9
3.510" - 4.010"	89.15 mm - 101.85 mm	0.00005	0.00010	0.00015	0.00020	6 3/8	1 1/2	3/4	10
4.010" - 4.510"	101.85 mm - 114.55 mm	0.00005	0.00010	0.00015	0.00020	7 1/4	1 1/2	7/8	11
4.510" - 4.760"	114.55 mm - 120.90 mm	0.000065	0.00013	0.00019	0.00025	7 1/4	1 1/2	7/8	11

GAGEMAHER'S TOLERANCES

Size Range		Class			
From	To (and including)	XX	X	Y	Z
0.021	0.825	0.00002	0.00004	0.00007	0.00010
0.826	1.510	0.00003	0.00006	0.00009	0.00012
1.511	2.510	0.00004	0.00008	0.00012	0.00016
2.511	4.510	0.00005	0.00010	0.00015	0.00020
4.511	6.510	0.000065	0.00013	0.00019	0.00025
6.511	9.010	0.00008	0.00016	0.00024	0.00032
9.011	12.01	0.00010	0.00020	0.00030	0.00040

VAN KEUREN PLAIN CYLINDRICAL GAGES



Plain Cylindrical Ring Gages

Van Keuren Cylindrical Ring Plain Gages are precision lapped for best accuracy and finish and are available in inch or metric and finishes of steel, chrome or solid carbide. Long form N.I.S.T. traceable certification is available. Please call 1-800-825-4272 and we will gladly prepare a quote. Cylindrical Plain Ring Gages are made to order. Please specify diameter in inch or metric, tolerance class, and application of tolerance - Go (minus), Not Go (plus) or Master (bilateral or split).

Van Keuren Plain Cylindrical Ring Gages

All sizes of steel and chrome ring gages are available in classes XX, X, Y, Z and ZZ.

STEEL AND CHROME RING GAGES

Size Range (From - To)		STD.A.G.D. Blank				Blank No.
Inches	mm	Length (Inches)	O.D. (Inches)	Length (mm)	O.D. (mm)	
0.070" - .0150"	1.780 mm - 3.810 mm	3/16"	15/16"	4.8 mm	23.8 mm	00
0.151" - 0.230"	3.810 mm - 5.840 mm	3/8"	15/16"	9.5 mm	23.8 mm	0
0.231" - 0.365"	5.840 mm - 9.270 mm	9/16"	1 1/8"	14.3 mm	28.6 mm	1
0.366" - 0.510"	9.270 mm - 12.95 mm	3/4"	1-3/8"	19.1 mm	34.9 mm	2
0.511" - 0.825"	12.95 mm - 20.96 mm	15/16"	1-3/4"	23.8 mm	44.4 mm	3
0.826" - 1.135"	20.96 mm - 28.83 mm	1-1/8"	2-1/8"	28.6 mm	54.0 mm	4
1.136" - 1.510"	28.83 mm - 38.35 mm	1 5/16"	2-1/2"	33.3 mm	63.5 mm	5
1.511" - 2.010"	38.35 mm - 51.05 mm	1-1/2"	4"	38.1 mm	101.6 mm	6
2.011" - 2.510"	51.05 mm - 63.75 mm	1-1/2"	4-1/2"	38.1 mm	114.3 mm	7
2.511" - 3.010"	63.75 mm - 76.45 mm	1-1/2"	5"	38.1 mm	127.0 mm	8
3.011" - 3.510"	76.45 mm - 89.15 mm	1-1/2"	5-1/2"	38.1 mm	139.7 mm	9
3.511" - 4.010"	89.15 mm - 101.85 mm	1-1/2"	6-3/8"	38.1 mm	161.9 mm	10
4.011" - 4.760"	101.85 mm - 120.90 mm	1-1/2"	7-1/4"	38.1 mm	184.2 mm	11
4.761" - 5.510"	120.90 mm - 139.95 mm	1-1/2"	8-1/4"	38.1 mm	209.6 mm	12
5.511" - 6.260"	139.95 mm - 159.00 mm	1-1/2"	9-1/4"	38.1 mm	235.0 mm	13
6.261" - 7.010"	159.00 mm - 178.05 mm	1-1/2"	10-1/4"	38.1 mm	260.4 mm	14
7.011" - 7.760"	178.05 mm - 197.10 mm	1-1/2"	11-1/4"	38.1 mm	285.8 mm	15
7.761" - 8.510"	197.10 mm - 216.15 mm	1-1/2"	12-1/4"	38.1 mm	311.2 mm	16
8.511" - 9.260"	216.15 mm - 235.20 mm	1-1/2"	13-1/4"	38.1 mm	336.6 mm	17
9.261" - 10.010"	235.20 mm - 254.25 mm	1-1/2"	14-1/4"	38.1 mm	362.0 mm	18
10.011" - 10.760"	254.25 mm - 273.30 mm	1-1/2"	15-1/4"	38.1 mm	387.4 mm	19
10.761" - 11.510"	273.30 mm - 292.35 mm	1-1/2"	16-1/4"	38.1 mm	412.8 mm	20
11.511" - 12.260"	292.35 mm - 311.40 mm	1-1/2"	17-1/4"	38.1 mm	438.2 mm	21
12.261" - 13.010"	311.40 mm - 330.45 mm	1-1/2"	18-1/4"	38.1 mm	463.6 mm	22
13.011" - 13.760"	330.45 mm - 349.50 mm	1-1/2"	19-1/4"	38.1 mm	489.0 mm	23
13.761" - 14.510"	349.50 mm - 368.55 mm	1-1/2"	20-1/4"	38.1 mm	514.4 mm	24
14.511" - 15.260"	368.55 mm - 387.60 mm	1-1/2"	21-1/4"	38.1 mm	539.8 mm	25
15.261" - 16.010"	387.60 mm - 406.65 mm	1-1/2"	22-1/4"	38.1 mm	565.2 mm	26

VAN KEUREN THREADED GAGES

Threaded Plug and Ring Gages



Van Keuren Threaded Plug Gages

Choosing Van Keuren threaded gages to ensure your part is within your specified limits will have a positive effect on your production costs. Go and Not Go Thread Gages are used in manufacturing applications to provide the user with a quick and accurate method of inspecting and verifying that their threaded product meets the required specification.

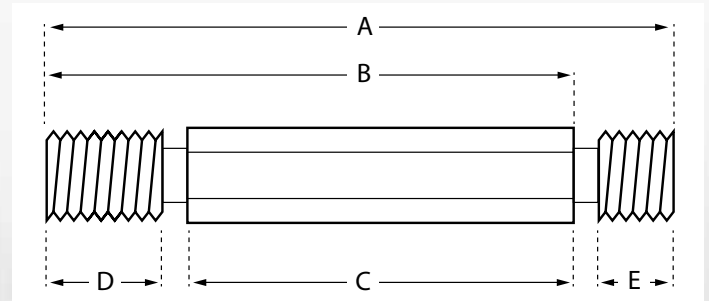
Van Keuren threaded gages are ground, precision lapped and then meticulously inspected to every thread element. We make our gages to X-tolerance and we stock class 2A/2B for general applications such as bolt, nut, screw and similar threaded fasteners and class 3A/3B for applications where closeness of fit and accuracy of lead and angle of thread are important. Metric Thread Gages are stocked in standard 6H and 6g Tolerance.

Van Keuren Precision Measuring Tools Handbook No. 37 is the number one resource for everything you need to know about Threaded Gages and is a great reference guide for any shop or laboratory. Thread Identification Designations and Terminology and much more can be found in the Van Keuren Precision Measuring Tools Handbook No. 37. (EDP No: VKHANDBOOK37)

Taperlock Thread Plug Gages



Van Keuren Go / Not Go Taperlock Thread Plug Gage in double end handle



Taperlock Thread Plug Gage Dimensions

TAPERLOCK STEEL THREAD PLUG GAGE DIMENSIONS

Nominal Size		Length (Inches)					Handle	
Inches	mm	A Overall	B GO member & Handle	C Handle Only	D GO member	E NOT GO member	Hex. Size	No.
0, 1, 2, 3	1.52, 1.6, 2, 2.5 mm	2-1/2"	2-1/32"	1-1/2"	1/4"	3/16"	3/16"	000
4, 5, 6	2.84, 3, 3.5 mm	2-31/32"	2-13/32"	1-3/4"	5/16"	7/32"	1/4"	00
8, 10, 12	4, 4.5, 5 mm	3-3/16"	2-21/32"	2"	13/32"	9/32"	5/16"	0
1/4", 5/16"	6, 6.3, 7, 8 mm	4-1/16"	3-1/2"	2-3/4"	1/2"	5/16"	3/8"	1
3/8", 7/16", 1/2"	10, 12 mm	4-5/8"	4"	3"	3/4"	3/8"	1/2"	2
9/16", 5/8", 3/4"	14, 16, 18, 20 mm	5-1/8"	4-3/8"	3-1/4"	7/8"	1/2"	11/16"	3
7/8", 1", 1-1/8"	24 mm	5-7/8"	4-15/16"	3-5/8"	1"	5/8"	7/8"	4
1-1/4", 1-3/8", 1-1/2"	31.8, 34.9, 38.1 mm	5-1/2" + D*	4-3/8" + D*	4"	D*	3/4"	1"	5

*D = 1" for 12 threads per inch and finer; 1-1/4" for threads per inch coarser than 12.

VAN KEUREN THREADED GAGES

X TOLERANCE FOR GO AND NOT GO THREAD GAGES

TPI	Lead (±)	Half Angle (±)	Major or Minor Diameter		Pitch Diameter		
			To and Including 4"	Above 4" Diameter	To & Including 1-1/2"	Above 1-1/2" to 4"	Above 4" to 8"
80	0.0002	30 min	0.0003		0.0002		
72	0.0002	30 min	0.0003				
64	0.0002	30 min	0.0004				
56	0.0002	30 min	0.0004				
48	0.0002	30 min	0.0004				
44	0.0002	20 min	0.0004				
40	0.0002	20 min	0.0004				
36	0.0002	20 min	0.0004				
32	0.0003	15 min	0.0005	0.0007	0.0003	0.0004	0.0005
28	0.0003	15 min	0.0005	0.0007	0.0003	0.0004	0.0005
24	0.0003	15 min	0.0005	0.0007	0.0003	0.0004	0.0005
20	0.0003	15 min	0.0005	0.0007	0.0003	0.0004	0.0005
18	0.0003	10 min	0.0005	0.0007	0.0003	0.0004	0.0005
16	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
14	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
13	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
12	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
11	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
10	0.0003	10 min	0.0006	0.0009	0.0003	0.0004	0.0006
9	0.0003	10 min	0.0007	0.0011	0.0003	0.0004	0.0006
8	0.0004	5 min	0.0007	0.0011	0.0004	0.0005	0.0006
7	0.0004	5 min	0.0007	0.0011	0.0004	0.0005	0.0006
6	0.0004	5 min	0.0008	0.0013	0.0004	0.0005	0.0006
5	0.0004	5 min	0.0008	0.0013		0.0005	0.0006
4.5	0.0004	5 min	0.0008	0.0013		0.0005	0.0006
4	0.0004	5 min	0.0009	0.0015		0.0005	0.0006

Thread gages are made to class X tolerances unless otherwise specified on orders or drawings.

Special Precision Plug and Ring Gages



Van Keuren Go/Not Go Taperlock Steel Thread Plug Gage in double end handle

Our state-of-the-art engineering, design and manufacturing capabilities allow us to manufacture special thread gages for every type of precision measuring requirement. We produce plug and ring gages up to 16-inches in size. Our special gage offering includes Acme, Buttress, AWWA, BSPT, BSPP, NGT, NPSH, Multi-Lead, IMC, PTF, SAE, Taper, Paddle Type, Concentricity, Line Pipe and Sucker Rod and many more. We offer Long Form N.I.S.T. Traceable A2LA 17025 Calibration Reports on all our gages. Please call us at 1-800-825-4272 and we will gladly prepare a quote.

VAN KEUREN THREADED GAGES

Taperlock HSS TiN Coated



Van Keuren Taperlock TiN (titanium nitride) Coated Thread Plug Gages are manufactured from High Speed Steel and coated with TiN. TiN coating provides added hardness and lubricity which greatly increases gage life and provides greater surface hardness as well as corrosion and abrasion resistance. Ideal for severe gaging applications such as abrasive products being gaged or high quantity of products being gaged.

Van Keuren TiN Coated Go/Not Go Thread Plug Gage in double end handle

Special pitch diameters and size are available – please call 1-800-825-4272 and we will gladly prepare a quote.

UNIFIED TIN TAPERLOCK THREAD PLUG GAGES

Nominal Size	GO Member	NOT GO Members and DE Assemblies				Handle
	Class 2B or 3B (Basic)	Class 2B	2B DE in Handle	Class 3B	3B DE in Handle	
2-56 UNC	W008656GTINK	W0086562BNTINK	W0086562BSTIN	W0086563BNTINK	W0086563BSTIN	000
2-64 UNF	W008664GTINK	W0086642BNTINK	W0086642BSTIN	W0086643BNTINK	W0086643BSTIN	000
3-48 UNC	W009948GTINK	W0099482BNTINK	W0099482BSTIN	W0099483BNTINK	W0099483BSTIN	000
3-56 UNF	W009956GTINK	W0099562BNTINK	W0099562BSTIN	W0099563BNTINK	W0099563BSTIN	000
4-40 UNC	W011240GTINK	W0112402BNTINK	W0112402BSTIN	W0112403BNTINK	W0112403BSTIN	00
4-48 UNF	W011248GTINK	W0112482BNTINK	W0112482BSTIN	W0112483BNTINK	W0112483BSTIN	00
5-40 UNC	W012540GTINK	W0125402BNTINK	W0125402BSTIN	W0125403BNTINK	W0125403BSTIN	00
5-44 UNF	W012544GTINK	W0125442BNTINK	W0125442BSTIN	W0125443BNTINK	W0125443BSTIN	00
6-32 UNC	W013832GTINK	W0138322BNTINK	W0138322BSTIN	W0138323BNTINK	W0138323BSTIN	00
6-40 UNF	W013840GTINK	W0138402BNTINK	W0138402BSTIN	W0138403BNTINK	W0138403BSTIN	00
8-32 UNC	W016432GTINK	W0164322BNTINK	W0164322BSTIN	W0164323BNTINK	W0164323BSTIN	0
8-36 UNF	W016436GTINK	W0164362BNTINK	W0164362BSTIN	W0164363BNTINK	W0164363BSTIN	0
10-24 UNC	W019024GTINK	W0190242BNTINK	W0190242BSTIN	W0190243BNTINK	W0190243BSTIN	0
10-32 UNF	W019032GTINK	W0190322BNTINK	W0190322BSTIN	W0190323BNTINK	W0190323BSTIN	0
12-24 UNC	W021624GTINK	W0216242BNTINK	W0216242BSTIN	W0216243BNTINK	W0216243BSTIN	0
12-28 UNF	W021628GTINK	W0216282BNTINK	W0216282BSTIN	W0216283BNTINK	W0216283BSTIN	0
1/4-20 UNC	W025020GTINK	W0250202BNTINK	W0250202BSTIN	W0250203BNTINK	W0250203BSTIN	1
1/4-28 UNF	W025028GTINK	W0250282BNTINK	W0250282BSTIN	W0250283BNTINK	W0250283BSTIN	1
5/16-18 UNC	W031218GTINK	W0312182BNTINK	W0312182BSTIN	W0312183BNTINK	W0312183BSTIN	1
5/16-24 UNF	W031224GTINK	W0312242BNTINK	W0312242BSTIN	W0312243BNTINK	W0312243BSTIN	1
3/8-16 UNC	W037516GTINK	W0375162BNTINK	W0375162BSTIN	W0375163BNTINK	W0375163BSTIN	2
3/8-24 UNF	W037524GTINK	W0375242BNTINK	W0375242BSTIN	W0375243BNTINK	W0375243BSTIN	2
7/16-14 UNC	W043714GTINK	W0437142BNTINK	W0437142BSTIN	W0437143BNTINK	W0437143BSTIN	2
7/16-20 UNF	W043720GTINK	W0437202BNTINK	W0437202BSTIN	W0437203BNTINK	W0437203BSTIN	2
1/2-13 UNC	W050013GTINK	W0500132BNTINK	W0500132BSTIN	W0500133BNTINK	W0500133BSTIN	2
1/2-20 UNF	W050020GTINK	W0500202BNTINK	W0500202BSTIN	W0500203BNTINK	W0500203BSTIN	2
9/16-12 UNC	W056212GTINK	W0562122BNTINK	W0562122BSTIN	W0562123BNTINK	W0562123BSTIN	3
9/16-18 UNF	W056218GTINK	W0562182BNTINK	W0562182BSTIN	W0562183BNTINK	W0562183BSTIN	3
5/8-11 UNC	W062511GTINK	W0625112BNTINK	W0625112BSTIN	W0625113BNTINK	W0625113BSTIN	3
5/8-18 UNF	W062518GTINK	W0625182BNTINK	W0625182BSTIN	W0625183BNTINK	W0625183BSTIN	3
3/4-10 UNC	W075010GTINK	W0750102BNTINK	W0750102BSTIN	W0750103BNTINK	W0750103BSTIN	3
3/4-16 UNF	W075016GTINK	W0750162BNTINK	W0750162BSTIN	W0750163BNTINK	W0750163BSTIN	3

VAN KEUREN THREADED GAGES

Unified Taperlock Steel Threaded Gages



Van Keuren Steel Go/Not Go Taperlock Thread Plug Gage in double end handle

Van Keuren Taperlock Steel Thread Plug Gages are machined from highest quality oil hardened tool steel with chip grooves supplied on all Go members from #10 Machine Screw size and larger. Our Taperlock Plug Gages are available in steel, chrome, solid carbide and TiN coat. Left hand thread, special pitch diameters and special sizes are available. Please call us at 1-800-825-4272 and we will gladly prepare a quote. Please specify type (member only, member with handle or double end with handle); nominal size and threads per inch; Go or Not Go member (or both in double end handle) and Class of fit (2B or 3B). Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

