



Precision Thread and Plain Gages

Including Gage Calibration



2025

Gage Calibration Service

New Swanson Gages

THREAD GAGES

Certificate of Compliance (Short Form)	No Charge
Certificate of Calibration (Long Form) up to 5"	\$20.00 / member
Certificate of Calibration (Long Form) over 5"	\$30.00 / member

TAPER PIPE GAGES

Certificate of Compliance (Short Form)	No Charge
Certificate of Calibration (Long Form).....	\$35.00 / member

CERTIFICATE OF COMPLIANCE (Short Form)

Certificate indicates the gage complies with applicable H28 and ANSI standards.

CERTIFICATE OF CALIBRATION (Long Form)

Certificate indicates actual measurements of pitch diameter, major diameter, minor diameter, flank angles and lead where they apply.

Customer Supplied Gages

THREAD PLUG GAGES: Work or Setting

Sizes #0 to 1-1/2" (M1.6 to M39)	\$30.00 / member
Sizes 1-9/16" to 8" (M40 to M203).....	\$35.00 / member

NOTE: As the centerline (axis) of Trilock plug gages cannot be accurately located, the lead cannot be calibrated and half-angle relation to axis cannot be accurately calibrated. The flank angles can be calibrated for included angle only.

THREAD RING GAGES:

Standard sizes to 1-1/2" (M39)	\$45.00 / member
Non-standard sizes #0 to 5" (M1.6 to M127).....	\$45.00 / member
Sizes over 5" (over M127)	\$80.00 / member

NOTE: For non-standard ring sizes where a set plug is not in our stock or is not furnished, a special tooling charge applies and will be quoted prior to processing.

TAPER PIPE GAGES

	<u>Plugs</u>	<u>Rings</u>
Sizes 1/16" to 3"	\$45.00 / member	\$70.00 / member
Sizes 3-1/2" to 6"	\$65.00 / member	\$85.00 / member

CYLINDRICAL GAGES

	<u>Plugs</u>	<u>Rings</u>
Sizes .040" to .060" (M1.016 to M1.524).....	\$88.00 / member	\$88.00 / member
Sizes .061" to .100" (M1.525 to M2.54).....	\$88.00 / member	\$88.00 / member
Sizes .101" to 2.010" (M2.541 to M51.05).....	\$88.00 / member	\$88.00 / member
Sizes 2.011" to 5.510" (M51.06 to M140.0).....	\$115.00 / member	\$115.00 / member
Sizes below .040" and over 5.510" – call for quote		

Table of Contents



SERVICE

Gage Calibration Service	1
--------------------------------	---

THREAD GAGES

WORK PLUG – HSS/TiN Coated - UNC, UNF	3
WORK PLUG – UNC, UNF, UNEF	4
RING – UNC, UNF, UNEF	5
SETTING PLUG – UNC, UNF, UNEF	6
8, 12 & 16 PITCH – Work Plug	7
8, 12 & 16 PITCH – Ring & Setting Plug	8
HELICAL COIL (STI) – Tool Steel & HSS/TiN Coated	9
LEFT HAND – Work Plug, Ring & Setting Plug	10
REVERSIBLE – UNC, UNF	11
METRIC – Work Plug - Reversible	11
METRIC – Work Plug - Taperlock - Tool Steel & HSS/TiN Coated	12
METRIC – Ring	13
METRIC – Setting Plug	14
PIPE – NPT, NPTF, ANPT - Plug & Ring	15
PIPE – NPSM - Work Plug, Ring & Setting Plug	16
PIPE – NPSF - Work Plug	16
BRITISH PARALLEL (BSPP) – Work Plug, Ring & Setting Plug	17
BRITISH TAPER (BSPT) – Work Plug & Ring	17
FLEXIBLE HOLE LOCATION GAGES	18
THREAD MEASURING WIRES	19

PLAIN CYLINDRICAL GAGES

REVERSIBLE	20
TRILOCK	20
TAPERLOCK	21
PROGRESSIVE	22
RING	23
MASTER SETTING DISCS	24

PITCH DIAMETER TABLES

TABLE I – Thread Plug Gages	25
TABLE II – Thread Ring & Setting Plug Gages	26
TABLE III – (STI) Helical Coil Insert Plug Gages	27
TABLE IV – Metric Thread Plug Gages	28
TABLE V – Metric Thread Ring & Setting Plug Gages	28
TABLE VI – Straight Pipe Plug & Ring Gages	29

