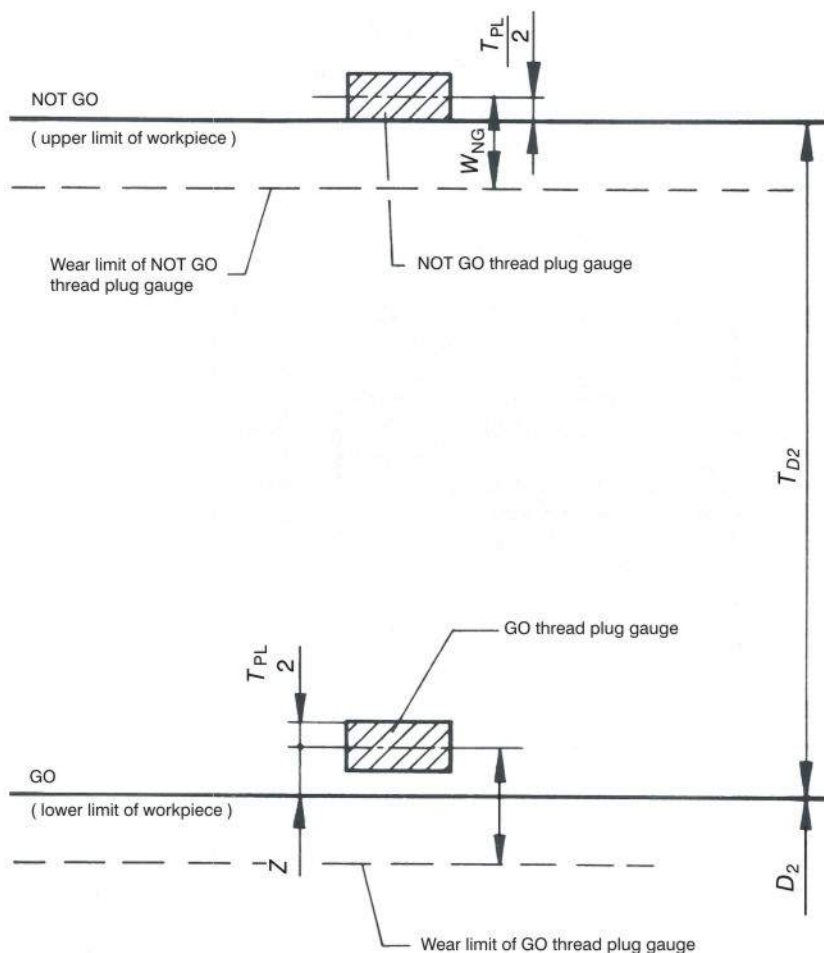


# THREAD PLUG GAUGES FOR PIPE THREADS, WHERE PRESSURE-TIGHT JOINTS ARE NOT MADE ON THE THREADS: 'G' THREADS

## TOLERANCE ZONES FOR THE PITCH DIAMETER OF THREAD PLUG GAUGES FOR INTERNAL 'G' THREADS

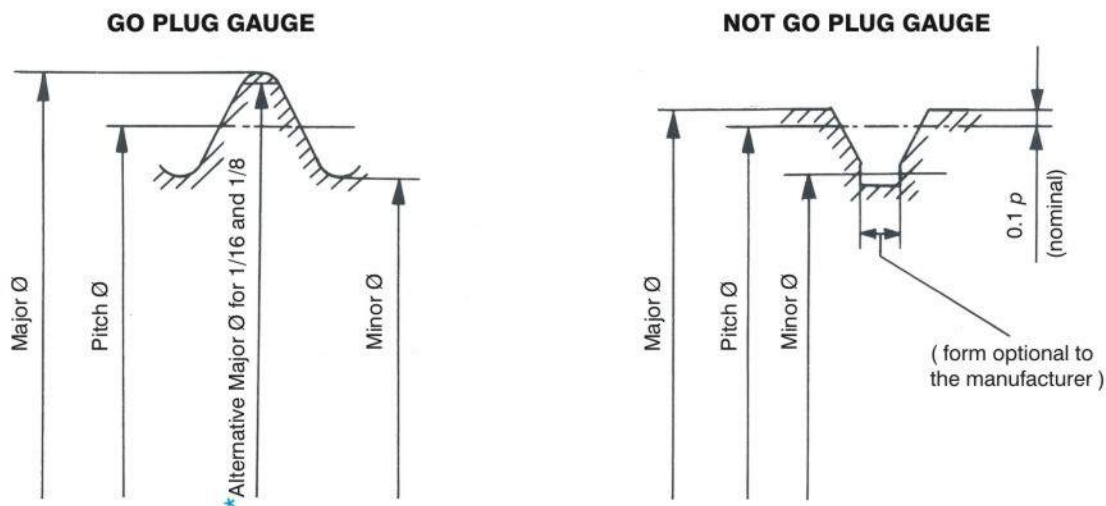
REF:  
 BASIC DIMENSIONS :- ISO 228 - 1  
 GAUGING PRACTICE :- ISO 228 - 2  
 BASIC DIMENSIONS :- IS 10216  
 GAUGING PRACTICE :- IS 2643