UNIFIED STEEL TAPERLOCK THREAD PLUG GAGES

Nominal Size	GO Member	NOT GO Members and DE Assemblies				Handle
	Class 2B or 3B (Basic)	Class 2B	2B DE in Handle	Class 3B	3B DE in Handle	
0-80 UNF	W006080GK	W0060802BNK	W0060802BS	W0060803BNK	W0060803BS	000
1-64 UNC	W007364GK	W0073642BNK	W0073642BS	W0073643BNK	W0073643BS	000
1-72 UNF	W007372GK	W0073722BNK	W0073722BS	W0073723BNK	W0073723BS	000
2-56 UNC	W008656GK	W0086562BNK	W0086562BS	W0086563BNK	W0086563BS	000
2-64 UNF	W008664GK	W0086642BNK	W0086642BS	W0086643BNK	W0086643BS	000
3-48 UNC	W009948GK	W0099482BNK	W0099482BS	W0099483BNK	W0099483BS	000
3-56 UNF	W009956GK	W0099562BNK	W0099562BS	W0099563BNK	W0099563BS	000
4-40 UNC	W011240GK	W0112402BNK	W0112402BS	W0112403BNK	W0112403BS	00
4-48 UNF	W011248GK	W0112482BNK	W0112482BS	W0112483BNK	W0112483BS	00
5-40 UNC	W012540GK	W0125402BNK	W0125402BS	W0125403BNK	W0125403BS	00
5-44 UNF	W012544GK	W0125442BNK	W0125442BS	W0125443BNK	W0125443BS	00
6-32 UNC	W013832GK	W0138322BNK	W0138322BS	W0138323BNK	W0138323BS	00
6-40 UNF	W013840GK	W0138402BNK	W0138402BS	W0138403BNK	W0138403BS	00
8-32 UNC	W016432GK	W0164322BNK	W0164322BS	W0164323BNK	W0164323BS	0
8-36 UNF	W016436GK	W0164362BNK	W0164362BS	W0164363BNK	W0164363BS	0
10-24 UNC	W019024GK	W0190242BNK	W0190242BS	W0190243BNK	W0190243BS	0
10-32 UNF	W019032GK	W0190322BNK	W0190322BS	W0190323BNK	W0190323BS	0
12-24 UNC	W021624GK	W0216242BNK	W0216242BS	W0216243BNK	W0216243BS	0
12-28 UNF	W021628GK	W0216282BNK	W0216282BS	W0216283BNK	W0216283BS	0
12-32 UNEF	W021632GK	W0216322BNK	W0216322BS	W0216323BNK	W0216323BS	0
1/4-20 UNC	W025020GK	W0250202BNK	W0250202BS	W0250203BNK	W0250203BS	1
1/4-28 UNF	W025028GK	W0250282BNK	W0250282BS	W0250283BNK	W0250283BS	1
1/4-32 UNEF	W025032GK	W0250322BNK	W0250322BS	W0250323BNK	W0250323BS	1
5/16-18 UNC	W031218GK	W0312182BNK	W0312182BS	W0312183BNK	W0312183BS	1
5/16-24 UNF	W031224GK	W0312242BNK	W0312242BS	W0312243BNK	W0312243BS	1
5/16-32 UNEF	W031232GK	W0312322BNK	W0312322BS	W0312323BNK	W0312323BS	1
3/8-16 UNC	W037516GK	W0375162BNK	W0375162BS	W0375163BNK	W0375163BS	2
3/8-24 UNF	W037524GK	W0375242BNK	W0375242BS	W0375243BNK	W0375243BS	2
3/8-32 UNEF	W037532GK	W0375322BNK	W0375322BS	W0375323BNK	W0375323BS	2
7/16-14 UNC	W043714GK	W0437142BNK	W0437142BS	W0437143BNK	W0437143BS	2
7/16-20 UNF	W043720GK	W0437202BNK	W0437202BS	W0437203BNK	W0437203BS	2
7/16-28 UNEF	W043728GK	W0437282BNK	W0437282BS	W0437203BNK	W0437203BS	2

UNIFIED STEEL TAPERLOCK THREAD PLUG GAGES (CONTINUED)

Nominal Size	GO Member	NOT GO Members and DE Assemblies				Handle
	Class 2B or 3B (Basic)	Class 2B	2B DE in Handle	Class 3B	3B DE in Handle	
1/2-13 UNC	W050013GK	W0500132BNK	W0500132BS	W0500133BNK	W0500133BS	2
1/2-20 UNF	W050020GK	W0500202BNK	W0500202BS	W0500203BNK	W0500203BS	2
1/2-28 UNEF	W050028GK	W0500282BNK	W0500282BS	W0500283BNK	W0500283BS	2
9/16-12 UNC	W056212GK	W0562122BNK	W0562122BS	W0562123BNK	W0562123BS	3
9/16-18 UNF	W056218GK	W0562182BNK	W0562182BS	W0562183BNK	W0562183BS	3
9/16-24 UNEF	W056224GK	W0562242BNK	W0562242BS	W0562243BNK	W0562243BS	3
5/8-11 UNC	W062511GK	W0625112BNK	W0625112BS	W0625113BNK	W0625113BS	3
5/8-18 UNF	W062518GK	W0625182BNK	W0625182BS	W0625183BNK	W0625183BS	3
5/8-24 UNEF	W062524GK	W0625242BNK	W0625242BS	W0625243BNK	W0625243BS	3
11/16-24 UNEF	W068724GK	W0687242BNK	W0687242BS	W0687243BNK	W0687243BS	3
3/4-10 UNC	W075010GK	W0750102BNK	W0750102BS	W0750103BNK	W0750103BS	3
3/4-16 UNF	W075016GK	W0750162BNK	W0750162BS	W0750163BNK	W0750163BS	3
3/4-20 UNEF	W075020GK	W0750202BNK	W0750202BS	W0750203BNK	W0750203BS	3
13/16-20 UNEF	W081220GK	W0812202BNK	W0812202BS	W0812203BNK	W0812203BS	3
7/8-9 UNC	W087509GK	W0875092BNK	W0875092BS	W0875093BNK	W0875093BS	4
7/8-14 UNF	W087514GK	W0875142BNK	W0875142BS	W0875143BNK	W0875143BS	4
7/8-20 UNEF	W087520GK	W0875202BNK	W0875202BS	W0875203BNK	W0875203BS	4
15/16-20 UNEF	W093720GK	W0937202BNK	W0937202BS	W0937203BNK	W0937203BS	4
1-8 UNC	W100008GK	W1000082BNK	W1000082BS	W1000083BNK	W1000083BS	4
1-12 UNF	W100012GK	W1000122BNK	W1000122BS	W1000123BNK	W1000123BS	4
1-14 UNS	W100014GK	W1000142BNK	W1000142BS	W1000143BNK	W1000143BS	4
1-20 UNEF	W100020GK	W1000202BNK	W1000202BS	W1000203BNK	W1000203BS	4
1 1/16-12 UNF	W106212GK	W1062122BNK	W1062122BS	W1062123BNK	W1062123BS	4
1 1/16-18 UNEF	W106218GK	W1062182BNK	W1062182BS	W1062183BNK	W1062183BS	4
1 1/8-7 UNC	W112507GK	W1125072BNK	W1125072BS	W1125073BNK	W1125073BS	4
1 1/8-12 UNF	W112512GK	W1125122BNK	W1125122BS	W1125123BNK	W1125123BS	4
1 1/8-18 UNEF	W112518GK	W1125182BNK	W1125182BS	W1125183BNK	W1125183BS	4
1 3/16-12 UNF	W118712GK	W1187122BNK	W1187122BS	W1187123BNK	W1187123BS	4
1 3/16-18 UNEF	W118718GK	W1187182BNK	W1187182BS	W1187183BNK	W1187183BS	4
1 1/4-7 UNC	W125007GK	W1250072BNK	W1250072BS	W1250073BNK	W1250073BS	5
1 1/4-12 UNF	W125012GK	W1250122BNK	W1250122BS	W1250123BNK	W1250123BS	5
1 1/4-18 UNEF	W125018GK	W1250182BNK	W1250182BS	W1250183BNK	W1250183BS	5
1 5/16-12 UNF	W131212GK	W1312122BNK	W1312122BS	W1312123BNK	W1312123BS	5
1 5/16-18 UNEF	W131218GK	W1312182BNK	W1312182BS	W1312183BNK	W1312183BS	5
1 3/8-6 UNC	W137506GK	W1375062BNK	W1375062BS	W1375063BNK	W1375063BS	5
1 3/8-12 UNF	W137512GK	W1375122BNK	W1375122BS	W1375123BNK	W1375123BS	5
1 3/8-18 UNEF	W137518GK	W1375182BNK	W1375182BS	W1375183BNK	W1375183BS	5
1 7/16-12 UNF	W143712GK	W1437122BNK	W1437122BS	W1437123BNK	W1437123BS	5
1 7/16-18 UNEF	W143718GK	W1437182BNK	W1437182BS	W1437183BNK	W1437183BS	5
1 1/2-6 UNC	W150006GK	W1500062BNK	W1500062BS	W1500063BNK	W1500063BS	5
1 1/2-12 UNF	W150012GK	W1500122BNK	W1500122BS	W1500123BNK	W1500123BS	5
1 1/2-18 UNEF	W150018GK	W1500182BNK	W1500182BS	W1500183BNK	W1500183BS	5

VAN KEUREN THREADED GAGES

Metric Taperlock Steel Thread Gages



Van Keuren Metric Taperlock Threaded Gage in double end handle

Van Keuren Metric Taperlock Steel Thread Plug Gages are machined from the highest quality oil hardened tool steel and are stocked in 6H Tolerance standard. Please specify nominal diameter, thread per inch and Go or Not Go member (or both in double end handle). Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

Our Metric Taperlock Plug Gages are available in chrome, solid carbide, and TiN coat. Special pitch diameters and size as well as left hand are available. Please call us at 1-800-825-4272 and we will gladly prepare a quote.

METRIC THREAD PLUG GAGES

Size	Pitch	GO Member 6H	NOT GO Member 6H	DE in Handle	Handle
M1.6	0.35	W0160356HGK	W0160356HNK	W0160356HS	000
M1.8	0.35	W0180356HGK	W0180356HNK	W0180356HS	000
M2	0.40	W0200406HGK	W0200406HNK	W0200406HS	000
M2.2	0.45	W0220456HGK	W0220456HNK	W0220456HS	000
M2.5	0.45	W0250456HGK	W0250456HNK	W0250456HS	000
M3	0.50	W0300506HGK	W0300506HNK	W0300506HS	00
M3.5	0.60	W0350606HGK	W0350606HNK	W0350606HS	00
M4	0.70	W0400706HGK	W0400706HNK	W0400706HS	0
M4.5	0.75	W0450756HGK	W0450756HNK	W0450756HS	0
M5	0.80	W0500806HGK	W0500806HNK	W0500806HS	0
M5.5	0.75	W0550756HGK	W0550756HNK	W0550756HS	0
M6	1.00	W0601006HGK	W0601006HNK	W0601006HS	1
M7	1.00	W0701006HGK	W0701006HNK	W0701006HS	1
M8	1.25	W0801256HGK	W0801256HNK	W0801256HS	1
M9	1.25	W0901256HGK	W0901256HNK	W0901256HS	2
M10	0.75	W1000756HGK	W1000756HNK	W1000756HS	2
M10	1.25	W1001256HGK	W1001256HNK	W1001256HS	2
M10	1.50	W1001506HGK	W1001506HNK	W1001506HS	2
M11	1.50	W1101506HGK	W1101506HNK	W1101506HS	2
M12	1.25	W1201256HGK	W1201256HNK	W1201256HS	2
M12	1.50	W1201506HGK	W1201506HNK	W1201506HS	2
M12	1.75	W1201756HGK	W1201756HNK	W1201756HS	2
M14	1.50	W1401506HGK	W1401506HNK	W1401506HS	3
M14	2.00	W1402006HGK	W1402006HNK	W1402006HS	3
M15	1.00	W1501006HGK	W1501006HNK	W1501006HS	3
M15	1.50	W1501506HGK	W1501506HNK	W1501506HS	3
M16	1.50	W1601506HGK	W1601506HNK	W1601506HS	3
M16	2.00	W1602006HGK	W1602006HNK	W1602006HS	3
M17	1.00	W1701006HGK	W1701006HNK	W1701006HS	3
M17	1.50	W1701506HGK	W1701506HNK	W1701506HS	3
M18	1.50	W1801506HGK	W1801506HNK	W1801506HS	3
M18	2.50	W1802506HGK	W1802506HNK	W1802506HS	3

VAN KEUREN THREADED GAGES

METRIC THREAD PLUG GAGES (CONTINUED)

Size	Pitch	GO Member 6H	NOT GO Member 6H	DE in Handle	Handle
M20	1.00	W2001006HGK	W2001006HNK	W2001006HS	4
M20	1.50	W2001506HGK	W2001506HNK	W2001506HS	4
M20	2.50	W2002506HGK	W2002506HNK	W2002506HS	4
M22	1.50	W2201506HGK	W2201506HNK	W2201506HS	4
M22	2.50	W2202506HGK	W2202506HNK	W2202506HS	4
M24	2.00	W2402006HGK	W2402006HNK	W2402006HS	4
M24	3.00	W2403006HGK	W2403006HNK	W2403006HS	4
M25	1.50	W2501506HGK	W2501506HNK	W2501506HS	4
M25	2.00	W2502006HGK	W2502006HNK	W2502006HS	4
M26	1.00	W2601006HGK	W2601006HNK	W2601006HS	4
M26	1.50	W2601506HGK	W2601506HNK	W2601506HS	4
M27	2.00	W2702006HGK	W2702006HNK	W2702006HS	4
M27	3.00	W2703006HGK	W2703006HNK	W2703006HS	4
M28	1.00	W2801006HGK	W2801006HNK	W2801006HS	4
M28	1.50	W2801506HGK	W2801506HNK	W2801506HS	4
M28	2.00	W2802006HGK	W2802006HNK	W2802006HS	4
M30	1.50	W3001506HGK	W3001506HNK	W3001506HS	5
M30	2.00	W3002006HGK	W3002006HNK	W3002006HS	5
M30	3.50	W3003506HGK	W3003506HNK	W3003506HS	5
M32	1.50	W3201506HGK	W3201506HNK	W3201506HS	5
M32	2.00	W3202006HGK	W3202006HNK	W3202006HS	5
M33	2.00	W3302006HGK	W3302006HNK	W3302006HS	5
M33	3.50	W3303506HGK	W3303506HNK	W3303506HS	5
M35	1.50	W3501506HGK	W3501506HNK	W3501506HS	5
M36	2.00	W3602006HGK	W3602006HNK	W3602006HS	5
M36	3.00	W3603006HGK	W3603006HNK	W3603006HS	5
M36	4.00	W3604006HGK	W3604006HNK	W3604006HS	5
M38	1.50	W3801506HGK	W3801506HNK	W3801506HS	5
*M39	2.00	W3902006HGK	W3902006HNK	W3902006HS	5
*M39	3.00	W3903006HGK	W3903006HNK	W3903006HS	5
*M39	4.00	W3904006HGK	W3904006HNK	W3904006HS	5

*Gages are trilock design.

VAN KEUREN THREADED GAGES

Helical Coil Taperlock Steel Gages (STI)

Van Keuren STI Gages are furnished in standard Class X tolerance and meet the demands of gaging oversized tapped holes prior to inserting Screw Thread Inserts. Stocked in 2B and 3B class of fit as standard.

Please specify type (member only, member with handle or double end with handle); nominal size and threads per inch; Go or Not Go member (or both in double end handle) and Class of fit (2B or 3B). Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

Our STI Plug Gages are available in chrome and TiN coat. Special pitch diameters; special size, metric and W tolerance are available – please call 1-800-825-4272 and we will gladly prepare a quote.



Van Keuren Go/Not Go Helical Coil Taperlock Gage in double end handle

HELICAL COIL TAPERLOCK STEEL GAGES (STI) X TOLERANCE

Size	Thread Length		GO Member	NOT GO Member				Handle
	GO	NOT GO	Class 2B and 3B	Class 2B	2B DE in Handle	Class 3B	3B DE in Handle	
2-56 UNC	5/16	7/32	H008656GK	H0086562BNK	H0086562BS	H0086563BNK	H0086563BS	0
4-40 UNC	5/16	7/32	H011240GK	H0112402BNK	H0112402BS	H0112403BNK	H0112403BS	0
4-48 UNF	5/16	7/32	H011248GK	H0112482BNK	H0112482BS	H0112483BNK	H0112483BS	0
5-40 UNC	5/16	7/32	H012540GK	H0125402BNK	H0125402BS	H0125403BNK	H0125403BS	0
6-32 UNC	13/32	7/32	H013832GK	H0132322BNK	H0132322BS	H0138323BNK	H0138323BS	0
6-40 UNF	13/32	7/32	H013840GK	H0138402BNK	H0138402BS	H0138403BNK	H0138403BS	0
8-32 UNC	13/32	7/32	H016432GK	H0164322BNK	H0164322BS	H0164323BNK	G0164323BS	0
8-36 UNF	13/32	7/32	H016436GK	H0164362BNK	H0164362BS	H0164363BNK	H0164363BS	0
10-24 UNC	13/32	7/32	H019024GK	H0190242BNK	H0190242BS	H0190243BNK	H0190243BS	0
10-32 UNF	13/32	7/32	H019032GK	H0190322BNK	H0190322BS	H0190323BNK	H0190323BS	0
12-24 UNC	1/2	5/16	H021624GK	H0216242BNK	H0216242BS	H0216243BNK	H0216243BS	1
1/4-20 UNC	1/2	5/16	H025020GK	H0250202BNK	H0250202BS	H0250203BNK	H0250203BS	1
1/4-28 UNF	1/2	5/16	H025028GK	H0250282BNK	H0250282BS	H0250283BNK	H0250283BS	1
5/16-18 UNC	3/4	3/8	H031218GK	H0312182BNK	H0312182BS	H0312183BNK	H0312183BS	2
5/16-24UNF	3/4	3/8	H031224GK	H0312242BNK	H0312242BS	H0312243BNK	H0312243BS	2
3/8-16 UNC	3/4	3/8	H037516GK	H0375162BNK	H0375162BS	H0375163BNK	H0375163BS	2
3/8-24 UNF	3/4	3/8	H037524GK	H0375242BNK	H0375242BS	H0375243BNK	H0375243BS	2
7/16-14 UNC	3/4	3/8	H043714GK	H0437142BNK	H0437142BS	H0375143BNK	H0375143BS	2
7/16-20 UNF	3/4	3/8	H043720GK	H0437202BNK	H0437202BS	H0437203BNK	H0437203BS	2
1/2-13 UNC	7/8	1/2	H050013GK	H0500132BNK	H0500132BS	H0500133BNK	H0500133BS	3
1/2-20 UNF	7/8	1/2	H050020GK	H0500202BNK	H0500202BS	H0500203BNK	H0500203BS	3
9/16-12 UNC	7/8	1/2	H056212GK	H0562122BNK	H0562122BS	H0562123BNK	H0562123BS	3
9/16-18 UNF	7/8	1/2	H056218GK	H0562182BNK	H0562182BS	H0562183BNK	H0562183BS	3
5/8-11 UNC	7/8	1/2	H062511GK	H0625112BNK	H0625112BS	H0625113BNK	H0625113BS	3
5/8-18 UNF	7/8	1/2	H062518GK	H0625182BNK	H0625182BS	H0625183BNK	H0625183BS	3
3/4-10 UNC	1	5/8	H075010GK	H0750102BNK	H0750102BS	H0750103BNK	H0750103BS	4
3/4-16 UNF	1	5/8	H075016GK	H0750162BNK	H0750162BS	H0750163BNK	H0750163BS	4

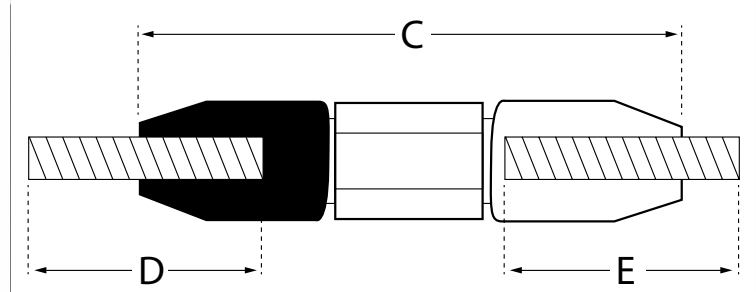
VAN KEUREN THREADED GAGES

Unified Reversible Steel Thread Plug Gages

Van Keuren Reversible Thread Plug Gages are straight and held to size over their entire length, which permits the use of both ends of the gage member (also a cost reduction). The added length of the reversible gage member allows gaging of greater thread depths. We make our gages to X tolerance and they are stocked in class 2B and 3B class of fit. Chip grooves supplied on Go members from #10 Machine Screw Size and larger.