ANSI THREAD SERIES DESIGNATIONS	30
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PRICES SUBJECT TO CHANGE WITHOUT NOTICE

All sales subject to and governed by the Terms and Conditions of Sale for Swanson Tool Manufacturing, Inc. located at www.swansongage.com/terms.htm

Titanium Nitride Coated HSS Thread Plug Gages



Class "X" Tolerance, Precision Lapped

SIZE	GO	2B, 3B NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
0-80 UNF	135.00	135.00	000	13.00	283.00
1-64 UNC	135.00	135.00	000	13.00	283.00
1-72 UNF	135.00	135.00	000	13.00	283.00
2-56 UNC	118.00	118.00	000	13.00	249.00
2-64 UNF	118.00	118.00	000	13.00	249.00
3-48 UNC	118.00	118.00	000	13.00	249.00
3-56 UNF	118.00	118.00	000	13.00	249.00
4-40 UNC	102.00	102.00	00	13.00	217.00
4-48 UNF	102.00	102.00	00	13.00	217.00
5-40 UNC	102.00	102.00	00	13.00	217.00
5-44 UNF	102.00	102.00	00	13.00	217.00
6-32 UNC	90.00	90.00	00	13.00	193.00
6-40 UNF	90.00	90.00	00	13.00	193.00
8-32 UNC	90.00	90.00	0	13.00	193.00
8-36 UNF	90.00	90.00	0	13.00	193.00
10-24 UNC	90.00	90.00	0	13.00	193.00
10-32 UNF	90.00	90.00	0	13.00	193.00
12-24 UNC	90.00	90.00	0	13.00	193.00
12-28 UNF	90.00	90.00	0	13.00	193.00
1/4-20 UNC	76.00	76.00	1	13.00	165.00
1/4-28 UNF	76.00	76.00	1	13.00	165.00
5/16-18 UNC	76.00	76.00	1	13.00	165.00
5/16-24 UNF	76.00	76.00	1	13.00	165.00
3/8-16 UNC	82.00	82.00	2	13.00	177.00
3/8-24 UNF	82.00	82.00	2	13.00	177.00
7/16-14 UNC	82.00	82.00	2	13.00	177.00
7/16-20 UNF	82.00	82.00	2	13.00	177.00
1/2-13 UNC	91.00	91.00	2	13.00	195.00
1/2-20 UNF	91.00	91.00	2	13.00	195.00
9/16-12 UNC	109.00	109.00	3	13.00	231.00
9/16-18 UNF	109.00	109.00	3	13.00	231.00
5/8-11 UNC	116.00	116.00	3	13.00	245.00
5/8-18 UNF	116.00	116.00	3	13.00	245.00
3/4-10 UNC	135.00	135.00	3	13.00	283.00
3/4-16 UNF	135.00	135.00	3	13.00	283.00
7/8-9 UNC	146.00	146.00	4	13.00	305.00
7/8-14 UNF	146.00	146.00	4	13.00	305.00
1"-8 UNC	189.00	189.00	4	13.00	391.00
1"-12 UNF	189.00	189.00	4	13.00	391.00

Advantages of TiN Coating:

- Greatly increased tool life
- Greater corrosion resistance
- Greater abrasion resistance
- Increased lubricity
- Visible sign of gage wear
- Lower gaging cost
- Increased productivity

For TiN coated METRIC PLUGS (see pg. 12), HELICAL COIL PLUGS (see pg. 9).
For TiN coated PIPE PLUGS & SPECIALS call Swanson