### WEAR ALLOWANCES FOR THREAD PLUG GAUGES

DESIGNATION	$W_{GO}$ $\mu m$	$W_{NG}$ $\mu m$
1 / 16 and 1 / 8	14	10
1 / 4 and 3 / 8	14	10
1 / 2 to 7 / 8	19	13
1 to 2	19	13
2 1/4 to 4	23	17
4 1/2 to 6	23	17

## THREAD PROFILE



\* For 1/16 & 1/8 GO PLUGS; A PROFILE IS PERMITTED WITHOUT A RADIUS

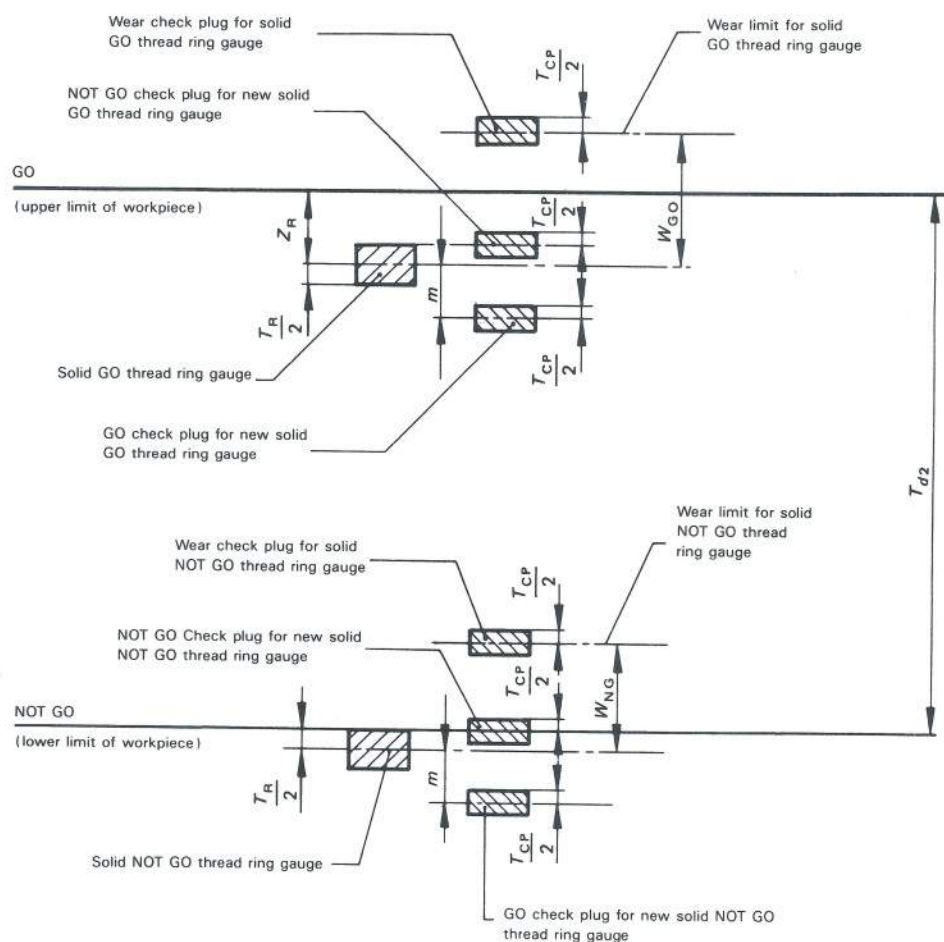
## DIMENSIONS OF THREAD PLUG GAUGES, 'G' THREADS