Van Keuren Go/Not Go Reversible Thread Plug Gage in double end handle



General dimensions of reversible thread plug gage.

UNIFIED REVERSIBLE THREAD PLUG GAGE DIMENSIONS

Nominal Size (Inches)	Length (Inches)			Handle	
	C Handle Only	D GO Member	E NOT GO Member	Hex. Size	No.
0, 1	1-29/32"	1/2"	1/2"	1/4"	1W
2, 3, 4, 5	2-15/32"	5/8"	5/8"	3/8"	2W
6, 8	2/15/32"	3/4"	3/4"	3/8"	2W
10, 1/4"	3-1/8"	7/8"	7/8"	9/16"	3W
5/16"	3-19/32"	1"	1"	11/16"	4W
3/8"	3-19/32"	1-1/8"	1-1/8"	13/16"	4W
7/16"	4-3/16"	1-1/4"	1-1/4"	13/16"	5W
1/2"	4-3/16"	1-3/8"	1-3/8"	13/16"	5W
9/16"	4-17/32"	1-1/2"	1-3/8"	15/16"	6W
3/4"	4-21/32"	1-3/4"	1-3/4"	1-1/16"	7W

Please specify type (member only, member with handle or double end with handle); nominal size and threads per inch; Go or Not Go member (or both in double end handle) and Class of fit (2B or 3B). Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

Our Reversible Thread Plug Gages are available in steel, chrome, solid carbide, TiN coat, left-hand, and special sizes. Please call 1-800-825-4272 and we will gladly prepare a quote.

Van Keuren Precision Measuring Tools Handbook No. 37 is the number one resource for everything you need to know about Threaded Gages and is a great reference guide for any shop or laboratory. Thread identification designations and terminology and much more can be found in the Van Keuren Precision Measuring Tools Handbook No. 37. (EDP No: VKHANDBOOK37)

VAN KEUREN THREADED GAGES

UNIFIED REVERSIBLE STEEL THREAD PLUG GAGES

Size	GO Member	NOT GO Member				Handle
	Class 2B and 3B	Class 2B	2B DE in Handle	Class 3B	3B DE in Handle	
0-80 UNF	V006080GK	V0060802BNK	V0060802BS	V0060803BNK	V0060803BS	1W
1-64 UNC	V007364GK	V0073642BNK	V0073642BS	V0073643BNK	V0073643BS	1W
1-72 UNF	V007372GK	V0073722BNK	V0073722BS	V0073723BNK	V0073723BS	1W
2-56 UNC	V008656GK	V0086562BNK	V0086562BS	V0086563BNK	V0086563BS	2W
2-64 UNF	V008664GK	V0086642BNK	V0086642BS	V0086643BNK	V0086643BS	2W
3-48 UNC	V009948GK	V0099482BNK	V0099482BS	V0099483BNK	V0099483BS	2W
3-56 UNF	V009956GK	V0099562BNK	V0099562BS	V0099563BNK	V0099563BS	2W
4-40 UNC	V011240GK	V0112402BNK	V0112402BS	V0112403BNK	V0112403BS	2W
4-48 UNF	V011248GK	V0112482BNK	V0112482BS	V0112483BNK	V0112483BS	2W
5-40 UNC	V012540GK	V0125402BNK	V0125402BS	V0125403BNK	V0125403BS	2W
5-44 UNF	V012544GK	V0125442BNK	V0125442BS	V0125443BNK	V0125443BS	2W
6-32 UNC	V013832GK	V0138322BNK	V0138322BS	V0138323BNK	V0138323BS	2W
6-40 UNF	V013840GK	V0138402BNK	V0138402BS	V0138403BNK	V0138403BS	2W
8-32 UNC	V016432GK	V0164322BNK	V0164322BS	V0164323BNK	V0164323BS	2W
8-36 UNF	V016436GK	V0164362BNK	V0164362BS	V0164363BNK	V0164363BS	2W
10-24 UNC	V019024GK	V0190242BNK	V0190242BS	V0190243BNK	V0190243BS	3W
10-32 UNF	V019032GK	V0190322BNK	V0190322BS	V0190323BNK	V0190323BS	3W
12-24 UNC	V021624GK	V0216242BNK	V0216242BS	V0216243BNK	V0216243BS	3W
12-28 UNF	V021628GK	V0216282BNK	V0216282BS	V0216283BNK	V0216283BS	3W
12-32 UNEF	V021632GK	V0216322BNK	V0216322BS	V0216323BNK	V0216323BS	3W
1/4-20 UNC	V025020GK	V0250202BNK	V0250202BS	V0250203BNK	V0250203BS	3W
1/4-28 UNF	V025028GK	V0250282BNK	V0250282BS	V0250283BNK	V0250283BS	3W
1/4-32 UNEF	V025032GK	V0250322BNK	V0250322BS	V0250323BNK	V0250323BS	3W
5/16-18 UNC	V031218GK	V0312182BNK	V0312182BS	V0312183BNK	V0312183BS	4W
5/16-24 UNF	V031224GK	V0312242BNK	V0312242BS	V0312243BNK	V0312243BS	4W
5/16-32 UNEF	V031232GK	V0312322BNK	V0312322BS	V0312323BNK	V0312323BS	4W
3/8-16 UNC	V037516GK	V0375162BNK	V0375162BS	V0375163BNK	V0375163BS	4W
3/8-24 UNF	V037524GK	V0375242BNK	V0375242BS	V0375243BNK	V0375243BS	4W
3/8-32 UNEF	V037532GK	V0375322BNK	V0375322BS	V0375323BNK	V0375323BS	4W
7/16-14 UNC	V043714GK	V0437142BNK	V0437142BS	V0437143BNK	V0437143BS	5W
7/16-20 UNF	V043720GK	V0437202BNK	V0437202BS	V0437203BNK	V0437203BS	5W
7/16-28 UNEF	V043728GK	V0437282BNK	V0437282BS	V0437283BNK	V0437283BS	5W
1/2-13 UNC	V050013GK	V0500132BNK	V0500132BS	V0500133BNK	V0500133BS	5W
1/2-20 UNF	V050020GK	V0500202BNK	V0500202BS	V0500203BNK	V0500203BS	5W
1/2-28 UNEF	V050028GK	V0500282BNK	V0500282BS	V0500283BNK	V0500283BS	5W
9/16-12 UNC	V056212GK	V0562122BNK	V0562122BS	V0562123BNK	V0562123BS	6W
9/16-18 UNF	V056218GK	V0562182BNK	V0562182BS	V0562183BNK	V0562183BS	6W
5/8-11 UNC	V062511GK	V0625112BNK	V0625112BS	V0625113BNK	V0625113BS	6W
5/8-18 UNF	V062518GK	V0625182BNK	V0625182BS	V0625183BNK	V0625183BS	6W
3/4-10 UNC	V075010GK	V0750102BNK	V0750102BS	V0750103BNK	V0750103BS	7W
3/4-16 UNF	V075016GK	V0750162BNK	V0750162BS	V0750163BNK	V0750163BS	7W

VAN KEUREN THREADED GAGES

Metric Reversible Steel Thread Plug Gages



Van Keuren Go/Not Go Reversible Thread Plug Gage in double end handle

Van Keuren Metric Reversible Steel Thread Plug Gages are machined from the highest quality oil hardened tool steel and are stocked in 6H Tolerance standard with other classes available by request.

Please specify nominal diameter, threads per inch and Go or Not Go member (or both in double end handle). Handles are not included with members unless specified. Customer specific tool numbers marked upon request. Our Metric Reversible Plug Gages are available in chrome, solid carbide and TiN coat. Special pitch diameters and size as well as left hand are available – please call 1-800-825-4272 and we will gladly prepare a quote.

METRIC REVERSIBLE STEEL THREAD PLUG GAGES

Size	Pitch	GO Member	NOT GO Member	DE in Handle	Handle
M1.6	0.35	V0160356HGK	V0160356HNK	V0160356HS	1W
M1.8	0.35	V0180356HGK	V0180356HNK	V0180356HS	1W
M2	0.40	V0200406HGK	V0200406HNK	V0200406HS	2W
M2.2	0.45	V0220456HGK	V0220456HNK	V0220456HS	2W
M2.5	0.45	V0250456HGK	V0250456HNK	V0250456HS	2W
M3	0.50	V0300506HGK	V0300506HNK	V0300506HS	2W
M3.5	0.60	V0350606HGK	V0350606HNK	V0350606HS	2W
M4	0.70	V0400706HGK	V0400706HNK	V0400706HS	2W
M4.5	0.75	V0450756HGK	V0450756HNK	V0450756HS	3W
M5	0.80	V0500806HGK	V0500806HNK	V0500806HS	3W
M5.5	0.75	V0550756HGK	V0550756HNK	V0550756HS	3W
M6	1.00	V0601006HGK	V0601006HNK	V0601006HS	3W
M7	1.00	V0701006HGK	V0701006HNK	V0701006HS	3W
M8	1.25	V0801256HGK	V0801256HNK	V0801256HS	4W
M9	1.25	V0901256HGK	V0901256HNK	V0901256HS	4W
M10	0.75	V1000756HGK	V1000756HNK	V1000756HS	4W
M10	1.25	V1001256HGK	V1001256HNK	V1001256HS	4W
M10	1.50	V1001506HGK	V1001506HNK	V1001506HS	4W
M11	1.50	V1101506HGK	V1101506HNK	V1101506HS	4W
M12	1.25	V1201256HGK	V1201256HNK	V1201256HS	5W
M12	1.50	V1201506HGK	V1201506HNK	V1201506HS	5W
M12	1.75	V1201756HGK	V1201756HNK	V1201756HS	5W
M14	1.50	V1401506HGK	V1401506HNK	V1401506HS	6W
M14	2.00	V1402006HGK	V1402006HNK	V1402006HS	6W
M15	1.00	V1501006HGK	V1501006HNK	V1501006HS	6W
M15	1.50	V1501506HGK	V1501506HNK	V1501506HS	6W
M16	1.50	V1601506HGK	V1601506HNK	V1601506HS	7W
M16	2.00	V1602006HGK	V1602006HNK	V1602006HS	7W
M17	1.00	V1701006HGK	V1701006HNK	V1701006HS	7W
M17	1.50	V1701506HGK	V1701506HNK	V1701506HS	7W
M18	1.50	V1801506HGK	V1801506HNK	V1801506HS	7W
M18	2.50	V1802506HGK	V1802506HNK	V1802506HS	7W

VAN KEUREN THREADED GAGES

Adjustable Threaded Ring Gages

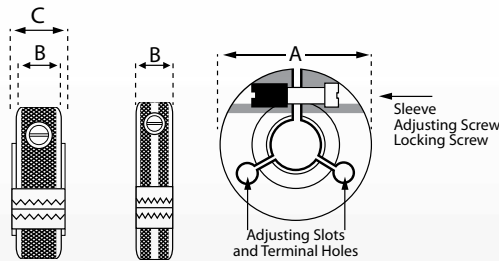


Van Keuren adjustable Go ring gage



Van Keuren adjustable Not Go ring gage

Van Keuren Adjustable Thread Ring Gages are manufactured from selected steel, machined and precision lapped and then meticulously inspected in every thread element. We set our rings with our high quality Thread Setting Plug Gages or Hilo Setting Plug Gages. Not Go ring gages are distinguished by a groove around the outside diameter. Setting plug gages should be ordered at the same time as ring gages to ensure proper mating. Pitch Diameter of adjustable thread ring cannot be taken as a direct measurement. The functional pitch diameter is transferred by the setting plug to the ring gage. The ring gage setting is unique to the particular setting plug gage and cannot be expected to be duplicated on any other setting plug gage without readjustment. The functional pitch diameter of any two given setting plugs both known to be within tolerance specifications could vary by more than 0.0003" from each other. Also, the relative "feel" of the inspector setting the ring gage plays a major role in the evaluation of this attribute. All our information is taken directly from the American Measuring Tool Manufacturers Association.



General Dimensions for Thread Ring Gages. Thick Blank (left), Thin Blank (right), and inner ring.

THREAD RING GAGE DIMENSIONS

Nominal Size		Holder and Ring Blank No.	All Blanks	Thin Blanks			Thick Blanks GO UNC Only		
Inches	mm		A Outside Diameter	B Thickness	Depth Counterbore	Length Thread	B Thickness Flange	C Thickness Hub	D Diameter Hub
0, 1, 2	1.52, 1.6, 2 mm	1	1	1/4	5/64	3/32	-	-	-
3, 4, 5, 6	2.5, 3, 3.5 mm	1	1	1/4	3/64	5/32	-	-	-
8, 10, 12	4, 5 mm	1	1	1/4	1/32	3/16	-	-	-
1/4", 5/16"	6, 8 mm	2	1.375	11/32	-	-	-	-	-
3/8", 7/16", 1/2"	10, 12 mm	3	1.75	7/16	-	-	-	-	-
9/16", 5/8", 3/4"	14, 16, 20 mm	4	2-3/16	9/16	-	-	9/16	3/4	1-1/16
7/8", 1", 1-1/8"	24 mm	5	2.625	11/16	-	-	11/16	15/16	1-1/2
1-1/4", 1-3/8", 1-1/2"	-	6	3.25	3/4	-	-	3/4	1-1/8	1-7/8

Thread Ring Gage Holders



Optional holders are available in these sizes:

- Holder 1 (Size 0" - 12", 1.6mm - 5mm)
- Holder 2 (Size 1/4" - 5/16", 6mm - 8mm)
- Holder 3 (Size 3/8" - 1/2", 10mm - 12mm)
- Holder 4 (Size 9/16" - 3/4", 14mm - 20mm)
- Holder 5 (Size 7/8" - 1-1/8", 24mm)
- Holder 6 (Size 1-1/4" - 1-1/2", 31.75mm - 38.10mm)

VAN KEUREN THREADED GAGES

Unified Adjustable Thread Ring Gages



Van Keuren adjustable Go ring gage

Van Keuren adjustable Not Go ring gage

Van Keuren Thread Ring Gages are best if purchased with and mated to a setting plug gage at the time of order. Please specify nominal diameter, pitch and class of fit required. Van Keuren Thread Ring Gages are stocked in standard 2A and 3A class of fit. Van Keuren Adjustable Thread Ring Gages are available in J thread, chrome, left hand, special sizes and special pitch diameters. Please call 1-800-825-4272 and we will gladly provide you with a quote.

Please specify nominal diameter, threads per inch, Go or Not Go member (or both) and 2A or 3A class of fit. We will specially mark your gage with your tool number if provided.

UNIFIED THREAD RING GAGES

Nominal Size	Class 2A			Class 3A			Holder
	GO member	NOT GO member	GO / NOT GO DE Ring	GO member	NOT GO member	GO / NOT GO DE Ring	
0-80 UNF	R0060802AGK	R0060802ANK	R0060802AS	R0060803AGK	R0060803ANK	R0060803AS	1
1-64 UNC	R0073642AGK	R0073642ANK	R0073642AS	R0073643AGK	R0073643ANK	R0073643AS	1
1-72 UNF	R0073722AGK	R0073722ANK	R0073722AS	R0073723AGK	R0073723ANK	R0073723AS	1
2-56 UNC	R0086562AGK	R0086562ANK	R0086562AS	R0086563AGK	R0086563ANK	R0086563AS	1
2-64 UNF	R0086642AGK	R0086642ANK	R0086642AS	R0086643AGK	R0086643ANK	R0086643AS	1
3-48 UNC	R0099482AGK	R0099482ANK	R0099482AS	R0099483AGK	R0099483ANK	R0099483AS	1
3-56 UNF	R0099562AGK	R0099562ANK	R0099562AS	R0099563AGK	R0099563ANK	R0099563AS	1
4-40 UNC	R0112402AGK	R0112402ANK	R0112402AS	R0112403AGK	R0112403ANK	R0112403AS	1
4-48 UNF	R0112482AGK	R0112482ANK	R0112482AS	R0012483AGK	R0012483ANK	R0012483AS	1
5-40 UNC	R0125402AGK	R0125402ANK	R0125402AS	R0125403AGK	R0125403ANK	R0125403AS	1
5-44 UNF	R0125442AGK	R0125442ANK	R0125442AS	R0125443AGK	R0125443ANK	R0125443AS	1
6-32 UNC	R0138322AGK	R0138322ANK	R0138322AS	R0138323AGK	R0138323ANK	R0138323AS	1
6-40 UNF	R0138402AGK	R0138402ANK	R0138402AS	R0138403AGK	R0138403ANK	R0138403AS	1
8-32 UNC	R0164322AGK	R0164322ANK	R0164322AS	R0164323AGK	R0164323ANK	R0164323AS	1
8-36 UNF	R0164362AGK	R0164362ANK	R0164362AS	R0164363AGK	R0164363ANK	R0164363AS	1
10-24 UNC	R0190242AGK	R0190242ANK	R0190242AS	R0190243AGK	R0190243ANK	R0190243AS	1
10-32 UNF	R0190322AGK	R0190322ANK	R0190322AS	R0190323AGK	R0190323ANK	R0190323AS	1
12-24 UNC	R0216242AGK	R0216242ANK	R0216242AS	R0216243AGK	R0216243ANK	R0216243AS	1
12-28 UNF	R0216282AGK	R0216282ANK	R0216282AS	R0216283AGK	R0216283ANK	R0216283AS	1
12-32 UNEF	R0216322AGK	R0216322ANK	R0216322AS	R0216323AGK	R0216323ANK	R0216323AS	1
1/4-20 UNC	R0250202AGK	R0250202ANK	R0250202AS	R0250203AGK	R0250203ANK	R0250203AS	2
1/4-28 UNF	R0250282AGK	R0250282ANK	R0250282AS	R0250283AGK	R0250283ANK	R0250283AS	2
1/4-32 UNEF	R0250322AGK	R0250322ANK	R0250322AS	R0250323AGK	R0250323ANK	R0250323AS	2
5/16-18 UNC	R0312182AGK	R0312182ANK	R0312182AS	R0312183AGK	R0312183ANK	R0312183AS	2
5/16-24 UNF	R0312242AGK	R0312242ANK	R0312242AS	R0312243AGK	R0312243ANK	R0312243AS	2
5/16-32 UNEF	R0312322AGK	R0312322ANK	R0312322AS	R0312323AGK	R0312323ANK	R0312323AS	2
3/8-16 UNC	R0375162AGK	R0375162ANK	R0375162AS	R0375163AGK	R0375163ANK	R0375163AS	3
3/8-24 UNF	R0375242AGK	R0375242ANK	R0375242AS	R0375243AGK	R0375243ANK	R0375243AS	3
3/8-32 UNEF	R0375322AGK	R0375322ANK	R0375322AS	R0375323AGK	R0375323ANK	R0375323AS	3

Continued on next page.