Taperlock Thread Plug Gages



Class "X" Tolerance, Precision Lapped

SIZE	GO	2B, 3B NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
0-80 UNF	64.00	64.00	000	13.00	141.00
1-64 UNC	64.00	64.00	000	13.00	141.00
1-72 UNF	64.00	64.00	000	13.00	141.00
2-56 UNC	61.00	61.00	000	13.00	135.00
2-64 UNF	61.00	61.00	000	13.00	135.00
3-48 UNC	56.00	56.00	000	13.00	125.00
3-56 UNF	56.00	56.00	000	13.00	125.00
4-40 UNC	52.00	52.00	00	13.00	117.00
4-48 UNF	52.00	52.00	00	13.00	117.00
5-40 UNC	50.00	50.00	00	13.00	113.00
5-44 UNF	50.00	50.00	00	13.00	113.00
6-32 UNC	46.00	46.00	00	13.00	105.00
6-40 UNF	46.00	46.00	00	13.00	105.00
8-32 UNC	46.00	46.00	0	13.00	105.00
8-36 UNF	46.00	46.00	0	13.00	105.00
10-24 UNC	46.00	46.00	0	13.00	105.00
10-32 UNF	46.00	46.00	0	13.00	105.00
12-24 UNC	46.00	46.00	0	13.00	105.00
12-28 UNF	46.00	46.00	0	13.00	105.00
12-32 UNEF	61.00	61.00	0	13.00	135.00
1/4-20 UNC	42.00	42.00	1	13.00	97.00
1/4-28 UNF	42.00	42.00	1	13.00	97.00
1/4-32 UNEF	75.00	75.00	1	13.00	163.00
5/16-18 UNC	42.00	42.00	1	13.00	97.00
5/16-24 UNF	42.00	42.00	1	13.00	97.00
5/16-32 UNEF	75.00	75.00	1	13.00	163.00
3/8-16 UNC	43.00	43.00	2	13.00	99.00
3/8-24 UNF	43.00	43.00	2	13.00	99.00
3/8-32 UNEF	86.00	86.00	2	13.00	185.00
7/16-14 UNC	43.00	43.00	2	13.00	99.00
7/16-20 UNF	43.00	43.00	2	13.00	99.00
7/16-28 UNEF	86.00	86.00	2	13.00	185.00
1/2-13 UNC	46.00	46.00	2	13.00	105.00
1/2-20 UNF	46.00	46.00	2	13.00	105.00
1/2-28 UNEF	89.00	89.00	2	13.00	191.00
9/16-12 UNC	58.00	58.00	3	13.00	129.00
9/16-18 UNF	58.00	58.00	3	13.00	129.00
9/16-24 UNEF	98.00	98.00	3	13.00	209.00
5/8-11 UNC	58.00	58.00	3	13.00	129.00
5/8-18 UNF	58.00	58.00	3	13.00	129.00
5/8-24 UNEF	98.00	98.00	3	13.00	209.00

SIZE	GO	2B, 3B NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
11/16-24 UNEF	99.00	99.00	3	13.00	211.00
3/4-10 UNC	64.00	64.00	3	13.00	141.00
3/4-16 UNF	64.00	64.00	3	13.00	141.00
3/4-20 UNEF	102.00	102.00	3	13.00	217.00
13/16-20 UNEF	114.00	114.00	3	13.00	241.00
7/8-9 UNC	71.00	71.00	4	13.00	155.00
7/8-14 UNF	71.00	71.00	4	13.00	155.00
7/8-20 UNEF	114.00	114.00	4	13.00	241.00
15/16-20 UNEF	115.00	115.00	4	13.00	243.00
1"-8 UNC	81.00	81.00	4	13.00	175.00
1"-12 UNF	81.00	81.00	4	13.00	175.00
1"-14 UNS	81.00	81.00	4	13.00	175.00
1"-20 UNEF	132.00	132.00	4	13.00	277.00
1 1/16-12 UN	147.00	147.00	4	13.00	307.00
1 1/16-18 UN	137.00	137.00	4	13.00	287.00
1 1/8-7 UNC	102.00	102.00	4	13.00	217.00
1 1/8-12 UNF	102.00	102.00	4	13.00	217.00
1 1/8-18 UNEF	133.00	133.00	4	13.00	279.00
1 3/16-12 UN	143.00	143.00	5	14.00	300.00
1 3/16-18 UN	143.00	143.00	5	14.00	300.00
1 1/4-7 UNC	110.00	110.00	5	14.00	234.00
1 1/4-12 UNF	110.00	110.00	5	14.00	234.00
1 1/4-18 UNEF	137.00	137.00	5	14.00	288.00
1 5/16-12 UN	156.00	156.00	5	14.00	326.00
1 5/16-18 UN	156.00	156.00	5	14.00	326.00
1 3/8-6 UNC	120.00	120.00	5	14.00	254.00
1 3/8-12 UNF	120.00	120.00	5	14.00	254.00
1 3/8-18 UNEF	164.00	164.00	5	14.00	342.00
1 7/16-12 UN	168.00	168.00	5	14.00	350.00
1 7/16-18 UN	168.00	168.00	5	14.00	350.00
1 1/2-6 UNC	135.00	135.00	5	14.00	284.00
1 1/2-12 UNF	135.00	135.00	5	14.00	284.00
1 1/2-18 UNEF	178.00	178.00	5	14.00	370.00

For chrome plate – add 30%.