SIZE	GO THREAD PLUG GAUGE					NOT GO THREAD PLUG GAUGE				
	MAJOR Ø mm	TOL. ±µm	PITCH Ø mm	TOL. ±µm	MINOR Ø MAX mm	MAJOR Ø mm	TOL. ±µm	PITCH Ø mm	TOL. ±µm	MINOR Ø MAX mm
G 1/16	* 7.584	5	7.150	5	6.561	7.435	10	7.254	5	6.454
G 1/8	* 9.589	5	9.155	5	8.566	9.440	10	9.259	5	8.459
G 1/4	13.162	10	12.309	5	11.445	12.698	10	12.431	5	11.320
G 3/8	16.667	10	15.814	5	14.950	16.203	10	15.936	5	14.825
G 1/2	20.961	12	19.806	6	18.631	20.304	12	19.941	6	18.489
G 5/8	22.917	12	21.762	6	20.587	22.260	12	21.897	6	20.445
G 3/4	26.447	12	25.292	6	24.117	25.790	12	25.427	6	23.975
G 7/8	30.207	12	29.052	6	27.877	29.550	12	29.187	6	27.735
G 1	33.255	12	31.783	6	30.291	32.418	12	31.956	6	30.111
G 1 <sup>1</sup> / <sub>8</sub>	37.903	12	36.431	6	34.939	37.066	12	36.604	6	34.759
G 1 <sup>1</sup> / <sub>4</sub>	41.916	12	40.444	6	38.952	41.079	12	40.617	6	38.772
G 1 <sup>1</sup> / <sub>2</sub>	47.809	12	46.337	6	44.845	46.972	12	46.510	6	44.665
G 1 <sup>3</sup> / <sub>4</sub>	53.752	12	52.280	6	50.788	52.915	12	52.453	6	50.608
G 2	59.620	12	58.148	6	56.656	58.783	12	58.321	6	56.476
G 2 <sup>1</sup> / <sub>4</sub>	65.718	16	64.249	8	62.752	64.918	16	64.456	8	62.535
G 2 <sup>1</sup> / <sub>2</sub>	75.192	16	73.723	8	72.226	74.392	16	73.930	8	72.009
G 2 <sup>3</sup> / <sub>4</sub>	81.542	16	80.073	8	78.576	80.742	16	80.280	8	78.359
G 3	87.892	16	86.423	8	84.926	87.092	16	86.630	8	84.709
G 3 <sup>1</sup> / <sub>2</sub>	100.338	16	98.869	8	97.372	99.538	16	99.076	8	97.155
G 4	113.038	16	111.569	8	110.072	112.238	16	111.776	8	109.855
G 4 <sup>1</sup> / <sub>2</sub>	125.738	16	124.269	8	122.772	124.938	16	124.476	8	122.555
G 5	138.438	16	136.969	8	135.472	137.638	16	137.176	8	135.255
G 5 <sup>1</sup> / <sub>2</sub>	151.138	16	149.669	8	148.172	150.338	16	149.876	8	147.955
G 6	163.838	16	162.369	8	160.872	163.038	16	162.576	8	160.655