UNIFIED THREAD RING GAGES (CONTINUED)

Nominal Size	Class 2A			Class 3A			Holder
	GO member	NOT GO member	GO / NOT GO DE Ring	GO member	NOT GO member	GO / NOT GO DE Ring	
7/16-14 UNC	R0437142AGK	R0437142ANK	R0437142AS	R0437143AGK	R0437143ANK	R0437143AS	3
7/16-20 UNF	R0437202AGK	R0437202ANK	R0437202AS	R0437203AGK	R0437203ANK	R0437203AS	3
7/16-28 UNEF	R0437282AGK	R0437282ANK	R0437282AS	R0437283AGK	R0437283ANK	R0437283AS	3
1/2-13 UNC	R0500132AGK	R0500132ANK	R0500132AS	R0500133AGK	R0500133ANK	R0500133AS	3
1/2-20 UNF	R0500202AGK	R0500202ANK	R0500202AS	R0500203AGK	R0500203ANK	R0500203AS	3
1/2-28 UNEF	R0500282AGK	R0500282ANK	R0500282AS	R0500283AGK	R0500283ANK	R0500283AS	3
9/16-12 UNC	R0562122AGK	R0562122ANK	R0562122AS	R0562123AGK	R0562123ANK	R0562123AS	4
9/16-18 UNF	R0562182AGK	R0562182ANK	R0562182AS	R0562183AGK	R0562183ANK	R0562183AS	4
9/16-24 UNEF	R0562242AGK	R0562242ANK	R0562242AS	R0562243AGK	R0562243ANK	R0562243AS	4
5/8-11 UNC	R0625112AGK	R0625112ANK	R0625112AS	R0625113AGK	R0625113ANK	R0625113AS	4
5/8-18 UNF	R0625182AGK	R0625182ANK	R0625182AS	R0625183AGK	R0625183ANK	R0625183AS	4
5/8-24 UNEF	R0625242AGK	R0625242ANK	R0625242AS	R0625243AGK	R0625243ANK	R0625243AS	4
11/16-24 UNEF	R0687242AGK	R0687242ANK	R0687242AS	R0687243AGK	R0687243ANK	R0687243AS	4
3/4-10 UNC	R0750102AGK	R0750102ANK	R0750102AS	R0750103AGK	R0750103ANK	R0750103AS	4
3/4-16 UNF	R0750162AGK	R0750162ANK	R0750162AS	R0750163AGK	R0750163ANK	R0750163AS	4
3/4-20 UNEF	R0750202AGK	R0750202ANK	R0750202AS	R0750203AGK	R0750203ANK	R0750203AS	4
13/16-20 UNEF	R0812202AGK	R0812202ANK	R0812202AS	R0812203AGK	R0812203ANK	R0812203AS	4
7/8-9 UNC	R0875092AGK	R0875092ANK	R0875092AS	R0875093AGK	R0875093ANK	R0875093AS	5
7/8-14 UNF	R0875142AGK	R0875142ANK	R0875142AS	R0875143AGK	R0875143ANK	R0875143AS	5
7/8-20 UNEF	R0875202AGK	R0875202ANK	R0875202AS	R0875203AGK	R0875203ANK	R0875203AS	5
15/16-20 UNEF	R0937202AGK	R0937202ANK	R0937202AS	R0937203AGK	R0937203ANK	R0937203AS	5
1-8 UNC	R1000082AGK	R1000082ANK	R1000082AS	R1000083AGK	R1000083ANK	R1000083AS	5
1-12 UNF	R1000122AGK	R1000122ANK	R1000122AS	R1000123AGK	R1000123ANK	R1000123AS	5
1-14 UNS	R1000142AGK	R1000142ANK	R1000142AS	R1000143AGK	R1000143ANK	R1000143AS	5
1-20 UNEF	R1000202AGK	R1000202ANK	R1000202AS	R1000203AGK	R1000203ANK	R1000203AS	5
1 1/16-12 UNF	R1062122AGK	R1062122ANK	R1062122AS	R1062123AGK	R1062123ANK	R1062123AS	5
1 1/16-18 UNEF	R1062182AGK	R1062182ANK	R1062182AS	R1062183AGK	R1062183ANK	R1062183AS	5
1 1/8-7 UNC	R1125072AGK	R1125072ANK	R1125072AS	R1125073AGK	R1125073ANK	R1125073AS	5
1 1/8-12 UNF	R1125122AGK	R1125122ANK	R1125122AS	R1125123AGK	R1125123ANK	R1125123AS	5
1 1/8-18 UNEF	R1125182AGK	R1125182ANK	R1125182AS	R1125183AGK	R1125183ANK	R1125183AS	5
1 3/16-12 UNF	R1187122AGK	R1187122ANK	R1187122AS	R1187123AGK	R1187123ANK	R1187123AS	6
1 3/16-18 UNEF	R1187182AGK	R1187182ANK	R1187182AS	R1187183AGK	R1187183ANK	R1187183AS	6
1 1/4-7 UNC	R1250072AGK	R1250072ANK	R1250072AS	R1250073AGK	R1250073ANK	R1250073AS	6
1 1/4-12 UNF	R1250122AGK	R1250122ANK	R1250122AS	R1250123AGK	R1250123ANK	R1250123AS	6
1 1/4-18 UNEF	R1250182AGK	R1250182ANK	R1250182AS	R1250183AGK	R1250183ANK	R1250183AS	6
1 5/16-12 UNF	R1312122AGK	R1312122ANK	R1312122AS	R1312123AGK	R1312123ANK	R1312123AS	6
1 5/16-18 UNEF	R1312182AGK	R1312182ANK	R1312182AS	R1312183AGK	R1312183ANK	R1312183AS	6
1 3/8-6 UNC	R1375062AGK	R1375062ANK	R1375062AS	R1375063AGK	R1375063ANK	R1375063AS	6
1 3/8-12 UNF	R1375122AGK	R1375122ANK	R1375122AS	R1375123AGK	R1375123ANK	R1375123AS	6
1 3/8-18 UNEF	R1375182AGK	R1375182ANK	R1375182AS	R1375183AGK	R1375183ANK	R1375183AS	6
1 7/16-12 UNF	R1437122AGK	R1437122ANK	R1437122AS	R1437123AGK	R1437123ANK	R1437123AS	6
1 7/16-18 UNEF	R1437182AGK	R1437182ANK	R1437182AS	R1437183AGK	R1437183ANK	R1437183AS	6
1 1/2-6 UNC	R1500062AGK	R1500062ANK	R1500062AS	R1500063AGK	R1500063ANK	R1500063AS	6
1 1/2-12 UNF	R1500122AGK	R1500122ANK	R1500122AS	R1500123AGK	R1500123ANK	R1500123AS	6
1 1/2-18 UNEF	R1500182AGK	R1500182ANK	R1500182AS	R1500183AGK	R1500183ANK	R1500183AS	6

VAN KEUREN THREADED GAGES

Unified Truncated Thread Setting Plug Gages



Van Keuren Go/Not Go Truncated Set Plug in a double end handle

Van Keuren Truncated Thread Setting Plug Gages have a full form threaded portion and a truncated portion. The pitch diameter is constant over the full length and the length of the thread is approximately twice that of the corresponding ring gage. The full form portion checks the pitch diameter and the major diameter clearance. The truncated portion checks pitch diameter and flank angle wear thus assuring the proper setting and control of thread ring gages. Setting Plug Gages are used for setting and evaluating adjustable thread ring gages. Standard Thread Setting Plugs are class X tolerance on pitch diameter, while holding W tolerance on lead and angles. Our set plug gages are stocked in 2A and 3A Class of Fit.

Van Keuren Truncated Thread Setting Plug Gages are available in class W tolerance, left hand, special sizes and special pitch diameter. Please specify nominal diameter, threads per inch and Go or Not Go member (or both in double end handle) and 2A or 3A class of fit. Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

UNIFIED TRUNCATED THREAD SETTING PLUG GAGES X TOLERANCE

Nominal Size	Class 2A			Class 3A		
	GO Member	NOT GO Member	DE in Handle	GO Member	NOT GO Member	DE in Handle
0-80 UNF	S0060802AGK	S0060802ANK	S0060802AS	S0060803AGK	S0060803ANK	S0060803AS
1-64 UNC	S0073642AGK	S0073642ANK	S0073642AS	S0073643AGK	S0073643ANK	S0073643AS
1-72 UNF	S0073722AGK	S0073722ANK	S0073722AS	S0073723AGK	S0073723ANK	S0073723AS
2-56 UNC	S0086562AGK	S0086562ANK	S0086562AS	S0086563AGK	S0086563ANK	S0086563AS
2-64 UNF	S0086642AGK	S0086642ANK	S0086642AS	S0086643AGK	S0086643ANK	S0086643AS
3-48 UNC	S0099482AGK	S0099482ANK	S0099482AS	S0099483AGK	S0099483ANK	S0099483AS
3-56 UNF	S0099562AGK	S0099562ANK	S0099562AS	S0099563AGK	S0099563ANK	S0099563AS
4-40 UNC	S0112402AGK	S0112402ANK	S0112402AS	S0112403AGK	S0112403ANK	S0112403AS
4-48 UNF	S0112482AGK	S0112482ANK	S0112482AS	S0112483AGK	S0112483ANK	S0112483AS
5-40 UNC	S0125402AGK	S0125402ANK	S0125402AS	S0125403AGK	S0125403ANK	S0125403AS
5-44 UNF	S0125442AGK	S0125442ANK	S0125442AS	S0125443AGK	S0125443ANK	S0125443AS
6-32 UNC	S0138322AGK	S0138322ANK	S0138322AS	S0138323AGK	S0138323ANK	S0138323AS
6-40 UNF	S0138402AGK	S0138402ANK	S0138402AS	S0138403AGK	S0138403ANK	S0138403AS
8-32 UNC	S0164322AGK	S0164322ANK	S0164322AS	S0164323AGK	S0164323ANK	S0164323AS
8-36 UNF	S0164362AGK	S0164362ANK	S0164362AS	S0164363AGK	S0164363ANK	S0164363AS
10-24 UNC	S0190242AGK	S0190242ANK	S0190242AS	S0190243AGK	S0190243ANK	S0190243AS
10-32 UNF	S0190322AGK	S0190322ANK	S0190322AS	S0190323AGK	S0190323ANK	S0190323AS
12-24 UNC	S0216242AGK	S0216242ANK	S0216242AS	S0216243AGK	S0216243ANK	S0216243AS
12-28 UNF	S0216282AGK	S0216282ANK	S0216282AS	S0216283AGK	S0216283ANK	S0216283AS
12-32 UNEF	S0216322AGK	S0216322ANK	S0216322AS	S0216323AGK	S0216323ANK	S0216323AS
1/4-20 UNC	S0250202AGK	S0250202ANK	S0250202AS	S0250203AGK	S0250203ANK	S0250203AS
1/4-28 UNF	S0250282AGK	S0250282ANK	S0250282AS	S0250283AGK	S0250283ANK	S0250283AS
1/4-32 UNEF	S0250322AGK	S0250322ANK	S0250322AS	S0250323AGK	S0250323ANK	S0250323AS
5/16-18 UNC	S0312182AGK	S0312182ANK	S0312182AS	S0312183AGK	S0312183ANK	S0312183AS
5/16-24 UNF	S0312242AGK	S0312242ANK	S0312242AS	S0312243AGK	S0312243ANK	S0312243AS
5/16-32 UNEF	S0312322AGK	S0312322ANK	S0312322AS	S0312323AGK	S0312323ANK	S0312323AS
3/8-16 UNC	S0375162AGK	S0375162ANK	S0375162AS	S0375163AGK	S0375163ANK	S0375163AS
3/8-24 UNF	S0375242AGK	S0375242ANK	S0375242AS	S0375243AGK	S0375243ANK	S0375243AS

Continued on next page.

UNIFIED TRUNCATED THREAD SETTING PLUG GAGES X TOLERANCE (CONT.)

Nominal Size	Class 2A			Class 3A		
	GO Member	NOT GO Member	DE in Handle	GO Member	NOT GO Member	DE in Handle
3/8-32 UNEF	S0375322AGK	S0375322ANK	S0375322AS	S0375323AGK	S0375323ANK	S0375323AS
7/16-14 UNC	S0437142AGK	S0437142ANK	S0437142AS	S0437143AGK	S0437143ANK	S0437143AS
7/16-20 UNF	S0437202AGK	S0437202ANK	S0437202AS	S0437203AGK	S0437203ANK	S0437203AS
7/16-28 UNEF	S0437282AGK	S0437282ANK	S0437282AS	S0437283AGK	S0437283ANK	S0437283AS
1/2-13 UNC	S0500132AGK	S0500132ANK	S0500132AS	S0500133AGK	S0500133ANK	S0500133AS
1/2-20 UNF	S0500202AGK	S0500202ANK	S0500202AS	S0500203AGK	S0500203ANK	S0500203AS
1/2-28 UNEF	S0500282AGK	S0500282ANK	S0500282AS	S0500283AGK	S0500283ANK	S0500283AS
9/16-12 UNC	S0562122AGK	S0562122ANK	S0562122AS	S0562123AGK	S0562123ANK	S0562123AS
9/16-18 UNF	S0562182AGK	S0562182ANK	S0562182AS	S0562183AGK	S0562183ANK	S0562183AS
9/16-24 UNEF	S0562242AGK	S0562242ANK	S0562242AS	S0562243AGK	S0562243ANK	S0562243AS
5/8-11 UNC	S0625112AGK	S0625112ANK	S0625112AS	S0625113AGK	S0625113ANK	S0625113AS
5/8-18 UNF	S0625182AGK	S0625182ANK	S0625182AS	S0625183AGK	S0625183ANK	S0625183AS
5/8-24 UNEF	S0625242AGK	S0625242ANK	S0625242AS	S0625243AGK	S0625243ANK	S0625243AS
11/16-24 UNEF	S0687242AGK	S0687242ANK	S0687242AS	S0687243AGK	S0687243ANK	S0687243AS
3/4-10 UNC	S0750102AGK	S0750102ANK	S0750102AS	S0750103AGK	S0750103ANK	S0750103AS
3/4-16 UNF	S0750162AGK	S0750162ANK	S0750162AS	S0750163AGK	S0750163ANK	S0750163AS
3/4-20 UNEF	S0750202AGK	S0750202ANK	S0750202AS	S0750203AGK	S0750203ANK	S0750203AS
13/16-20 UNEF	S0812202AGK	S0812202ANK	S0812202AS	S0812203AGK	S0812203ANK	S0812203AS
7/8-9 UNC	S0875092AGK	S0875092ANK	S0875092AS	S0875093AGK	S0875093ANK	S0875093AS
7/8-14 UNF	S0875142AGK	S0875142ANK	S0875142AS	S0875143AGK	S0875143ANK	S0875143AS
7/8-20 UNEF	S0875202AGK	S0875202ANK	S0875202AS	S0875203AGK	S0875203ANK	S0875203AS
15/16-20 UNEF	S0937202AGK	S0937202ANK	S0937202AS	S0937203AGK	S0937203ANK	S0937203AS
1-8 UNC	S1000082AGK	S1000082ANK	S1000082AS	S1000083AGK	S1000083ANK	S1000083AS
1-12 UNF	S1000122AGK	S1000122ANK	S1000122AS	S1000123AGK	S1000123ANK	S1000123AS
1-14 UNS	S1000142AGK	S1000142ANK	S1000142AS	S1000143AGK	S1000143ANK	S1000143AS
1-20 UNEF	S1000202AGK	S1000202ANK	S1000202AS	S1000203AGK	S1000203ANK	S1000203AS
1 1/16-12 UNF	S1062122AGK	S1062122ANK	S1062122AS	S1062123AGK	S1062123ANK	S1062123AS
1 1/16-18 UNEF	S1062182AGK	S1062182ANK	S1062182AS	S1062183AGK	S1062183ANK	S1062183AS
1 1/8-7 UNC	S1125072AGK	S1125072ANK	S1125072AS	S1125073AGK	S1125073ANK	S1125073AS
1 1/8-12 UNF	S1125122AGK	S1125122ANK	S1125122AS	S1125123AGK	S1125123ANK	S1125123AS
1 1/8-18 UNEF	S1125182AGK	S1125182ANK	S1125182AS	S1125183AGK	S1125183ANK	S1125183AS
1 3/16-12 UNF	S1187122AGK	S1187122ANK	S1187122AS	S1187123AGK	S1187123ANK	S1187123AS
1 3/16-18 UNEF	S1187182AGK	S1187182ANK	S1187182AS	S1187183AGK	S1187183ANK	S1187183AS
1 1/4-7 UNC	S1250072AGK	S1250072ANK	S1250072AS	S1250073AGK	S1250073ANK	S1250073AS
1 1/4-12 UNF	S1250122AGK	S1250122ANK	S1250122AS	S1250123AGK	S1250123ANK	S1250123AS
1 1/4-18 UNEF	S1250182AGK	S1250182ANK	S1250182AS	S1250183AGK	S1250183ANK	S1250183AS
1 5/16-12 UNF	S1312122AGK	S1312122ANK	S1312122AS	S1312123AGK	S1312123ANK	S1312123AS
1 5/16-18 UNEF	S1312182AGK	S1312182ANK	S1312182AS	S1312183AGK	S1312183ANK	S1312183AS
1 3/8-6 UNC	S1375062AGK	S1375062ANK	S1375062AS	S1375063AGK	S1375063ANK	S1375063AS
1 3/8-12 UNF	S1375122AGK	S1375122ANK	S1375122AS	S1375123AGK	S1375123ANK	S1375123AS
1 3/8-18 UNEF	S1375182AGK	S1375182ANK	S1375182AS	S1375183AGK	S1375183ANK	S1375183AS
1 7/16-12 UNF	S1437122AGK	S1437122ANK	S1437122AS	S1437123AGK	S1437123ANK	S1437123AS
1 7/16-18 UNEF	S1437182AGK	S1437182ANK	S1437182AS	S1437183AGK	S1437183ANK	S1437183AS
1 1/2-6 UNC	S1500062AGK	S1500062ANK	S1500062AS	S1500063AGK	S1500063ANK	S1500063AS
1 1/2-12 UNF	S1500122AGK	S1500122ANK	S1500122AS	S1500123AGK	S1500123ANK	S1500123AS
1 1/2-18 UNEF	S1500182AGK	S1500182ANK	S1500182AS	S1500183AGK	S1500183ANK	S1500183AS

VAN KEUREN THREADED GAGES

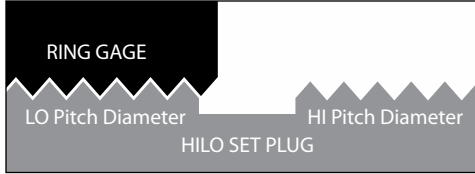
HILO Thread Setting Plug Gages



Van Keuren Go/Not Go HILO Thread Setting Plug Gage in double end handle

Most times, you have to rely on an individual's sense of "good feel", "good fit", or amount of "shake", to set an adjustable ring gage with a truncated setting plug gage. And sometimes the accuracy of human judgment is highly debatable... especially if you're looking at hundreds of rejected parts.

A HILO setting plug gage provides optimum ring gage accuracy, without subjective human judgments for "fit", "feel", or "shake". It only relies on an inspector to turn it into the thread ring, and then helps the inspector make foolproof adjustments. Here's how:



First, the adjustable ring is set so it can be threaded onto the LO pitch diameter. The second or HI pitch diameter portion indicates that the setting is too high if the ring gage can be threaded on to it more than 1½ turns. The setting is correct when the adjustable ring gage can be threaded only onto the LO pitch diameter portion, but not more than 1½ turns on the HI. It's that simple!