Adjustable Thread Ring Gages



Class "X" Tolerance Precision Lapped

SIZE	2A, 3A GO	2A, 3A NOGO	SET GO/ NOGO	HOLDERS	
				NO.	PRICE
0-80 UNF	188.00	188.00	376.00	1	23.00
1-64 UNC	172.00	172.00	344.00	1	23.00
1-72 UNF	172.00	172.00	344.00	1	23.00
2-56 UNC	155.00	155.00	310.00	1	23.00
2-64 UNF	155.00	155.00	310.00	1	23.00
3-48 UNC	155.00	155.00	310.00	1	23.00
3-56 UNF	155.00	155.00	310.00	1	23.00
4-40 UNC	137.00	137.00	274.00	1	23.00
4-48 UNF	137.00	137.00	274.00	1	23.00
5-40 UNC	120.00	120.00	240.00	1	23.00
5-44 UNF	120.00	120.00	240.00	1	23.00
6-32 UNC	120.00	120.00	240.00	1	23.00
6-40 UNF	120.00	120.00	240.00	1	23.00
8-32 UNC	117.00	117.00	234.00	1	23.00
8-36 UNF	117.00	117.00	234.00	1	23.00
10-24 UNC	117.00	117.00	234.00	1	23.00
10-32 UNF	117.00	117.00	234.00	1	23.00
12-24 UNC	117.00	117.00	234.00	1	23.00
12-28 UNF	117.00	117.00	234.00	1	23.00
12-32 UNEF	161.00	161.00	322.00	1	23.00
1/4-20 UNC	116.00	116.00	232.00	2	24.00
1/4-28 UNF	116.00	116.00	232.00	2	24.00
1/4-32 UNEF	161.00	161.00	322.00	2	24.00
5/16-18 UNC	116.00	116.00	232.00	2	24.00
5/16-24 UNF	116.00	116.00	232.00	2	24.00
5/16-32 UNEF	161.00	161.00	322.00	2	24.00
3/8-16 UNC	127.00	127.00	254.00	3	25.00
3/8-24 UNF	127.00	127.00	254.00	3	25.00
3/8-32 UNEF	165.00	165.00	330.00	3	25.00
7/16-14 UNC	127.00	127.00	254.00	3	25.00
7/16-20 UNF	127.00	127.00	254.00	3	25.00
7/16-28 UNEF	165.00	165.00	330.00	3	25.00
1/2-13 UNC	137.00	137.00	274.00	3	25.00
1/2-20 UNF	137.00	137.00	274.00	3	25.00
1/2-28 UNEF	175.00	175.00	350.00	3	25.00
9/16-12 UNC	149.00	149.00	298.00	4	31.00
9/16-18 UNF	149.00	149.00	298.00	4	31.00
9/16-24 UNEF	176.00	176.00	352.00	4	31.00
5/8-11 UNC	156.00	156.00	312.00	4	31.00
5/8-18 UNF	156.00	156.00	312.00	4	31.00
5/8-24 UNEF	213.00	213.00	426.00	4	31.00

SIZE	2A, 3A GO	2A, 3A NOGO	SET GO/ NOGO	HOLDERS	
				NO.	PRICE
11/16-24 UNEF	198.00	198.00	396.00	4	31.00
3/4-10 UNC	194.00	194.00	388.00	4	31.00
3/4-16 UNF	194.00	194.00	388.00	4	31.00
3/4-20 UNEF	241.00	241.00	482.00	4	31.00
13/16-20 UNEF	245.00	245.00	490.00	4	31.00
7/8-9 UNC	210.00	210.00	420.00	5	43.00
7/8-14 UNF	210.00	210.00	420.00	5	43.00
7/8-20 UNEF	255.00	255.00	510.00	5	43.00
15/16-20 UNEF	256.00	256.00	512.00	5	43.00
1"-8 UNC	260.00	260.00	520.00	5	43.00
1"-12 UNF	260.00	260.00	520.00	5	43.00
1"-14 UNS	260.00	260.00	520.00	5	43.00
1"-20 UNEF	291.00	291.00	582.00	5	43.00
1 1/16-12 UN	317.00	317.00	634.00	5	43.00
1 1/16-18 UN	330.00	330.00	660.00	5	43.00
1 1/8-7 UNC	322.00	322.00	644.00	5	43.00
1 1/8-12 UNF	322.00	322.00	644.00	5	43.00
1 1/8-18 UNEF	334.00	334.00	668.00	5	43.00
1 3/16-12 UN	345.00	345.00	690.00	6	55.00
1 3/16-18 UN	345.00	345.00	690.00	6	55.00
1 1/4-7 UNC	345.00	345.00	690.00	6	55.00
1 1/4-12 UNF	345.00	345.00	690.00	6	55.00
1 1/4-18 UNEF	351.00	351.00	702.00	6	55.00
1 5/16-12 UN	355.00	355.00	710.00	6	55.00
1 5/16-18 UN	355.00	355.00	710.00	6	55.00
1 3/8-6 UNC	351.00	351.00	702.00	6	55.00
1 3/8-12 UNF	351.00	351.00	702.00	6	55.00
1 3/8-18 UNEF	375.00	375.00	750.00	6	55.00
1 7/16-12 UN	377.00	377.00	754.00	6	55.00
1 7/16-18 UN	377.00	377.00	754.00	6	55.00
1 1/2-6 UNC	386.00	386.00	772.00	6	55.00
1 1/2-12 UNF	386.00	386.00	772.00	6	55.00
1 1/2-18 UNEF	403.00	403.00	806.00	6	55.00