\* truncated

# THREAD RING GAUGES FOR PIPE THREADS, WHERE PRESSURE-TIGHT JOINTS ARE NOT MADE ON THE THREADS: 'G' THREADS

## TOLERANCE ZONES FOR THE PITCH DIAMETER OF THREAD PLUG GAUGES FOR EXTERNAL 'G' THREADS



### WEAR ALLOWANCES FOR THREAD RING GAUGES: CLASS 'A'

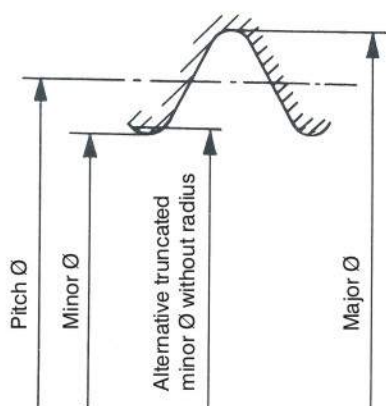
DESIGNATION	$W_{GO}$ $\mu\text{m}$	$W_{NG}$ $\mu\text{m}$
1 / 16 and 1 / 8	18	13
1 / 4 and 3 / 8	18	13
1 / 2 to 7 / 8	23	17
1 to 2	23	17
2 1/4 to 4	28	21
4 1/2 to 6	28	21

### WEAR ALLOWANCES FOR THREAD RING GAUGE: 'B'

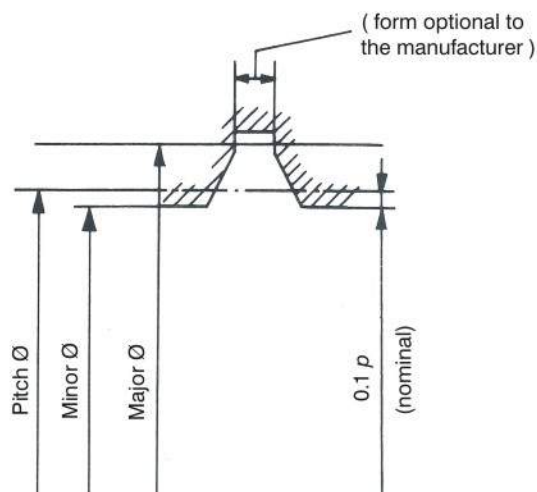
DESIGNATION	$W_{GO}$ $\mu\text{m}$	$W_{NG}$ $\mu\text{m}$
1 / 16 and 1 / 8	18	21
1 / 4 and 3 / 8	18	21
1 / 2 to 7 / 8	23	21
1 to 2	23	28
2 1/4 to 4	28	28
4 1/2 to 6	28	28