HILO Qualities and Applications

Prolongs Ring Gage Life: How many gages has your company scrapped or sent to be reconditioned because the "feel", "fit", or "shake" wasn't right? HILO set plugs can tell you without a doubt when flanks are excessively worn, or too much "bellmouthing" has affected the accuracy of your gage. Plus, since HILO plugs are designed for the full use of the pitch diameter tolerance, you can often discover additional tolerances in thread rings that couldn't be found with conventional set plug gages.

More Than Just a Setting Plug: HILO is the only plug gage available with the HI and LO portions ground and lapped with identical lead and angles. That means you can use a HILO plug gage to perform positive and dependable wear checks on solid ring gages too.

HILO Thread Setting Gages For Standard and Special Threads: HILO master setting plug gages are designed to precisely size and check minimum and maximum tolerances of adjustable and solid type threaded ring gages. They're also ideal for checking flanks and angles for wear, and to determine excessive "bellmouthing". Each gage is engraved to indicate: size, threads per inch, thread type, and minimum pitch diameter limit for quick identification.

For Highly Accurate Adjustable Ring Gage Settings: HILO set plugs take the guesswork out of setting high and low tolerances on adjustable thread ring gages. These unique setting plugs are designed with two different thread pitch diameters. The front portion is the low tolerance limit, and the back portion is the high tolerance limit. By adjusting the ring gage so it will thread onto the front portion without threading more than 1½ turns onto the back portion, a precise setting is achieved.

Worn Flank Checks: The back portion, or high limit end of each HILO gage has the outside diameter of the thread truncated in accordance with ANSI/ASME B1.2, latest edition. It automatically furnishes a check on worn flanks similar to, but more exacting than, standard truncated setting plug gages.

Angle Checks: In addition, HILO setting plugs can also provide a precise angle check on ring gages because of the high limit pitch diameter, and the low outside diameter on the back portion of the plug. Any worn flanks or angles will be indicated when the ring gage fits snugly on the low pitch diameter portion, and enters the high pitch diameter portion more than 1½ turns.

"Bellmouthing" Inspection: The amount of excessive ring gage "bellmouthing" can be determined by the number of turns required for the high pitch diameter portion to enter the ring. If the high portion does not enter the ring, the ring is within tolerance.



Solid Ring Gage Checks: Since the HILO setting plug has the low and high limit portions ground and lapped with identical leads and angles, the low and high limits on solid gages can be easily and accurately checked. The HILO plug design provides a completely positive and dependable wear check, and allows for full utilization of the pitch diameter tolerance inside the ring in accordance with ANSI/ASME B1.2, latest edition.

VAN KEUREN THREADED GAGES

HILO Thread Setting Plug Gages



Van Keuren Go/Not Go HILO Thread Setting Plug Gage in double end handle

Manufacturing Standards

Material: High Speed Steel (Up to 1 1/2" Diameter)
 LO Pitch Diameter Tolerance (Minimum Ring Pitch Diameter Tolerance): $\pm 0.00005''$
 HI Pitch Diameter Tolerance (Maximum Ring Pitch Diameter Tolerance): $+ 0.0001''$
 Lead & Angles: W Tolerance
 Major Diameter Back Portion (HI): Truncated per ANSI/ASME B1.2 (Class X)
 Major Diameter Back Portion (LO): Full Form (Class Y)
 Straightness & Taper: ANSI/ASME B1.2, Latest Edition

UNIFIED HILO THREAD SETTING PLUG GAGES

Nominal Size	2A		3A	
	GO Member	NOT GO Member	GO Member	NOT GO Member
0-80 UNF	HL0060802AGK	HL0060802ANK	HL0060803AGK	HL0060803ANK
1-64 UNC	HL0073642AGK	HL0073642ANK	HL0073643AGK	HL0073643ANK
1-72 UNF	HL0073722AGK	HL0073722ANK	HL0073723AGK	HL0073723ANK
2-56 UNC	HL0086562AGK	HL0086562ANK	HL0086563AGK	HL0086563ANK
2-64 UNF	HL0086642AGK	HL0086642ANK	HL0086643AGK	HL0086643ANK
3-48 UNC	HL0099482AGK	HL0099482ANK	HL0099483AGK	HL0099483ANK
3-56 UNF	HL0099562AGK	HL0099562ANK	HL0099563AGK	HL0099563ANK
4-40 UNC	HL0112402AGK	HL0112402ANK	HL0112403AGK	HL0112403ANK
4-48 UNF	HL0112482AGK	HL0112482ANK	HL0012483AGK	HL0012483ANK
5-40 UNC	HL0125402AGK	HL0125402ANK	HL0125403AGK	HL0125403ANK
5-44 UNF	HL0125442AGK	HL0125442ANK	HL0125443AGK	HL0125443ANK
6-32 UNC	HL0138322AGK	HL0138322ANK	HL0138323AGK	HL0138323ANK
6-40 UNF	HL0138402AGK	HL0138402ANK	HL0138403AGK	HL0138403ANK
8-32 UNC	HL0164322AGK	HL0164322ANK	HL0164323AGK	HL0164323ANK
8-36 UNF	HL0164362AGK	HL0164362ANK	HL0164363AGK	HL0164363ANK
10-24 UNC	HL0190242AGK	HL0190242ANK	HL0190243AGK	HL0190243ANK
10-32 UNF	HL0190322AGK	HL0190322ANK	HL0190323AGK	HL0190323ANK
12-24 UNC	HL0216242AGK	HL0216242ANK	HL0216243AGK	HL0216243ANK
12-28 UNF	HL0216282AGK	HL0216282ANK	HL0216283AGK	HL0216283ANK
12-32 UNEF	HL0216322AGK	HL0216322ANK	HL0216323AGK	HL0216323ANK
1/4-20 UNC	HL0250202AGK	HL0250202ANK	HL0250203AGK	HL0250203ANK
1/4-28 UNF	HL0250282AGK	HL0250282ANK	HL0250283AGK	HL0250283ANK
1/4-32 UNEF	HL0250322AGK	HL0250322ANK	HL0250323AGK	HL0250323ANK
5/16-18 UNC	HL0312182AGK	HL0312182ANK	HL0312183AGK	HL0312183ANK
5/16-24 UNF	HL0312242AGK	HL0312242ANK	HL0312243AGK	HL0312243ANK
5/16-32 UNEF	HL0312322AGK	HL0312322ANK	HL0312323AGK	HL0312323ANK
3/8-16 UNC	HL0375162AGK	HL0375162ANK	HL0375163AGK	HL0375163ANK
3/8-24 UNF	HL0375242AGK	HL0375242ANK	HL0375243AGK	HL0375243ANK
3/8-32 UNEF	HL0375322AGK	HL0375322ANK	HL0375323AGK	HL0375323ANK
7/16-14 UNC	HL0437142AGK	HL0437142ANK	HL0437143AGK	HL0437143ANK

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UNIFIED HILO THREAD SETTING PLUG GAGES (CONTINUED)

Nominal Size	2A		3A	
	GO Member	NOT GO Member	GO Member	NOT GO Member
7/16-20 UNF	HL0437202AGK	HL0437202ANK	HL0437203AGK	HL0437203ANK
7/16-28 UNEF	HL0437282AGK	HL0437282ANK	HL0437283AGK	HL0437283ANK
1/2-13 UNC	HL0500132AGK	HL0500132ANK	HL0500133AGK	HL0500133ANK
1/2-20 UNF	HL0500202AGK	HL0500202ANK	HL0500203AGK	HL0500203ANK
1/2-28 UNEF	HL0500282AGK	HL0500282ANK	HL0500283AGK	HL0500283ANK
9/16-12 UNC	HL0562122AGK	HL0562122ANK	HL0562123AGK	HL0562123ANK
9/16-18 UNF	HL0562182AGK	HL0562182ANK	HL0562183AGK	HL0562183ANK
9/16-24 UNEF	HL0562242AGK	HL0562242ANK	HL0562243AGK	HL0562243ANK
5/8-11 UNC	HL0625112AGK	HL0625112ANK	HL0625113AGK	HL0625113ANK
5/8-18 UNF	HL0625182AGK	HL0625182ANK	HL0625183AGK	HL0625183ANK
5/8-24 UNEF	HL0625242AGK	HL0625242ANK	HL0625243AGK	HL0625243ANK
11/16-24 UNEF	HL0687242AGK	HL0687242ANK	HL0687243AGK	HL0687243ANK
3/4-10 UNC	HL0750102AGK	HL0750102ANK	HL0750103AGK	HL0750103ANK
3/4-16 UNF	HL0750162AGK	HL0750162ANK	HL0750163AGK	HL0750163ANK
3/4-20 UNEF	HL0750202AGK	HL0750202ANK	HL0750203AGK	HL0750203ANK
13/16-20 UNEF	HL0812202AGK	HL0812202ANK	HL0812203AGK	HL0812203ANK
7/8-9 UNC	HL0875092AGK	HL0875092ANK	HL0875093AGK	HL0875093ANK
7/8-14 UNF	HL0875142AGK	HL0875142ANK	HL0875143AGK	HL0875143ANK
7/8-20 UNEF	HL0875202AGK	HL0875202ANK	HL0875203AGK	HL0875203ANK
15/16-20 UNEF	HL0937202AGK	HL0937202ANK	HL0937203AGK	HL0937203ANK
1-8 UNC	HL1000082AGK	HL1000082ANK	HL1000083AGK	HL1000083ANK
1-12 UNF	HL1000122AGK	HL1000122ANK	HL1000123AGK	HL1000123ANK
1-14 UNS	HL1000142AGK	HL1000142ANK	HL1000143AGK	HL1000143ANK
1-20 UNEF	HL1000202AGK	HL1000202ANK	HL1000203AGK	HL1000203ANK
1 1/16-12 UNF	HL1062122AGK	HL1062122ANK	HL1062123AGK	HL1062123ANK
1 1/16-18 UNEF	HL1062182AGK	HL1062182ANK	HL1062183AGK	HL1062183ANK
1 1/8-7 UNC	HL1125072AGK	HL1125072ANK	HL1125073AGK	HL1125073ANK
1 1/8-12 UNF	HL1125122AGK	HL1125122ANK	HL1125123AGK	HL1125123ANK
1 1/8-18 UNEF	HL1125182AGK	HL1125182ANK	HL1125183AGK	HL1125183ANK
1 3/16-12 UNF	HL1187122AGK	HL1187122ANK	HL1187123AGK	HL1187123ANK
1 3/16-18 UNEF	HL1187182AGK	HL1187182ANK	HL1187183AGK	HL1187183ANK
1 1/4-7 UNC	HL1250072AGK	HL1250072ANK	HL1250073AGK	HL1250073ANK
1 1/4-12 UNF	HL1250122AGK	HL1250122ANK	HL1250123AGK	HL1250123ANK
1 1/4-18 UNEF	HL1250182AGK	HL1250182ANK	HL1250183AGK	HL1250183ANK
1 5/16-12 UNF	HL1312122AGK	HL1312122ANK	HL1312123AGK	HL1312123ANK
1 5/16-18 UNEF	HL1312182AGK	HL1312182ANK	HL1312183AGK	HL1312183ANK
1 3/8-6 UNC	HL1375062AGK	HL1375062ANK	HL1375063AGK	HL1375063ANK
1 3/8-12 UNF	HL1375122AGK	HL1375122ANK	HL1375123AGK	HL1375123ANK
1 3/8-18 UNEF	HL1375182AGK	HL1375182ANK	HL1375183AGK	HL1375183ANK
1 7/16-12 UNF	HL1437122AGK	HL1437122ANK	HL1437123AGK	HL1437123ANK
1 7/16-18 UNEF	HL1437182AGK	HL1437182ANK	HL1437183AGK	HL1437183ANK
1 1/2-6 UNC	HL1500062AGK	HL1500062ANK	HL1500063AGK	HL1500063ANK
1 1/2-12 UNF	HL1500122AGK	HL1500122ANK	HL1500123AGK	HL1500123ANK
1 1/2-18 UNEF	HL1500182AGK	HL1500182ANK	HL1500183AGK	HL1500183ANK

VAN KEUREN THREADED GAGES

Adjustable Metric Thread Ring Gages



Van Keuren adjustable
Go ring gage

Van Keuren adjustable
Not Go gage

Adjustable Thread Ring Gages are best if purchased with, and mated to a setting plug gage at the time of order. Not Go rings are furnished with identifying groove around the outside diameter of the gage. Please specify nominal diameter, pitch and class of fit required. Van Keuren Metric Thread Ring Gages are stocked in 6g class of fit.

Van Keuren Metric Thread Ring Gages are available in J thread, chrome, left hand, special sizes and special pitch diameters — please call 1-800-825-4272 and we will gladly prepare a quote.

METRIC THREAD RING GAGES X TOLERANCE

Size	Pitch	GO Member	NOT GO Member	GO / NOT GO DE RINGS	Holder
M1.6	0.35	R0160356GGK	R0160356GNK	R0160356GS	1
M1.8	0.35	R0180356GGK	R0180356GNK	R0180356GS	1
M2	0.40	R0200406GGK	R0200406GNK	R0200406GS	1
M2.2	0.45	R0220456GGK	R0220456GNK	R0220456GS	1
M2.5	0.45	R0250456GGK	R0250456GNK	R0250456GS	1
M3	0.50	R0300506GGK	R0300506GNK	R0300506GS	1
M3.5	0.60	R0350606GGK	R0350606GNK	R0350606GS	1
M4	0.70	R0400706GGK	R0400706GNK	R0400706GS	1
M4.5	0.75	R0450756GGK	R0450756GNK	R0450756GS	1
M5	0.80	R0500806GGK	R0500806GNK	R0500806GS	1
M5.5	0.75	R0550756GGK	R0550756GNK	R0550756GS	1
M6	1.00	R0601006GGK	R0601006GNK	R0601006GS	1
M7	1.00	R0701006GGK	R0701006GNK	R0701006GS	2
M8	1.25	R0801256GGK	R0801256GNK	R0801256GS	2
M9	1.25	R0901256GGK	R0901256GNK	R0901256GS	3
M10	0.75	R1000756GGK	R1000756GNK	R1000756GS	3
M10	1.25	R1001256GGK	R1001256GNK	R1001256GS	3
M10	1.50	R1001506GGK	R1001506GNK	R1001506GS	3
M11	1.50	R1101506GGK	R1101506GNK	R1101506GS	3
M12	1.25	R1201256GGK	R1201256GNK	R1201256GS	3
M12	1.50	R1201506GGK	R1201506GNK	R1201506GS	3
M12	1.75	R1201756GGK	R1201756GNK	R1201756GS	3
M14	1.50	R1401506GGK	R1401506GNK	R1401506GS	4
M14	2.00	R1402006GGK	R1402006GNK	R1402006GS	4
M15	1.00	R1501006GGK	R1501006GNK	R1501006GS	4
M15	1.50	R1501506GGK	R1501506GNK	R1501506GS	4
M16	1.50	R1601506GGK	R1601506GNK	R1601506GS	4
M16	2.00	R1602006GGK	R1602006GNK	R1602006GS	4
M17	1.00	R1701006GGK	R1701006GNK	R1701006GS	4
M17	1.50	R1701506GGK	S1701506GNK	R1701506GS	4
M18	1.50	R1801506GGK	R1801506GNK	R1801506GS	4
M18	2.50	R1802506GGK	R1802506GNK	R1802506GS	4

VAN KEUREN THREADED GAGES

METRIC THREAD RING GAGES X TOLERANCE (CONTINUED)

Size	Pitch	GO Member	NOT GO Member	GO / NOT GO DE Rings	Holder
M20	1.00	R2001006GGK	R2001006GNK	R2001006GS	5
M20	1.50	R2001506GGK	R2001506GNK	R2001506GS	5
M20	2.50	R2002506GGK	R2002506GNK	R2002506GS	5
M22	1.50	R2201506GGK	R2201506GNK	R2201506GS	5
M22	2.50	R2202506GGK	R2202506GNK	R2202506GS	5
M24	2.00	R2402006GGK	R2402006GNK	R2402006GS	5
M24	3.00	R2403006GGK	R2403006GNK	R2403006GS	5
M25	1.50	R2501506GGK	R2501506GNK	R2501506GS	5
M25	2.00	R2502006GGK	R2502006GNK	R2502006GS	5
M26	1.00	R2601006GGK	R2601006GNK	R2601006GS	5
M26	1.50	R2601506GGK	R2601506GNK	R2601506GS	5
M27	2.00	R2702006GGK	R2702006GNK	R2702006GS	5
M27	3.00	R2703006GGK	R2703006GNK	R2703006GS	5
M28	1.00	R2801006GGK	R2801006GNK	R2801006GS	5
M28	1.50	R2801506GGK	R2801506GNK	R2801506GS	5
M28	2.00	R2802006GGK	R2802006GNK	R2802006GS	5
M30	1.50	R3001506GGK	R3001506GNK	R3001506GS	6
M30	2.00	R3002006GGK	R3002006GNK	R3002006GS	6
M30	3.50	R3003506GGK	R3003506GNK	R3003506GS	6
M32	1.50	R3201506GGK	R3201506GNK	R3201506GS	6
M32	2.00	R3202006GGK	R3202006GNK	R3202006GS	6
M33	2.00	R3302006GGK	R3302006GNK	R3302006GS	6
M33	3.50	R3303506GGK	R3303506GNK	R3303506GS	6
M35	1.50	R3501506GGK	R3501506GNK	R3501506GS	6
M36	2.00	R3602006GGK	R3602006GNK	R3602006GS	6
M36	3.00	R3603006GGK	R3603006GNK	R3603006GS	6
M36	4.00	R3604006GGK	R3604006GNK	R3604006GS	6
M38	1.50	R3801506GGK	R3801506GNK	R3801506GS	6
M39	2.00	R3902006GGK	R3902006GNK	R3902006GS	6
M39	3.00	R3903006GGK	R3903006GNK	R3903006GS	6
M39	4.00	R3904006GGK	R3904006GNK	R3904006GS	6

Thread Ring Gage Holders

Optional holders are available in these sizes:

Holder 1 (Size 0" - 12", 1.6mm - 5mm)

Holder 2 (Size 1/4" - 5/16", 6mm - 8mm)

Holder 3 (Size 3/8" - 1/2", 10mm - 12mm)

Holder 4 (Size 9/16" - 3/4", 14mm - 20mm)

Holder 5 (Size 7/8" - 1-1/8", 24mm)

Holder 6 (Size 1-1/4" - 1-1/2", 31.75mm - 38.10mm)



VAN KEUREN THREADED GAGES

Metric Thread Setting Plug Gages



Van Keuren Metric Go / Not Go Hilo Thread Setting Plug Gages in double end handle

Van Keuren offers both HILO and Truncated Setting Plug Gages that are used for setting and evaluating adjustable thread ring gages. Metric Setting Plug Gages are stocked in 6g class of fit.

Van Keuren Metric Truncated Thread Setting Plug Gages are available in class W tolerance, left hand, special sizes and special pitch diameters — please call 1-800-825-4272 and we will gladly prepare a quote.