Chrome Plate for 1/4" and larger – add 50%.

**For "J" Conversion – Add \$50.00 to
GO ring price.**

Thread Setting Plugs



Class "X" Pitch Diameters "W" Lead & Angles, Precision Lapped

SIZE	2A, 3A GO	2A, 3A NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
0-80 UNF	128.00	128.00	000	13.00	269.00
1-64 UNC	128.00	128.00	000	13.00	269.00
1-72 UNF	128.00	128.00	000	13.00	269.00
2-56 UNC	128.00	128.00	000	13.00	269.00
2-64 UNF	128.00	128.00	000	13.00	269.00
3-48 UNC	121.00	121.00	000	13.00	255.00
3-56 UNF	121.00	121.00	000	13.00	255.00
4-40 UNC	116.00	116.00	00	13.00	245.00
4-48 UNF	116.00	116.00	00	13.00	245.00
5-40 UNC	109.00	109.00	00	13.00	231.00
5-44 UNF	109.00	109.00	00	13.00	231.00
6-32 UNC	109.00	109.00	00	13.00	231.00
6-40 UNF	109.00	109.00	00	13.00	231.00
8-32 UNC	109.00	109.00	0	13.00	231.00
8-36 UNF	109.00	109.00	0	13.00	231.00
10-24 UNC	109.00	109.00	0	13.00	231.00
10-32 UNF	109.00	109.00	0	13.00	231.00
12-24 UNC	116.00	116.00	0	13.00	245.00
12-28 UNF	116.00	116.00	0	13.00	245.00
12-32 UNEF	141.00	141.00	0	13.00	295.00
1/4-20 UNC	99.00	99.00	1	13.00	211.00
1/4-28 UNF	99.00	99.00	1	13.00	211.00
1/4-32 UNEF	139.00	139.00	1	13.00	291.00
5/16-18 UNC	99.00	99.00	1	13.00	211.00
5/16-24 UNF	99.00	99.00	1	13.00	211.00
5/16-32 UNEF	139.00	139.00	1	13.00	291.00
3/8-16 UNC	101.00	101.00	2	13.00	215.00
3/8-24 UNF	101.00	101.00	2	13.00	215.00
3/8-32 UNEF	162.00	162.00	2	13.00	337.00
7/16-14 UNC	105.00	105.00	2	13.00	223.00
7/16-20 UNF	105.00	105.00	2	13.00	223.00
7/16-28 UNEF	164.00	164.00	2	13.00	341.00
1/2-13 UNC	112.00	112.00	2	13.00	237.00
1/2-20 UNF	112.00	112.00	2	13.00	237.00
1/2-28 UNEF	179.00	179.00	2	13.00	371.00
9/16-12 UNC	128.00	128.00	3	13.00	269.00
9/16-18 UNF	128.00	128.00	3	13.00	269.00
9/16-24 UNEF	192.00	192.00	3	13.00	397.00
5/8-11 UNC	132.00	132.00	3	13.00	277.00
5/8-18 UNF	132.00	132.00	3	13.00	277.00
5/8-24 UNEF	198.00	198.00	3	13.00	409.00