## THREAD PROFILE

### GO RING GAUGE



### NOT GO RING GAUGE



## DIMENSIONS FOR THREAD RING GAUGES, 'G' THREADS

CLASS 'A'										
SIZE	GO THREAD RING GAUGE					NOT GO THREAD RING GAUGE				
	MINOR Ø	TOL.	*PITCH Ø	TOL.	MAJOR Ø MIN	MINOR Ø	TOL.	*PITCH Ø	TOL.	MAJOR Ø MIN
	mm	±µm	mm	±µm	mm	mm	±µm	mm	±µm	mm
G 1/16	6.703	8	7.140	8	7.723	6.846	16	7.027	8	7.733
G 1/8	8.708	8	9.145	8	9.728	8.851	16	9.032	8	9.738
G 1/4	11.651	8	12.299	8	13.157	11.901	16	12.168	8	13.167
G 3/8	15.156	8	15.804	8	16.662	15.406	16	15.673	8	16.672
G 1/2	18.909	10	19.784	10	20.955	19.278	20	19.641	10	20.967
G 5/8	20.865	10	21.740	10	22.911	21.234	20	21.597	10	22.923
G 3/4	24.395	10	25.270	10	26.441	24.764	20	25.127	10	26.453
G 7/8	28.155	10	29.030	10	30.201	28.524	20	28.887	10	30.213
G 1	30.642	10	31.761	10	33.249	31.118	20	31.580	10	33.261
G 1 <sup>1</sup> / <sub>8</sub>	35.290	10	36.409	10	37.897	35.766	20	36.228	10	37.909
G 1 <sup>1</sup> / <sub>4</sub>	39.303	10	40.422	10	41.910	39.779	20	40.241	10	41.922
G 1 <sup>1</sup> / <sub>2</sub>	45.196	10	46.315	10	47.803	45.672	20	46.134	10	47.815
G 1 <sup>3</sup> / <sub>4</sub>	51.139	10	52.258	10	53.746	51.615	20	52.077	10	53.758
G 2	57.007	10	58.126	10	59.614	57.483	20	57.945	10	59.626
G 2 <sup>1</sup> / <sub>4</sub>	63.106	13	64.218	13	65.710	63.539	26	64.001	13	65.726
G 2 <sup>1</sup> / <sub>2</sub>	72.580	13	73.692	13	75.184	73.013	26	73.475	13	75.200
G 2 <sup>3</sup> / <sub>4</sub>	78.930	13	80.042	13	81.534	79.363	26	79.825	13	81.550
G 3	85.280	13	86.392	13	87.884	85.713	26	86.175	13	87.900
G 3 <sup>1</sup> / <sub>2</sub>	97.726	13	98.838	13	100.330	98.159	26	98.621	13	100.346
G 4	110.426	13	111.538	13	113.030	110.859	26	111.321	13	113.046
G 4 <sup>1</sup> / <sub>2</sub>	123.126	13	124.238	13	125.730	123.559	26	124.021	13	125.746
G 5	135.826	13	136.938	13	138.430	136.259	26	136.721	13	138.446
G 5 <sup>1</sup> / <sub>2</sub>	148.526	13	149.638	13	151.130	148.959	26	149.421	13	151.146
G 6	161.226	13	162.338	13	163.830	161.659	26	162.121	13	163.846
CLASS 'B'										
G 1/16	6.703	8	7.140	8	7.723	6.734	26	6.915	13	7.739
G 1/8	8.708	8	9.145	8	9.728	8.739	26	8.920	13	9.744
G 1/4	11.651	8	12.299	8	13.157	11.771	26	12.038	13	13.173
G 3/8	15.156	8	15.804	8	16.662	15.276	26	15.543	13	16.678
G 1/2	18.909	10	19.784	10	20.955	19.133	26	19.496	13	20.971
G 5/8	20.865	10	21.740	10	22.911	21.089	26	21.452	13	22.927
G 3/4	24.395	10	25.270	10	26.441	24.619	26	24.982	13	26.457
G 7/8	28.155	10	29.030	10	30.201	28.379	26	28.742	13	30.217
G 1	30.642	10	31.761	10	33.249	30.931	34	31.393	17	33.269
G 1 <sup>1</sup> / <sub>8</sub>	35.290	10	36.409	10	37.897	35.579	34	36.041	17	37.917
G 1 <sup>1</sup> / <sub>4</sub>	39.303	10	40.422	10	41.910	39.592	34	40.054	17	41.930
G 1 <sup>1</sup> / <sub>2</sub>	45.196	10	46.315	10	47.803	45.485	34	45.947	17	47.823
G 1 <sup>3</sup> / <sub>4</sub>	51.139	10	52.258	10	53.746	51.428	34	51.890	17	53.766
G 2	57.007	10	58.126	10	59.614	57.296	34	57.758	17	59.634
G 2 <sup>1</sup> / <sub>4</sub>	63.106	13	64.218	13	65.710	63.318	34	63.780	17	65.730
G 2 <sup>1</sup> / <sub>2</sub>	72.580	13	73.692	13	75.184	72.792	34	73.254	17	75.204
G 2 <sup>3</sup> / <sub>4</sub>	78.930	13	80.042	13	81.534	79.142	34	79.604	17	81.554
G 3	85.280	13	86.392	13	87.884	85.492	34	85.954	17	87.904
G 3 <sup>1</sup> / <sub>2</sub>	97.726	13	98.838	13	100.330	97.938	34	98.400	17	100.350
G 4	110.426	13	111.538	13	113.030	110.638	34	111.100	17	113.050
G 4 <sup>1</sup> / <sub>2</sub>	123.126	13	124.238	13	125.730	123.338	34	123.800	17	125.750
G 5	135.826	13	136.938	13	138.430	136.038	34	136.500	17	138.450
G 5 <sup>1</sup> / <sub>2</sub>	148.526	13	149.638	13	151.130	148.738	34	149.200	17	151.150
G 6	161.226	13	162.338	13	163.830	161.438	34	161.900	17	163.850