Please specify nominal diameter, threads per inch and Go or Not Go member (or both in double end handle). Handles are not included with members unless specified. We will specially mark your gage handle with your tool number if provided.



Van Keuren Metric Truncated Set Plug in a double end handle

METRIC THREAD SETTING PLUG GAGES

Size	Pitch	Truncated 6g X Tolerance				Hilo 6g		
		GO Member	NOT GO Member	Double End in Handle	Handle	GO Member	NOT GO Member	Handle
M1.6	0.35	S0160356GGK	S0160356GNK	S0160356GS	000	HL0160356GGK	HL0160356GNK	000
M1.8	0.35	S0180356GGK	S0180356GNK	S0180356GS	000	HL0180356GGK	HL0180356GNK	000
M2	0.40	S0200406GGK	S0200406GNK	S0200406GS	000	HL0200406GGK	HL0200406GNK	000
M2.2	0.45	S0220456GGK	S0220456GNK	S0220456GS	000	HL0220456GGK	HL0220456GNK	000
M2.5	0.45	S0250456GGK	S0250456GNK	S0250456GS	00	HL0250456GGK	HL0250456GNK	00
M3	0.50	S0300506GGK	S0300506GNK	S0300506GS	00	HL0300506GGK	HL0300506GNK	00
M3.5	0.60	S0350606GGK	S0350606GNK	S0350606GS	00	HL0350606GGK	HL0350606GNK	00
M4	0.70	S0400706GGK	S0400706GNK	S0400706GS	0	HL0400706GGK	HL0400706GNK	0
M4.5	0.75	S0450756GGK	S0450756GNK	S0450756GS	0	HL0450756GGK	HL0450756GNK	0
M5	0.80	S0500806GGK	S0500806GNK	S0500806GS	0	HL0500806GGK	HL0500806GNK	0
M5.5	0.75	S0550756GGK	S0550756GNK	S0550756GS	0	available on request *		
M6	1.00	S0601006GGK	S0601006GNK	S0601006GS	1	HL0601006GGK	HL0601006GNK	1
M7	1.00	S0701006GGK	S0701006GNK	S0701006GS	1	HL0701006GGK	HL0701006GNK	1
M8	1.25	S0801256GGK	S0801256GNK	S0801256GS	1	HL0801256GGK	HL0801256GNK	1
M9	1.25	S0901256GGK	S0901256GNK	S0901256GS	2	available on request *		
M10	0.75	S1000756GGK	S1000756GNK	S1000756GS	2	available on request *		
M10	1.25	S1001256GGK	S1001256GNK	S1001256GS	2	HL1001256GGK	HL1001256GNK	2
M10	1.50	S1001506GGK	S1001506GNK	S1001506GS	2	HL1001506GGK	HL1001506GNK	2
M11	1.50	S1101506GGK	S1101506GNK	S1101506GS	2	available on request *		
M12	1.25	S1201256GGK	S1201256GNK	S1201256GS	2	HL1201256GGK	HL1201256GNK	2
M12	1.50	S1201506GGK	S1201506GNK	S1201506GS	2	HL1201506GGK	HL1201506GNK	2
M12	1.75	S1201756GGK	S1201756GNK	S1201756GS	2	HL1201756GGK	HL1201756GNK	2
M14	1.50	S1401506GGK	S1401506GNK	S1401506GS	3	HL1401506GGK	HL1401506GNK	3
M14	2.00	S1402006GGK	S1402006GNK	S1402006GS	3	HL1402006GGK	HL1402006GNK	3
M15	1.00	S1501006GGK	S1501006GNK	S1501006GS	3	available on request *		
M15	1.50	S1501506GGK	S1501506GNK	S1501506GS	3	available on request *		
M16	1.50	S1601506GGK	S1601506GNK	S1601506GS	3	HL1601506GGK	HL1601506GNK	3

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VAN KEUREN THREADED GAGES

METRIC THREAD SETTING PLUG GAGES (CONTINUED)

Size	Pitch	Truncated 6g X Tolerance				Hilo 6g		
		GO Member	NOT GO Member	Double End Setting Plug	Handle	GO Member	NOT GO Member	Handle
M16	2.00	S1602006GGK	S1602006GNK	S1602006GS	3	HL1602006GGK	HL1602006GNK	3
M17	1.00	S1701006GGK	S1701006GNK	S1701006GS	3	available on request *		
M17	1.50	S1701506GGK	S1701506GNK	S1701506GS	3	available on request *		
M18	1.50	S1801506GGK	S1801506GNK	S1801506GS	3	HL1801506GGK	HL1801506GNK	3
M18	2.50	S1802506GGK	S1802506GNK	S1802506GS	3	HL1802506GGK	HL1802506GNK	3
M20	1.00	S2001006GGK	S2001006GNK	S2001006GS	4	HL2001006GGK	HL2001006GNK	4
M20	1.50	S2001506GGK	S2001506GNK	S2001506GS	4	HL2001506GGK	HL2001506GNK	4
M20	2.50	S2002506GGK	S2002506GNK	S2002506GS	4	HL2002506GGK	HL2002506GNK	4
M22	1.50	S2201506GGK	S2201506GNK	S2201506GS	4	HL2201506GGK	HL2201506GNK	4
M22	2.50	S2202506GGK	S2202506GNK	S2202506GS	4	HL2202506GGK	HL2202506GNK	4
M24	2.00	S2402006GGK	S2402006GNK	S2402006GS	4	HL2402006GGK	HL2402006GNK	4
M24	3.00	S2403006GGK	S2403006GNK	S2403006GS	4	HL2403006GGK	HL2403006GNK	4
M25	1.50	S2501506GGK	S2501506GNK	S2501506GS	4	available on request *		
M25	2.00	S2502006GGK	S2502006GNK	S2502006GS	4	available on request *		
M26	1.00	S2601006GGK	S2601006GNK	S2601006GS	4	available on request *		
M26	1.50	S2601506GGK	S2601506GNK	S2601506GS	4	available on request *		
M27	2.00	S2702006GGK	S2702006GNK	S2702006GS	4	HL2702006GGK	HL2702006GNK	4
M27	3.00	S2703006GGK	S2703006GNK	S2703006GS	4	HL2703006GGK	HL2703006GNK	4
M28	1.00	S2801006GGK	S2801006GNK	S2801006GS	4	available on request *		
M28	1.50	S2801506GGK	S2801506GNK	S2801506GS	4	available on request *		
M28	2.00	S2802006GGK	S2802006GNK	S2802006GS	4	available on request *		
M30	1.50	S3001506GGK	S3001506GNK	S3001506GS	5	available on request *		
M30	2.00	S3002006GGK	S3002006GNK	S3002006GS	5	HL3002006GGK	HL3002006GNK	5
M30	3.50	S3003506GGK	S3003506GNK	S3003506GS	5	HL3003506GGK	HL3003506GNK	5
M32	1.50	S3201506GGK	S3201506GNK	S3201506GS	5	available on request *		
M32	2.00	S3202006GGK	S3202006GNK	S3202006GS	5	available on request *		
M33	2.00	S3302006GGK	S3302006GNK	S3302006GS	5	HL3302006GGK	HL3302006GNK	5
M33	3.50	S3303506GGK	S3303506GNK	S3303506GS	5	HL3303506GGK	HL3303506GNK	5
M35	1.50	S3501506GGK	S3501506GNK	S3501506GS	5	HL3501506GGK	HL3501506GNK	5
M36	2.00	S3602006GGK	S3602006GNK	S3602006GS	5	available on request *		
M36	3.00	S3603006GGK	S3603006GNK	S3603006GS	5	HL3603006GGK	HL3603006GNK	5
M36	4.00	S3604006GGK	S3604006GNK	S3604006GS	5	HL3604006GGK	HL3604006GNK	5
M38	1.50	S3801506GGK	S3801506GNK	S3801506GS	5	available on request *		
*M39	2.00	S3902006GGK	S3902006GNK	S3902006GS	5	available on request *		
*M39	3.00	S3903006GGK	S3903006GNK	S3903006GS	5	HL3903006GGK	HL3903006GNK	5
*M39	4.00	S3904006GGK	S3904006GNK	S3904006GS	5	HL3904006GGK	HL3904006GNK	5

* Quoted as a special made-to-order gage. Please call 1-800-825-4272 and we will gladly prepare a quote.

VAN KEUREN STRAIGHT PIPE GAGES



Van Keuren Go/Not Go N.P.S.M./N.P.S.F. Work Plug Gage in Double End Handle



Go gage

Not Go gage

Van Keuren N.P.S.F./N.P.S.M. Work Ring Gages

Straight Pipe Plug/Ring Gages (N.P.S.F. & N.P.S.M.)

Van Keuren N.P.S.F. and N.P.S.M. Straight Pipe Gages are furnished to thread specifications which are in agreement with the ANSI/ASME dimensions as shown below. Available in plug and ring gages.

N.P.S.F. – National Pipe Straight Fuel and N.P.S.M. – National Straight Mechanical are available in stock and ready to ship to you. NPSC, NSPL, NPSH and many other Pipe Thread Gages are available as well as special sizes — please call 1-800-825-4272 and we will gladly prepare a quote.

Please specify nominal diameter and Go or Not Go member (or both in double end handle for plug gages). Handles are not included with members unless specified. Customer specific tool numbers marked upon request.

N.P.S.F.

Size	Threads per Inch	Pitch Diameter		Work Plug		Handle
		Min.	Max.	GO Member	NOT GO Member	
1/8"	27	0.3692	0.3727	W012527NFGK	W012527NFNK	2
1/4"	18	0.4852	0.4904	W025018NFGK	W025018NFNK	2
3/8"	18	0.6205	0.6257	W037518NFGK	W037518NFNK	3
1/2"	14	0.7700	0.7767	W050014NFGK	W050014NFNK	3
3/4"	14	0.9805	0.9872	W075014NFGK	W075014NFNK	4
1"	11-1/2	1.2284	1.2365	W100099NFGK	W100099NFNK	5

N.P.S.M.

Size	Threads per Inch	Ring (N.P.S.M. 2A)		Set Plug (N.P.S.M. 2A)		Work Plug (N.P.S.M. 2B)	
		Go Member	NOT GO Member	GO Member	NOT GO Member	GO Member	NOT GO Member
1/8"	27	R0125272NMGK	R0125272NMGK	S0125272NMGK	S0125272NMGK	W012527NMGK	W0125272NMGK
1/4"	18	R0250182NMGK	R0250182NMGK	S0250182NMGK	S0250182NMGK	W025018NMGK	W0250182NMGK
3/8"	18	R0375182NMGK	R0375182NMGK	S0375182NMGK	S0375182NMGK	W037518NMGK	W0375182NMGK
1/2"	14	R0500142NMGK	R0500142NMGK	S0500142NMGK	S0500142NMGK	W050014NMGK	W0500142NMGK
3/4"	14	R0750142NMGK	R0750142NMGK	S0750142NMGK	S0750142NMGK	W075014NMGK	W0750142NMGK
1"	11-1/2	R1000992NMGK	R1000992NMGK	S1000992NMGK	S1000992NMGK	W100099NMGK	W1000992NMGK
1-1/4"	11-1/2	R1250992NMGK	R1250992NMGK	S1250992NMGK	S1250992NMGK	W125099NMGK	W1250992NMGK
1-1/2"	11-1/2	R1500992NMGK	R1500992NMGK	S1500992NMGK	S1500992NMGK	W150099NMGK	W1500992NMGK
2"	11-1/2	R2000992NMGK	R2000992NMGK	S2000992NMGK	S2000992NMGK	W200099NMGK	W2000992NMGK
2-1/2"	8	R2500082NMGK	R2500082NMGK	S2500082NMGK	S2500082NMGK	W250008NMGK	W2500082NMGK
3"	8	R3000082NMGK	R3000082NMGK	S3000082NMGK	S3000082NMGK	W300008NMGK	W3000082NMGK

VAN KEUREN TAPER PIPE GAGES

Taper Pipe Plug/Ring Gages (N.P.T.)

Van Keuren N.P.T., A.N.P.T. and N.P.T.F Taper Pipe Gages are furnished to thread specifications which are in agreement with ANSI/ASME standards. Available in plug and ring gages which are available to ship from stock. Larger sizes and special pipe gages are available – please call 1-800-825-4272 and we will gladly prepare a quote.



N.P.T. (National Taper Pipe): To gage Internal N.P.T. taper pipe threads, screw the N.P.T. thread plug firmly into the product – do not force. The thread is within the permissible tolerance when the gaging notch of the plug is not more than one turn plus or minus from being flush with the end of the product. N.P.T. plugs are regularly furnished with the basic step only. Minimum and maximum steps can be added on request. To gage External N.P.T. taper pipe threads, screw the N.P.T. thread ring on to the product as far as it will go without using force. If the face of the small end of the ring is flush with the face of the product the thread is basic. The permissible tolerance is one turn plus or minus from basic.

Please specify nominal diameter. Handles are not included with plug gage members unless specified. Customer specific tool numbers marked upon request.

N.P.T. (L-1)

Size	Threads per Inch	Plug Gage	Ring Gage
1/16"	27	P006227NK	T006227NK
1/8"	27	P012527NK	T012527NK
1/4"	18	P025018NK	T025018NK
3/8"	18	P037518NK	T037518NK
1/2"	14	P050014NK	T050014NK
3/4"	14	P075014NK	T075014NK
1"	11-1/2	P100099NK	T100099NK
1-1/4"	11-1/2	P125099NK	T125099NK
1-1/2"	11-1/2	P150099NK	T150099NK

N.P.T. (L-1) CONTINUED

Size	Threads per Inch	Plug Gage	Ring Gage
2"	11-1/2	P200099NK	T200099NK
2-1/2"	8	P250008NK	T250008NK
3"	8	P300008NK	T300008NK
3-1/2"	8	P350008NK	T350008NK
4"	8	P400008NK	T400008NK
5"	8	P500008NK	T500008NK
6"	8	P600008NK	T600008NK
8"	8	P800008NK	T800008NK

Aeronautical National Pipe Taper Plug and Ring Gages (A.N.P.T.)



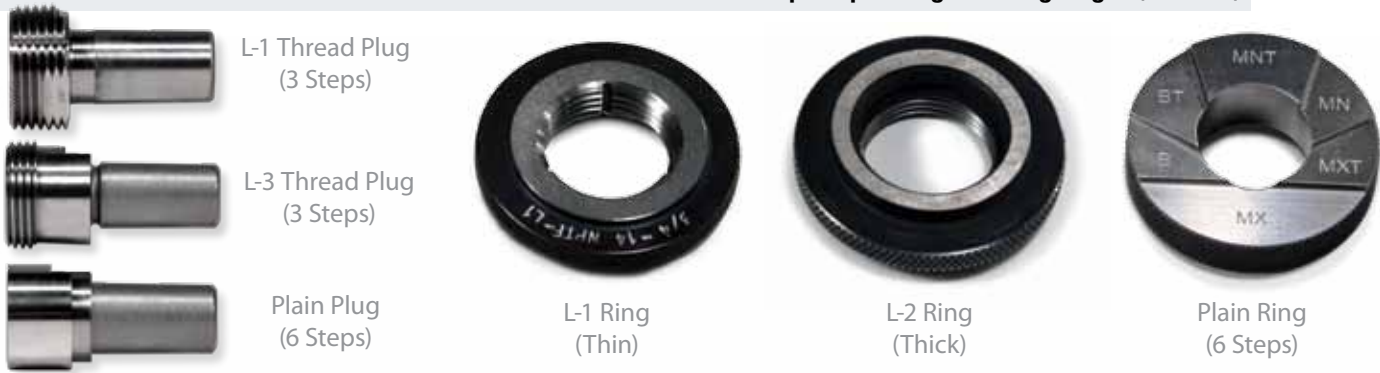
In gaging internal threads, with A.N.P.T. plug gages, there are three gaging members involved: (1) L-1 thread plug gage which checks the thread elements within hand tight engagement; (2) L-3 thread plug which checks the threads that will be engaged when wrench tight; and (3) 6-Step plain plug which is used to check the minor diameter of the female fitting.

A.N.P.T. internal taper pipe threads are basically the same as the N.P.T. pipe threads except that for Army and Navy Aeronautical use they must be more carefully controlled for diameter, taper and thread form. We make our A.N.P.T. gages per SAE AS71051.

See table and more information on next page.

VAN KEUREN TAPER PIPE GAGES

Aeronautical National Pipe Taper Plug and Ring Gages (A.N.P.T.)



A.N.P.T. (AERONAUTICAL NATIONAL PIPE TAPER)

Size	Threads per Inch	Plug Gage			Ring Gage		
		3-Step L-1	3-Step L-3	6-Step Plain	L-1	L-2	6-Step Plain
1/16"	27	P006227AL1K	P006227AL3K	P006227A6K	T006227AL1K	T006227AL2K	T006227A6K
1/8"	27	P012527AL1K	P012527AL3K	P012527A6K	T012527AL1K	T012527AL2K	T012527A6K
1/4"	18	P025018AL1K	P025018AL3K	P025018A6K	T025018AL1K	T025018AL2K	T025018A6K
3/8"	18	P037518AL1K	P037518AL3K	P037518A6K	T037518AL1K	T037518AL2K	T037518A6K
1/2"	14	P050014AL1K	P050014AL3K	P050014A6K	T050014AL1K	T050014AL2K	T050014A6K
3/4"	14	P075014AL1K	P075014AL3K	P075014A6K	T075014AL1K	T075014AL2K	T075014A6K
1"	11-1/2	P100099AL1K	P100099AL3K	P100099A6K	T100099AL1K	T100099AL2K	T100099A6K
1-1/4"	11-1/2	P125099AL1K	P125099AL3K	P125099A6K	T125099AL1K	T125099AL2K	T125099A6K
1-1/2"	11-1/2	P150099AL1K	P150099AL3K	P150099A6K	T150099AL1K	T150099AL2K	T150099A6K
2"	11-1/2	P200099AL1K	P200099AL3K	P200099A6K	T200099AL1K	T200099AL2K	T200099A6K
2-1/2"	8	P250008AL1K	P250008AL3K	P250008A6K	T250008AL1K	T250008AL2K	T250008A6K
3"	8	P300008AL1K	P300008AL3K	P300008A6K	T300008AL1K	T300008AL2K	T300008A6K

To gage Internal A.N.P.T. taper pipe threads, check first with the A.N.P.T. L-1 thread plug gage. This plug differs in dimensions from the N.P.T. plug and has minimum and maximum steps in addition to the basic step. If the face of the product is between the minimum and maximum steps of the plug, the product is in tolerance. The A.N.P.T. L-3 plug gage is used to check the three threads beyond the L-1 depth. As a check on taper the "reading" on the L-3 thread plug must be within one-half turn of the "reading" on the L-1 thread plug gage. The truncation is checked with a six-step plain taper plug gage. This plug has a minimum and maximum truncation steps for each of the three pitch diameter conditions – Minimum, Maximum and Basic. If the L-1 plug shows the product to be basic pitch diameter, the face of the product should lie between the basic minimum and the basic maximum steps of the truncation plug. If the pitch diameter is minimum, the part should fall between the MN and MNT step. If the pitch diameter is maximum, the part should fall between the MX and MXT steps. No appreciable shake or wobble is permitted. Shaky fit indicates taper error.