SIZE	2A, 3A GO	2A, 3A NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
11/16-24 UNEF	212.00	212.00	3	13.00	437.00
3/4-10 UNC	154.00	154.00	3	13.00	321.00
3/4-16 UNF	154.00	154.00	3	13.00	321.00
3/4-20 UNEF	204.00	204.00	3	13.00	421.00
13/16-20 UNEF	218.00	218.00	3	13.00	449.00
7/8-9 UNC	178.00	178.00	4	13.00	369.00
7/8-14 UNF	178.00	178.00	4	13.00	369.00
7/8-20 UNEF	223.00	223.00	4	13.00	459.00
15/16-20 UNEF	225.00	225.00	4	13.00	463.00
1"-8 UNC	204.00	204.00	4	13.00	421.00
1"-12 UNF	204.00	204.00	4	13.00	421.00
1"-14 UNS	204.00	204.00	4	13.00	421.00
1"-20 UNEF	236.00	236.00	4	13.00	485.00
1 1/16-12 UN	231.00	231.00	4	13.00	475.00
1 1/16-18 UN	231.00	231.00	4	13.00	475.00
1 1/8-7 UNC	231.00	231.00	4	13.00	475.00
1 1/8-12 UNF	231.00	231.00	4	13.00	475.00
1 1/8-18 UNEF	253.00	253.00	4	13.00	519.00
1 3/16-12 UN	253.00	253.00	5	14.00	520.00
1 3/16-18 UN	253.00	253.00	5	14.00	520.00
1 1/4-7 UNC	259.00	259.00	5	14.00	532.00
1 1/4-12 UNF	259.00	259.00	5	14.00	532.00
1 1/4-18 UNEF	289.00	289.00	5	14.00	592.00
1 5/16-12 UN	295.00	295.00	5	14.00	604.00
1 5/16-18 UN	295.00	295.00	5	14.00	604.00
1 3/8-6 UNC	297.00	297.00	5	14.00	608.00
1 3/8-12 UNF	297.00	297.00	5	14.00	608.00
1 3/8-18 UNEF	307.00	307.00	5	14.00	628.00
1 7/16-12 UN	319.00	319.00	5	14.00	652.00
1 7/16-18 UN	319.00	319.00	5	14.00	652.00
1 1/2-6 UNC	322.00	322.00	5	14.00	658.00
1 1/2-12 UNF	322.00	322.00	5	14.00	658.00
1 1/2-18 UNEF	329.00	329.00	5	14.00	672.00

For class "W" pitch diameters – add 25%.

8, 12 & 16 PITCH THREAD PLUG GAGES



**“UN” Class 2B & 3B
Class “X” Tolerance**

NOMINAL SIZE & PITCH				GO	2B, 3B NOGO	HANDLES		DOUBLE END
						NO.	PRICE	
11/16			16	142.00	142.00	3	13.00	297.00
13/16			16	146.00	146.00	3	13.00	305.00
7/8			16	146.00	146.00	4	13.00	305.00
15/16			16	146.00	146.00	4	13.00	305.00
1"			16	146.00	146.00	4	13.00	305.00
1 1/16			16	146.00	146.00	4	13.00	305.00
1 1/8			16	146.00	146.00	4	13.00	305.00
1 3/16			16	154.00	154.00	5	14.00	322.00
1 1/4			16	154.00	154.00	5	14.00	322.00
1 5/16			16	173.00	173.00	5	14.00	360.00
1 3/8			16	173.00	173.00	5	14.00	360.00
1 7/16			16	179.00	179.00	5	14.00	372.00
1 1/2			16	179.00	179.00	5	14.00	372.00
1 5/8	8	12	16	198.00	198.00	5 1/2	20.00	416.00
1 3/4	8	12	16	213.00	213.00	5 1/2	20.00	446.00
1 7/8	8	12	16	227.00	227.00	5 1/2	20.00	474.00
2"	8	12	16	239.00	239.00	5 1/2	20.00	498.00
2 1/8	8	12	16	252.00	252.00	6	20.00	524.00
2 1/4	8	12	16	252.00	252.00	6	20.00	524.00
2 3/8	8	12	16	274.00	274.00	6	20.00	568.00
2 1/2	8	12	16	274.00	274.00	6	20.00	568.00
2 5/8	8	12	16	298.00	298.00	7	24.00	620.00
2 3/4	8	12	16	298.00	298.00	7	24.00	620.00
2 7/8	8	12	16	326.00	326.00	7	24.00	676.00
3"	8	12	16	326.00	326.00	7	24.00	700.00*
3 1/4	8	12	16	354.00	354.00	7	24.00	756.00*
3 1/2	8	12	16	387.00	387.00	7	24.00	822.00*
3 3/4	8	12	16	412.00	412.00	7	24.00	872.00*
4"	8	12	16	444.00	444.00	7	24.00	936.00*

* 2 Handles

Sizes 11/16" to 1-1/2" are Taperlock.
 Sizes 1-5/8" to 4" are Trilock.
 For plug gages over 4" diameter – call Swanson.