To gage External A.N.P.T. taper pipe threads, first check with the A.N.P.T. L-1 ring. The small end of the ring must be within one turn plus or minus of being flush with the end of the product thread. Note exactly what this "standoff" is and compare it with the "standoff" obtained with the A.N.P.T. L-2 thread ring. As a check on taper the total tolerance on standoff variation between the L-1 and L-2 rings must not exceed one-half turn. The truncation is checked with a six-step plain taper ring gage. This ring has minimum and maximum truncation steps for each of the three pitch diameter conditions – Minimum, Basic, and Maximum. If the L-1 ring shows the part to be basic pitch diameter the end of the part should fall between the B and BT steps on the six-step plain ring. If the pitch diameter is minimum, the part should fall between the MN and MNT step. If the pitch diameter is maximum, the part should fall between the MX and MXT steps. No appreciable shake or wobble should be permitted. Lead, angles and root truncation should be checked whenever possible, by projection as a check on tool wear.

VAN KEUREN TAPER PIPE GAGES

Taper Pipe Plug/Ring Gages (N.P.T.F.)



N.P.T.F. (National Pipe Taper Dryseal Pressure-Tight Joints)

Dryseal pipe threads are designed to seal pressure tight joints without the use of sealing compounds, therefore a greater variety of gages and/or measuring equipment is used to more adequately check size, taper and thread form. L1 and L3 Plugs supplied with 1 step as standard.

In gaging internal threads with N.P.T.F. plug gages, there are three gaging members involved: (1) L-1 thread plug gage which checks the thread elements within hand tight engagement; (2) L-3 thread plug which checks the threads that will be engaged when wrench tight; and (3) 6-Step plain plug which is used to check the minor diameter of the female fitting.

N.P.T.F. Internal taper pipe threads may be gaged in the same manner as the A.N.P.T. threads. Gages are dimensionally different, however, and must not be interchanged. The turns method may be substituted for the "standoff" method to compensate for gage and product chamfers. With the turns method, the number of turns are counted from hand tight engagement to complete release, and the gaging steps are completely disregarded. A tolerance of plus or minus one turn is permitted from the basic number of turns specified. As a check on taper, the difference in turns between the L-1 and L-3 plugs shall be within one-half turn of the difference between the basic turns engagement of the plug gages. Truncation must be within the proper limits on a six-step dryseal plain taper plug gage.

N.P.T.F. External taper pipe threads are checked in the same manner as A.N.P.T. threads. Gages are dimensionally different, however, and must not be interchanged. The turns method may be substituted for the "standoff" method to compensate for gage and product chamfers. A tolerance of plus or minus one turn is permitted from the basic number of turns specified. As a check on taper, the difference in turns engagement with the L-1 and L-2 dryseal rings shall be within one-half turn of the difference between the basic turns engagement of the ring gages.

In gaging external threads with N.P.T.F. ring gages, there are three gages employed:

- (1) 6-Step plain ring which checks the major diameter of the male fitting
- (2) L-1 (thin) ring which checks the thread elements over the distance of hand tight engagement
- (3) L-2 (thick) ring which checks the thread elements of those threads engaged when wrench tight. A.N.P.T. and N.P.T.F. are not meant to be interchangeable.

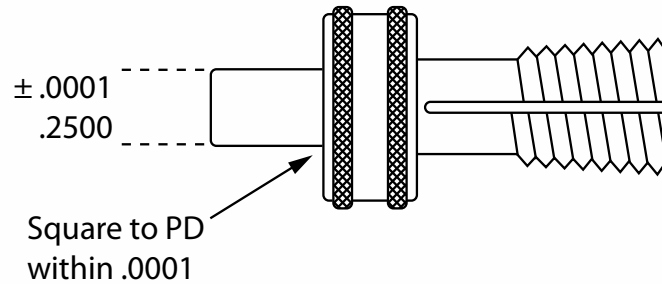
N.P.T.F. (NATIONAL PIPE TAPER DRYSEAL PRESSURE-TIGHT JOINTS)

Size	Threads per inch	Plug Gage					Ring Gage		
		Basic L-1	Basic L-3	3-Step L-1	3-Step L-3	6-Step Plain	L-1	L-2	6-Step Plain
1/16"	27	P006227NL1K	P006227NL3K	P006227NL1-3K	P006227NL3-3K	P006227N6K	T006227NL1K	T006227NL2K	T006227N6K
1/8"	27	P012527NL1K	P012527NL3K	P012527NL1-3K	P012527NL3-3K	P012527N6K	T012527NL1K	T012527NL2K	T012527N6K
1/4"	18	P025018NL1K	P025018NL3K	P025018NL1-3K	P025018NL3-3K	P025018N6K	T025018NL1K	T025018NL2K	T025018N6K
3/8"	18	P037518NL1K	P037518NL3K	P037518NL1-3K	P037518NL3-3K	P037518N6K	T037518NL1K	T037518NL2K	T037518N6K
1/2"	14	P050014NL1K	P050014NL3K	P050014NL1-3K	P050014NL3-3K	P050014N6K	T050014NL1K	T050014NL2K	T050014N6K
3/4"	14	P075014NL1K	P075014NL3K	P075014NL1-3K	P075014NL3-3K	P075014N6K	T075014NL1K	T075014NL2K	T075014N6K
1"	11-1/2	P100099NL1K	P100099NL3K	P100099NL1-3K	P100099NL3-3K	P100099N6K	T100099NL1K	T100099NL2K	T100099N6K
1 1/4"	11-1/2	P125099NL1K	P125099NL3K	P125099NL1-3K	P125099NL3-3K	P125099N6K	T125099NL1K	T125099NL2K	T125099N6K
1 1/2"	11-1/2	P150099NL1K	P150099NL3K	P150099NL1-3K	P150099NL3-3K	P150099N6K	T150099NL1K	T150099NL2K	T150099N6K
2"	11-1/2	P200099NL1K	P200099NL3K	P200099NL1-3K	P200099NL3-3K	P200099N6K	T200099NL1K	T200099NL2K	T200099N6K
2 1/2"	8	P250008NL1K	P250008NL3K	P250008NL1-3K	P250008NL3-3K	P250008N6K	T250008NL1K	T250008NL2K	T250008N6K
3"	8	P300008NL1K	P300008NL3K	P300008NL1-3K	P300008NL3-3K	P300008N6K	T300008NL2K	T300008N6K	T300008N6K

VAN KEUREN FLEXIBLE HOLE LOCATION GAGES

Flexible Hole Location Gages (Unified and Metric)

Van Keuren Flexible Hole Location Gages are slotted at 90° increments to insure positive location on the threads flank regardless of hole size. Flexible Hole Location Gages are used to determine centerline to centerline distances of threaded holes, and for inspection of the location of a threaded hole in a part. Sizes #10 and smaller or M5 and smaller are of solid construction, with front taper to cover the entire product tolerance. Please specify size when ordering.



Van Keuren Flexible Hole Location Gage

FLEXIBLE HOLE LOCATION GAGES

Size (Unified)	EDP No.
0 - 80 UNF	HLOC006080K
1 - 64 UNC	HLOC007364K
1 - 72 UNF	HLOC007372K
2 - 56 UNC	HLOC008656K
2 - 64 UNF	HLOC008664K
3 - 48 UNC	HLOC009948K
3 - 56 UNF	HLOC009956K
4 - 40 UNC	HLOC011240K
4 - 48 UNF	HLOC011248K
5 - 40 UNC	HLOC012540K
5 - 44 UNF	HLOC012544K
6 - 32 UNC	HLOC013832K
6 - 40 UNF	HLOC013840K
8 - 32 UNC	HLOC016432K
8 - 36 UNF	HLOC016436K
10 - 24 UNC	HLOC019024K
10 - 32 UNF	HLOC019032K
12 - 24 UNC	HLOC021624K
12 - 28 UNF	HLOC021628K
1/4 - 20 UNC	HLOC025020K

FLEXIBLE HOLE LOCATION GAGES (CONT.)

Size (Unified)	EDP No.
1/4 - 28 UNF	HLOC025028K
5/16 - 18 UNC	HLOC031218K
5/16 - 24 UNF	HLOC031224K
3/8 - 16 UNC	HLOC037516K
3/8 - 24 UNF	HLOC037524K
7/16 - 14 UNC	HLOC043714K
7/16 - 20 UNF	HLOC043720K
1/2 - 13 UNC	HLOC050013K
1/2 - 20 UNF	HLOC050020K
9/16 - 12 UNC	HLOC056212K
9/16 - 18 UNF	HLOC056218K
5/8 - 11 UNC	HLOC062511K
5/8 - 18 UNF	HLOC062518K
3/4 - 10 UNC	HLOC075010K
3/4 - 16 UNF	HLOC075016K
7/8 - 9 UNC	HLOC087509K
7/8 - 14 UNF	HLOC087514K
1 - 8 UNC	HLOC100008K
1 - 12 UNF	HLOC100012K

METRIC FLEXIBLE HOLE LOCATION GAGES

Size (Metric)	Pitch	EDP No.
M4	0.70	HLOC040700K
M5	0.80	HLOC050800K
M6	1.00	HLOC060100K
M8	1.25	HLOC080125K
M10	1.50	HLOC100100K
M12	1.25	HLOC120125K
M12	1.75	HLOC120175K

VAN KEUREN PLAIN SNAP GAGES



Van Keuren SC Snap Gage

Model SC and SMC Plain Snap Gages

Van Keuren Plain Snap Gages are adjustable limit gages ideal for gaging flat surfaces or parts still on machine centers. Our gages are available as unset or set and sealed in inch or metric capacities. Marking discs are supplied on all Van Keuren Snap Gages and we have holders available which will accommodate all sizes of plain frames.

Please specify capacity required or frame number in inch or metric and indicate if you require unset or set/sealed gages. Long Form Certification traceable to N.I.S.T. is available.

Snap Gage Holders are available for both models. The stand will handle all sizes of plain frames equally well. EDP No. V39320

PLAIN SNAP GAGES MODEL SC

Frame No.	Capacity		EDP No.
	Inches	mm	
1	0" - 1/4"	0 - 6.4 mm	V701092
2	1/4" - 1/2"	6.4 - 12.7 mm	V701093
2A	1/2" - 3/4"	12.7 - 19.1 mm	V701094
3	3/4" - 1"	19.1 - 25.4 mm	V701095
3A	1" - 1-1/4"	25.4 - 31.8 mm	V701096
4	1-1/4" - 1-1/2"	31.8 - 38.1 mm	V701097
4A	1-1/2" - 1-3/4"	38.1 - 44.5 mm	V701098
5	1-3/4" - 2"	44.5 - 50.8 mm	V701099
5A	2" - 2-1/4"	50.8 - 57.2 mm	V701100
6	2-1/4" - 2-1/2"	57.2 - 63.5 mm	V701101
6A	2-1/2" - 2-3/4"	63.5 - 69.9 mm	V701102
7	2-3/4" - 3-1/16"	69.9 - 77.8 mm	V701103
7A	3-1/16" - 3-7/16"	77.8 - 87.3 mm	V701104

PLAIN SNAP GAGES MODEL SC

Frame No.	Capacity		EDP No.
	Inches	mm	
8	3-7/16" - 3-13/16"	87.3 - 96.8 mm	V701105
8A	3-13/16" - 4-3/16"	96.8 - 106.4 mm	V701106
9	4-3/16" - 4-9/16"	106.4 - 115.9 mm	V701107
9A	4-9/16" - 4-15/16"	115.9 - 125.4 mm	V701108
10	4-15/16" - 5-5/16"	125.4 - 134.9 mm	V701109
10A	5-5/16" - 5-11/16"	134.9 - 144.5 mm	V701110
11	5-11/16" - 6-1/8"	144.5 - 155.6 mm	V701111
11A	6-1/8" - 6-5/8"	155.6 - 168.3 mm	V701112
12	6-5/8" - 7-1/8"	168.3 - 181.0 mm	V701113
12A	7-1/8" - 7-5/8"	181.0 - 193.7 mm	V701114
13	7-5/8" - 8-1/8"	193.7 - 206.4 mm	V701115
13A	8-1/8" - 8-5/8"	206.4 - 219.1 mm	V701116

PLAIN SNAP GAGES MODEL SMC

Frame No.	Capacity		EDP No.
	Inches	mm	
00	0" - 0.195"	0 - 5.0 mm	V701136
00A	0.195" - 0.385"	5.0 - 9.8 mm	V701137
0	0.385" - 0.570"	9.8 - 14.5 mm	V701138
0A	0.570" - 0.760"	14.5 - 19.3 mm	V701139



Van Keuren SMC Snap Gage

VAN KEUREN OUTSIDE MICROMETER MASTERS



Surveillance Set Masters

Van Keuren Surveillance Set Masters provide one single reference master to replace multiple pieces of size for more accuracy and control of your calibration. Guarantee the accuracy of your hard to control precision hand tools and reduce gaging errors and scrap costs with our easy-to-use and low-cost Van Keuren Surveillance Masters, which are available in nine easy to use models and are marked with inch or metric measurements. Please indicate inch or metric at time of order.

Our gages are case hardened, stabilized, ground and lapped for long life and consistent accuracy and are available with Long Form Certification traceable to N.I.S.T.. Van Keuren Surveillance Master gage steps will expose out of parallel anvils on micrometers and are convenient for tool crib surveillance of micrometers.



Micrometer Set Masters – also known as “Mikemasters”

“Mikemaster” Surveillance Kit for 1-inch micrometers is designed and packaged for the shop using a majority of 1-inch micrometers. Our gage has nine different sized steps, each one accurate to ± 0.0001 ". Steps will explore out-of-parallel anvils in 45° increments and determine any other wear in the micrometer. Rugged, foam-lined protective metal case included. Kit is serial numbered and chrome plated to help prevent rust and corrosion and prolong wear life. Kit is marked with inch or metric measurements. Please indicate inch or metric at time of order. EDP number V701266.



“Mikemaster” Surveillance Kit for 1, 2 and 3-inch micrometers is compact and portable, yet contains 27 masters accurate to ± 0.0001 " for on-the-spot surveillance of 1, 2 and 3-inch micrometers. Steps are in decimals instead of fractions. Van Keuren Mikemaster will survey out-of-parallel anvils in 45° increments and determine any other wear in the micrometer. Rugged, foam-lined protective metal case included. Kit is serial numbered and chrome plated to help prevent rust and corrosion and prolong wear life. Please indicate inch or metric at time of order. EDP number V701271.

VAN KEUREN OUTSIDE MICROMETER MASTERS

Surveillance Set Masters (Continued)



Mikemaster M-1 for 1-inch to 6-inch range has six masters which are hardened, stabilized, ground and lapped for long life and consistent accuracy. Each master is calibrated, marked and accurate to ± 0.0001 ". Range permits checking micrometers from 1-inch through 6-inches and each step is 1-inch. Van Keuren M-1 ships with heavy gage polyethylene cover for protection. Please indicate inch or metric at time of order.



Mikemaster M-1/2 for 1-inch to 6-inch range will keep your 6-inch Micrometers in a surveillance program and eliminates the need for expensive gage blocks. Gives your operator actual "feel". Steps are from 1/2-inch through 6-inches in 1/2-inch increments. Chrome plated to help prevent rust and corrosion and prolong gage wear life, Van Keuren M-1/2 is hardened, stabilized, ground and lapped for longer life and accuracy and ships with a heavy gage polyethylene cover for protection. Please indicate inch or metric at time of order.



Van Keuren Mikemaster M-12A for 1-inch to 12-inch is a convenient size and weight for easy carrying to special job locations. Our gage has 12 steps calibrated in 1-inch increments and is accurate to ± 0.0001 " and can be used for checking and setting both solid and mandrel-type outside micrometers. Masters are ground and lapped between centers so ends are a true radius of the size represented. Van Keuren Mikemaster M-12A can be custom built in larger or smaller sizes and the bars are available separately – please call 1-800-825-4272 and we will gladly prepare a quote. Ships with a heavy gage polyethylene cover for protection. Please indicate inch or metric at time of order.

SURVEILLANCE MASTERS

Range		EDP No.
Inches	mm	Inches/Metric
0" - 1"	0 - 25.40 mm	V701266
0" - 3"	0 - 76.20 mm	V701271
1" - 6"	25.40 - 152.40 mm	V701283
1/2" - 6"	12.70 - 152.40 mm	V701295
1" - 12"	25.40 - 304.80 mm	V701324

VAN KEUREN OUTSIDE MICROMETER MASTERS

Vernier Caliper Master

Van Keuren Vernier Caliper Masters accurately check outside jaws, inside jaws and parallax of jaws on your Vernier calipers. Our gages are hardened, stabilized, ground and lapped for long wear life and gaging accuracy and are ideal for detecting worn spots in Vernier Caliper Blades. Long Form N.I.S.T. Traceable Certs are available. Both models are marked with inch or metric measurements. Please indicate inch or metric at time of order.



Van Keuren Vernier Caliper Master

Vernier Caliper Masters – also known as “Kalmasters”

Van Keuren Kalmaster K-1 is a convenient way to place your 6-inch Vernier calipers in a surveillance program. Our K-1 has 12 settings for checking inside and outside jaws, jaw frames, rack lead error and the anvils over the entire 6-inch range. All calibrations are accurate to ± 0.0001 ". Durable wood storage case included.

K-1 Range: 1" - 6" (25.40 mm - 152.40 mm)

EDP No. V701277

Van Keuren Kalmaster K-2 includes the same features as our K-1 but has 24 settings for checking over a 12-inch range. 0 to 6" range is accurate to ± 0.0001 " and 7" to 12" range is accurate to ± 0.0002 ". Durable wood storage case included.

K-2 Range: 1" - 12" (25.40 mm - 304.80 mm)

EDP No. V701280

Depth Micrometer Masters



Van Keuren Model D-1 Micrometer Master

Van Keuren Depth Micrometer Masters are precision designed and manufactured with the ultimate in close tolerance to help you handle your daily gaging needs with confidence. Our gages are hardened, stabilized, ground and lapped for long wear life and gaging accuracy and are the ideal for convenient tool crib surveillance for depth micrometers. Long Form N.I.S.T. Traceable Certs are available.

Depth Micrometer Masters – also known as “Mikemasters”

Van Keuren model D-1 is a 6-inch depth gage master which offers convenient tool crib surveillance of depth gages. Our gage has six step depths for quick and easy checking of the accuracy of dial depth gages and depth micrometers and proper seating of the rods. Decimal steps are accurate to ± 0.0001 ". Please indicate inch or metric at time of order.

D-1 Range: $\frac{1}{2}$ " - $5\frac{1}{2}$ " (12.70 mm - 139.70 mm)

EDP number 701346.



Van Keuren Model D-2 Micrometer Master

Van Keuren model D-2 is a 12-inch depth gage master which checks depth gages longer than the conventional 6-inch quickly and accurately. Range .500 to 11.500" in 1-inch increments. The $\frac{1}{2}$ " to $5\frac{1}{2}$ " steps are accurate to ± 0.0001 " and the steps from $6\frac{1}{2}$ " to $11\frac{1}{2}$ " are accurate to ± 0.0003 ". Please indicate inch or metric at time of order.

D-2 Range: $\frac{1}{2}$ " - $11\frac{1}{2}$ " (12.70 mm - 292.10 mm)

EDP number 701350.