For TiN coated thread plug gages – call Swanson.

8, 12 & 16 Pitch Thread Ring Gages

NOMINAL SIZE & PITCH				2A, 3A GO	2A, 3A NOGO	SET	HOLDER	
							NO.	PRICE
11/16			16	358.00	358.00	716.00	4	31.00
13/16			16	363.00	363.00	726.00	4	31.00
7/8			16	363.00	363.00	726.00	5	43.00
15/16			16	366.00	366.00	732.00	5	43.00
1"			16	366.00	366.00	732.00	5	43.00
1 1/16			16	372.00	372.00	744.00	5	43.00
1 1/8			16	372.00	372.00	744.00	5	43.00
1 3/16			16	385.00	385.00	770.00	6	55.00
1 1/4			16	385.00	385.00	770.00	6	55.00
1 5/16			16	401.00	401.00	802.00	6	55.00
1 3/8			16	401.00	401.00	802.00	6	55.00
1 7/16			16	427.00	427.00	854.00	6	55.00
1 1/2			16	427.00	427.00	854.00	6	55.00
1 5/8	8	12	16	445.00	445.00	890.00		
1 3/4	8	12	16	472.00	472.00	944.00		
1 7/8	8	12	16	490.00	490.00	980.00		
2"	8	12	16	519.00	519.00	1038.00		
2 1/8	8	12	16	553.00	553.00	1106.00		
2 1/4	8	12	16	553.00	553.00	1106.00		
2 3/8	8	12	16	583.00	583.00	1166.00		
2 1/2	8	12	16	583.00	583.00	1166.00		



**“UN” Class 2A & 3A
Class “X” Tolerance
Precision Lapped**

For ring gages over 2-1/2" –
call Swanson.

8, 12 & 16 Pitch Truncated Setting Plug Gages

NOMINAL SIZE & PITCH				2A, 3A GO	2A, 3A NOGO	SET	HANDLES	
							NO.	PRICE
11/16			16	192.00	192.00	3	13.00	397.00
13/16			16	209.00	209.00	3	13.00	431.00
7/8			16	209.00	209.00	4	13.00	431.00
15/16			16	234.00	234.00	4	13.00	481.00
1"			16	234.00	234.00	4	13.00	481.00
1 1/16			16	246.00	246.00	4	13.00	505.00
1 1/8			16	246.00	246.00	4	13.00	505.00
1 3/16			16	281.00	281.00	5	14.00	576.00
1 1/4			16	281.00	281.00	5	14.00	576.00
1 5/16			16	305.00	305.00	5	14.00	624.00
1 3/8			16	305.00	305.00	5	14.00	624.00
1 7/16			16	318.00	318.00	5	14.00	650.00
1 1/2			16	318.00	318.00	5	14.00	650.00
1 5/8	8	12	16	340.00	340.00	5 1/2	20.00	700.00
1 3/4	8	12	16	343.00	343.00	5 1/2	20.00	706.00
1 7/8	8	12	16	352.00	352.00	5 1/2	20.00	724.00
2"	8	12	16	361.00	361.00	5 1/2	20.00	742.00
2 1/8	8	12	16	373.00	373.00	6	20.00	766.00
2 1/4	8	12	16	373.00	373.00	6	20.00	766.00
2 3/8	8	12	16	415.00	415.00	6	20.00	850.00
2 1/2	8	12	16	415.00	415.00	6	20.00	850.00



**“UN” Class 2A & 3A
Class “X” Pitch
Diameters**

**“W” Lead & Angles
Precision Lapped**

Sizes 11/16" to 1-1/2" are Taperlock.

Sizes 1-5/8" to 2-1/2" are Trilock.

For Setting Plug Gages over
2-1/2" – call Swanson.