UNIFIED THREAD PLUG P.D. CHART

UNIFIED THREAD GAGES

Thread Plugs			
Nominal Size	GO Basic	NOTGO 2B	NOTGO 3B
0-80 UNF	.0519	.0542	.0536
1-64 UNC	.0629	.0655	.0648
1-72 UNF	.0640	.0665	.0659
2-56 UNC	.0744	.0772	.0765
2-64 UNF	.0759	.0786	.0779
3-48 UNC	.0855	.0885	.0877
3-56 UNF	.0874	.0902	.0895
4-40 UNC	.0958	.0991	.0982
4-48 UNF	.0985	.1016	.1008
5-40 UNC	.1088	.1121	.1113
5-44 UNF	.1102	.1134	.1126
6-32 UNC	.1177	.1214	.1204
6-40 UNF	.1218	.1252	.1243
8-32 UNC	.1437	.1475	.1465
8-36 UNF	.1460	.1496	.1487
10-24 UNC	.1629	.1672	.1661
10-32 UNF	.1697	.1736	.1726
12-24 UNC	.1889	.1933	.1922
12-28 UNF	.1928	.1970	.1959
12-32 UNEF	.1957	.1998	.1988
1/4-20 UNC	.2175	.2224	.2211
1/4-28 UNF	.2268	.2311	.2300
1/4-32 UNEF	.2297	.2339	.2328
5/16-18 UNC	.2764	.2817	.2803
5/16-24 UNF	.2854	.2902	.2890
5/16-32 UNEF	.2922	.2964	.2953
3/8-16 UNC	.3344	.3401	.3387
3/8-24 UNF	.3479	.3528	.3516
3/8-32 UNEF	.3547	.3591	.3580
7/16-14 UNC	.3911	.3972	.3957
7/16-20 UNF	.4050	.4104	.4091
7/16-28 UNEF	.4143	.4189	.4178
1/2-13 UNC	.4500	.4565	.4548
1/2-20 UNF	.4675	.4731	.4717
1/2-28 UNEF	.4768	.4816	.4804
9/16-12 UNC	.5084	.5152	.5135
9/16-18 UNF	.5264	.5323	.5308

UNIFIED THREAD GAGES

Thread Plugs			
Nominal Size	GO Basic	NOTGO 2B	NOTGO 3B
9/16-24 UNEF	.5354	.5405	.5392
5/8-11 UNC	.5660	.5732	.5714
5/8-18 UNF	.5889	.5949	.5934
5/8-24 UNEF	.5979	.6031	.6018
11/16-24 UNEF	.6604	.6656	.6643
3/4-10 UNC	.6850	.6927	.6907
3/4-16 UNF	.7094	.7159	.7143
3/4-20 UNEF	.7175	.7232	.7218
13/16-20 UNEF	.7800	.7857	.7843
7/8-9 UNC	.8028	.8110	.8089
7/8-14 UNF	.8286	.8356	.8339
7/8-20 UNEF	.8425	.8482	.8468
15/16-20 UNEF	.9050	.9109	.9094
1-8 UNC	.9188	.9276	.9254
1-12 UNF	.9459	.9535	.9516
1-14 UNS	.9536	.9609	.9590
1-20 UNEF	.9675	.9734	.9719
1 1/16-12 UNF	1.0084	1.0158	1.0139
1 1/16-18 UNEF	1.0264	1.0326	1.0310
1 1/8-7 UNC	1.0322	1.0416	1.0393
1 1/8-12 UNF	1.0709	1.0787	1.0768
1 1/8-18 UNEF	1.0889	1.0951	1.0935
1 3/16-12 UNF	1.1334	1.1409	1.1390
1 3/16-18 UNEF	1.1514	1.1577	1.1561
1 1/4-7 UNC	1.1572	1.1668	1.1644
1 1/4-12 UNF	1.1959	1.2039	1.2019
1 1/4-18 UNEF	1.2139	1.2202	1.2186
1 5/16-12 UNF	1.2584	1.2659	1.2640
1 5/16-18 UNEF	1.2764	1.2827	1.2811
1 3/8-6 UNC	1.2667	1.2771	1.2745
1 3/8-12 UNF	1.3209	1.3291	1.3270
1 3/8-18 UNEF	1.3389	1.3452	1.3436
1 7/16-12 UNF	1.3834	1.3910	1.3891
1 7/16-18 UNEF	1.4014	1.4079	1.4062
1 1/2-6 UNC	1.3917	1.4022	1.3996
1 1/2-12 UNF	1.4459	1.4542	1.4522
1 1/2-18 UNEF	1.4639	1.4704	1.4687

UNIFIED THREAD RING & SETTING PLUG P.D. CHART

UNIFIED THREAD GAGES

Thread Ring & Setting Plugs

Nominal Size	GO 3A	NOTGO 3A	GO 2A	NOTGO 2A
0-80 UNF	.0519	.0506	.0514	.0496
1-64 UNC	.0629	.0614	.0623	.0603
1-72 UNF	.0640	.0626	.0634	.0615
2-56 UNC	.0744	.0728	.0738	.0717
2-64 UNF	.0759	.0744	.0753	.0733
3-48 UNC	.0855	.0838	.0848	.0825
3-56 UNF	.0874	.0858	.0867	.0845
4-40 UNC	.0958	.0939	.0950	.0925
4-48 UNF	.0985	.0967	.0978	.0954
5-40 UNC	.1088	.1069	.1080	.1054
5-44 UNF	.1102	.1083	.1095	.1070
6-32 UNC	.1177	.1156	.1169	.1141
6-40 UNF	.1218	.1198	.1210	.1184
8-32 UNC	.1437	.1415	.1428	.1399
8-36 UNF	.1460	.1439	.1452	.1424
10-24 UNC	.1629	.1604	.1619	.1586
10-32 UNF	.1697	.1674	.1688	.1658
12-24 UNC	.1889	.1863	.1879	.1845
12-28 UNF	.1928	.1904	.1918	.1886
12-32 UNEF	.1957	.1933	.1948	.1917
1/4-20 UNC	.2175	.2147	.2164	.2127
1/4-28 UNF	.2268	.2243	.2258	.2225
1/4-32 UNEF	.2297	.2273	.2287	.2255
5/16-18 UNC	.2764	.2734	.2752	.2712
5/16-24 UNF	.2854	.2827	.2843	.2806
5/16-32 UNEF	.2922	.2898	.2912	.2880
3/8-16 UNC	.3344	.3311	.3331	.3287
3/8-24 UNF	.3479	.3450	.3468	.3430
3/8-32 UNEF	.3547	.3522	.3537	.3503
7/16-14 UNC	.3911	.3876	.3897	.3850
7/16-20 UNF	.4050	.4019	.4037	.3995
7/16-28 UNEF	.4143	.4116	.4132	.4096
1/2-13 UNC	.4500	.4463	.4485	.4435
1/2-20 UNF	.4675	.4643	.4662	.4619
1/2-28 UNEF	.4768	.4740	.4757	.4720
9/16-12 UNC	.5084	.5045	.5068	.5016
9/16-18 UNF	.5264	.5230	.5250	.5205

UNIFIED THREAD GAGES

Thread Ring & Setting Plugs

Nominal Size	GO 3A	NOTGO 3A	GO 2A	NOTGO 2A
9/16-24 UNEF	.5354	.5325	.5342	.5303
5/8-11 UNC	.5660	.5619	.5644	.5589
5/8-18 UNF	.5889	.5854	.5875	.5828
5/8-24 UNEF	.5979	.5949	.5967	.5927
11/16-24 UNEF	.6604	.6574	.6592	.6552
3/4-10 UNC	.6850	.6806	.6832	.6773
3/4-16 UNF	.7094	.7056	.7079	.7029
3/4-20 UNEF	.7175	.7142	.7162	.7118
13/16-20 UNEF	.7800	.7767	.7787	.7743
7/8-9 UNC	.8028	.7981	.8009	.7946
7/8-14 UNF	.8286	.8245	.8270	.8216
7/8-20 UNEF	.8425	.8392	.8412	.8368
15/16-20 UNEF	.9050	.9016	.9036	.8991
1-8 UNC	.9188	.9137	.9168	.9100
1-12 UNF	.9459	.9415	.9441	.9382
1-14 UNS	.9536	.9494	.9519	.9463
1-20 UNEF	.9675	.9641	.9661	.9616
1 1/16-12 UNF	1.0084	1.0042	1.0067	1.0010
1 1/16-18 UNEF	1.0264	1.0228	1.0250	1.0203
1 1/8-7 UNC	1.0322	1.0268	1.0300	1.0228
1 1/8-12 UNF	1.0709	1.0664	1.0691	1.0631
1 1/8-18 UNEF	1.0889	1.0853	1.0875	1.0828
1 3/16-12 UNF	1.1334	1.1291	1.1317	1.1259
1 3/16-18 UNEF	1.1514	1.1478	1.1499	1.1450
1 1/4-7 UNC	1.1572	1.1517	1.1550	1.1476
1 1/4-12 UNF	1.1959	1.1913	1.1941	1.1879
1 1/4-18 UNEF	1.2139	1.2103	1.2124	1.2075
1 5/16-12 UNF	1.2584	1.2541	1.2567	1.2509
1 5/16-18 UNEF	1.2764	1.2728	1.2749	1.2700
1 3/8-6 UNC	1.2667	1.2607	1.2643	1.2563
1 3/8-12 UNF	1.3209	1.3162	1.3190	1.3127
1 3/8-18 UNEF	1.3389	1.3353	1.3374	1.3325
1 7/16-12 UNF	1.3834	1.3790	1.3816	1.3757
1 7/16-18 UNEF	1.4014	1.3977	1.3999	1.3949
1 1/2-6 UNC	1.3917	1.3856	1.3893	1.3812
1 1/2-12 UNF	1.4459	1.4411	1.4440	1.4376
1 1/2-18 UNEF	1.4639	1.4602	1.4624	1.4574

METRIC THREAD PLUG P.D. CHART

METRIC THREAD GAGES

Thread Plugs				
Nominal Size	METRIC		DECIMAL REF.	
	GO 6H	NOTGO 6H	GO 6H	NOTGO 6H
1.6 x .35	1.373	1.458	.05406	.05740
1.8 x .35	1.573	1.658	.06193	.06528
2 x .4	1.740	1.830	.06850	.07205
2.2 x .45	1.908	2.003	.07512	.07886
2.5 x .45	2.208	2.303	.08693	.09067
3 x .5	2.675	2.775	.10531	.10925
3.5 x .6	3.110	3.222	.12244	.12685
4 x .7	3.545	3.663	.13957	.14421
4.5 x .75	4.013	4.131	.15799	.16264
5 x .8	4.480	4.605	.17638	.18130
5.5 x .75	5.013	5.131	.19736	.20201
6 x 1.0	5.350	5.500	.21063	.21654
6.3 x 1.0	5.650	5.800	.22244	.22835
7 x 1.0	6.350	6.500	.25000	.25591
8 x 1.25	7.188	7.348	.28299	.28929
8 x 1.0	7.350	7.500	.28937	.29528
9 x 1.25	8.188	8.348	.32236	.32866
10 x .75	9.513	9.645	.37453	.37972
10 x 1.5	9.026	9.206	.35535	.36244
10 x 1.25	9.188	9.348	.36173	.36803
11 x 1.5	10.026	10.206	.39472	.40181
12 x 1.0	11.350	11.510	.44685	.45315
12 x 1.5	11.026	11.216	.43409	.44157
12 x 1.75	10.863	11.063	.42768	.43555
12 x 1.25	11.188	11.368	.44047	.44756
14 x 2.0	12.701	12.913	.50004	.50838
14 x 1.5	13.026	13.216	.51283	.52031
15 x 1.5	14.026	14.216	.55220	.55968
15 x 1.0	14.350	14.510	.56496	.57126
16 x 2.0	14.701	14.913	.57878	.58712
16 x 1.5	15.026	15.216	.59157	.59905
17 x 1.0	16.350	16.510	.54370	.65000

METRIC THREAD GAGES

Thread Plugs				
Nominal Size	METRIC		DECIMAL REF.	
	GO 6H	NOTGO 6H	GO 6H	NOTGO 6H
17 x 1.5	16.026	16.216	.63094	.63842
18 x 2.5	16.376	16.600	.64472	.65354
18 x 1.5	17.026	17.216	.67031	.67779
20 x 1.0	19.350	19.510	.76181	.76811
20 x 2.5	18.376	18.600	.72346	.73228
20 x 1.5	19.026	19.216	.74905	.75653
22 x 2.5	20.376	20.600	.80220	.81102
22 x 1.5	21.026	21.216	.82779	.83527
24 x 3.0	22.051	22.316	.86815	.87858
24 x 2.0	22.701	22.925	.89374	.90256
25 x 2.0	23.701	23.925	.93311	.94193
25 x 1.5	24.026	24.226	.94590	.95378
26 x 1.5	25.026	25.226	.98527	.99315
26 x 1.0	25.350	25.520	.99803	1.00472
27 x 3.0	25.051	25.316	.98626	.99669
27 x 2.0	25.701	25.925	1.01185	1.02067
28 x 2.0	26.701	26.925	1.05122	1.06004
28 x 1.5	27.026	27.226	1.06401	1.07189
28 x 1.0	27.350	27.520	1.07677	1.08346
30 x 1.5	29.026	29.226	1.14276	1.15063
30 x 3.5	27.727	28.007	1.09161	1.10264
30 x 2.0	28.701	28.925	1.12996	1.13878
32 x 2.0	30.701	30.925	1.20870	1.21752
32 x 1.5	31.026	31.226	1.22149	1.22937
33 x 3.5	30.727	31.007	1.20972	1.22075
33 x 2.0	31.701	31.925	1.24807	1.25689
35 x 1.5	34.026	34.226	1.33960	1.34748
36 x 2.0	34.701	34.925	1.36618	1.37500
36 x 4.0	33.402	33.702	1.31504	1.32685
36 x 3.0	34.051	34.316	1.34059	1.35102
38 x 1.5	37.026	37.226	1.45771	1.46559
39 x 2.0	37.701	37.925	1.48429	1.49311

METRIC THREAD RING & SETTING PLUG P.D. CHART

METRIC THREAD GAGES

Thread Rings & Settings Plugs

Nominal Size	METRIC		DECIMAL REF.	
	GO 6g	NOTGO 6g	GO 6g	NOTGO 6g
1.6 x .35	1.354	1.291	.05331	.05083
1.8 x .35	1.554	1.491	.06118	.05870
2 x .4	1.721	1.654	.06776	.06512
2.2 x .45	1.888	1.817	.07433	.07154
2.5 x .45	2.188	2.117	.08614	.08335
3 x .5	2.655	2.580	.10453	.10157
3.5 x .6	3.089	3.004	.12161	.11827
4 x .7	3.523	3.433	.13870	.13516
4.5 x .75	3.991	3.901	.15713	.15358
5 x .8	4.456	4.361	.17543	.17169
5.5 x .75	4.991	4.901	.19650	.19295
6 x 1.0	5.324	5.212	.20961	.20520
6.3 x 1.0	5.624	5.512	.22142	.21701
7 x 1.0	6.324	6.212	.24898	.24457
8 x 1.25	7.160	7.042	.28189	.27724
8 x 1.0	7.324	7.212	.28835	.28394
9 x 1.25	8.160	8.042	.32126	.31661
10 x .75	9.491	9.391	.37366	.36972
10 x 1.5	8.994	8.862	.35409	.34890
10 x 1.25	9.160	9.042	.36063	.35598
11 x 1.5	9.994	9.862	.39346	.38827
12 x 1.0	11.324	11.206	.44583	.44118
12 x 1.5	10.994	10.854	.43283	.42732
12 x 1.75	10.829	10.679	.42634	.42043
12 x 1.25	11.160	11.028	.43937	.43417
14 x 2.0	12.663	12.503	.49854	.49224
14 x 1.5	12.994	12.854	.51157	.50606
15 x 1.5	13.994	13.854	.55094	.54543
15 x 1.0	14.324	14.206	.56394	.55929
16 x 2.0	14.663	14.503	.57728	.57098
16 x 1.5	14.994	14.854	.59031	.58480
17 x 1.0	16.324	16.206	.64268	.63803

METRIC THREAD GAGES

Thread Rings & Settings Plugs

Nominal Size	METRIC		DECIMAL REF.	
	GO 6g	NOTGO 6g	GO 6g	NOTGO 6g
17 x 1.5	15.994	15.854	.62968	.62417
18 x 2.5	16.334	16.164	.64307	.63638
18 x 1.5	16.994	16.854	.66905	.66354
20 x 1.0	19.324	19.206	.76079	.75614
20 x 2.5	18.334	18.164	.72181	.71512
20 x 1.5	18.994	18.854	.74779	.74228
22 x 2.5	20.334	20.164	.80055	.79386
22 x 1.5	20.994	20.854	.82653	.82102
24 x 3.0	22.003	21.803	.86626	.85838
24 x 2.0	22.663	22.493	.89224	.88555
25 x 2.0	23.663	23.493	.93161	.92492
25 x 1.5	23.994	23.844	.94464	.93874
26 x 1.5	24.994	24.844	.98401	.97811
26 x 1.0	25.324	25.199	.99701	.99209
27 x 3.0	25.003	24.803	.98437	.97649
27 x 2.0	25.663	25.493	1.01035	1.00366
28 x 2.0	26.663	26.493	1.04972	1.04303
28 x 1.5	26.994	26.844	1.07625	1.05684
28 x 1.0	27.324	27.199	1.07575	1.07082
30 x 1.5	28.994	28.844	1.14150	1.13559
30 x 3.5	27.674	27.462	1.08953	1.08118
30 x 2.0	28.663	28.493	1.12846	1.12177
32 x 2.0	30.663	30.493	1.20720	1.20051
32 x 1.5	30.994	30.844	1.22023	1.21432
33 x 3.5	30.674	30.462	1.20764	1.19929
33 x 2.0	31.663	31.493	1.24657	1.23988
35 x 1.5	33.994	33.844	1.33834	1.33244
36 x 2.0	34.663	34.493	1.36469	1.35799
36 x 4.0	33.342	33.118	1.31267	1.30386
36 x 3.0	34.003	33.803	1.33870	1.33082
38 x 1.5	36.994	36.844	1.45645	1.45055
39 x 2.0	37.663	37.493	1.48280	1.47610

VAN KEUREN INSTRUMENTS

Van Keuren proudly offers the highest quality instruments to solve your toughest measuring needs. A wonderful addition to the Van Keuren Instruments line of products: ContouReader™ and SquareMaster™.



SQUAREMASTER

The SquareMaster can measure with an accuracy of ± 0.000050 of an inch (50 millionths) over any 12" of specified range. No hand gage even comes close. The SquareMaster can be used for virtually any measurement of straightness, squareness or parallelism on interior or exterior surfaces. Its precision direct dial readout substitutes reliable and repeatable results for the subjective calculations you probably now make.



CONTOUREADER

The ContouReader by PMC Lonestar is part of a new generation of precision instruments to inspect both internal and external dimensions of thousands of parts to guarantee the quality of your products. We offer two versions of the ContouReader; a standard and new Windows-based computerized version. The ContouReader inspects everything from dimples on golf balls to turbine blades with the same repeatable accuracy to reveal any defects, deviation from specifications, or rough edges that can adversely affect product quality.



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