Helical Coil (STI) Thread Plug Gages



**Class "X" Tolerance
Precision Lapped**

NOMINAL SIZE	REGULAR TOOL STEEL			TIN COATED HIGH SPEED STEEL			HANDLES	
	GO	2B, 3B NOGO	DOUBLE END	GO	2B, 3B NOGO	DOUBLE END	NO.	PRICE
2-56 UNC	78.00	78.00	169.00	150.00	150.00	313.00	00	13.00
4-40 UNC	69.00	69.00	151.00	132.00	132.00	277.00	00	13.00
4-48 UNF	69.00	69.00	151.00	217.00	217.00	447.00	00	13.00
5-40 UNC	69.00	69.00	151.00	217.00	217.00	447.00	0	13.00
6-32 UNC	69.00	69.00	151.00	132.00	132.00	277.00	0	13.00
6-40 UNF	69.00	69.00	151.00	217.00	217.00	447.00	0	13.00
8-32 UNC	65.00	65.00	143.00	128.00	128.00	269.00	0	13.00
8-36 UNF	65.00	65.00	143.00	205.00	205.00	423.00	0	13.00
10-24 UNC	65.00	65.00	143.00	195.00	195.00	403.00	0	13.00
10-32 UNF	65.00	65.00	143.00	128.00	128.00	269.00	0	13.00
12-24 UNC	65.00	65.00	143.00	205.00	205.00	423.00	1	13.00
1/4-20 UNC	65.00	65.00	143.00	191.00	191.00	395.00	1	13.00
1/4-28 UNF	65.00	65.00	143.00	126.00	126.00	265.00	1	13.00
5/16-18 UNC	65.00	65.00	143.00	191.00	191.00	395.00	2	13.00
5/16-24 UNF	65.00	65.00	143.00	126.00	126.00	265.00	1	13.00
3/8-16 UNC	67.00	67.00	147.00	202.00	202.00	417.00	2	13.00
3/8-24 UNF	67.00	67.00	147.00	128.00	128.00	269.00	2	13.00
7/16-14 UNC	69.00	69.00	151.00	202.00	202.00	417.00	3	13.00
7/16-20 UNF	69.00	69.00	151.00	202.00	202.00	417.00	2	13.00
1/2-13 UNC	74.00	74.00	161.00	202.00	202.00	417.00	3	13.00
1/2-20 UNF	74.00	74.00	161.00	202.00	202.00	417.00	3	13.00
9/16-12 UNC	86.00	86.00	185.00	202.00	202.00	417.00	3	13.00
9/16-18 UNF	86.00	86.00	185.00	202.00	202.00	417.00	3	13.00
5/8-11 UNC	86.00	86.00	185.00	216.00	216.00	445.00	3	13.00
5/8-18 UNF	86.00	86.00	185.00	216.00	216.00	445.00	3	13.00
3/4-10 UNC	92.00	92.00	197.00	244.00	244.00	501.00	4	13.00
3/4-16 UNF	92.00	92.00	197.00	244.00	244.00	501.00	3	13.00

For class "W" pitch diameters – call Swanson.

For chrome plate (on regular steel only) – add 30%.

Left Hand Thread Work Plugs 2B & 3B



SIZE & PITCH			GO	2B, 3B NOGO	HANDLES		DOUBLE END
					NO.	PRICE	
4	40	48	145.00	145.00	00	13.00	303.00
5	40	44	145.00	145.00	00	13.00	303.00
6	32	40	145.00	145.00	00	13.00	303.00
8	32	36	134.00	134.00	0	13.00	281.00
10	24	32	134.00	134.00	0	13.00	281.00
12	24	28	134.00	134.00	0	13.00	281.00
1/4	20	28	131.00	131.00	1	13.00	275.00
5/16	18	24	131.00	131.00	1	13.00	275.00
3/8	16	24	131.00	131.00	2	13.00	275.00
7/16	14	20	131.00	131.00	2	13.00	275.00
1/2	13	20	131.00	131.00	2	13.00	275.00
9/16	12	18	131.00	131.00	3	13.00	275.00
5/8	11	18	134.00	134.00	3	13.00	281.00
3/4	10	16	142.00	142.00	3	13.00	297.00

For chrome plate – add 30%.

For TiN coated prices – call Swanson.

Left Hand Thread Rings 2A & 3A



SIZE & PITCH			GO 2A, 3A	NOGO 2A, 3A	SET	HOLDERS	
						NO.	PRICE
4	40	48	315.00	315.00	630.00	1	23.00
5	40	44	303.00	303.00	606.00	1	23.00
6	32	40	290.00	290.00	580.00	1	23.00
8	32	36	268.00	268.00	536.00	1	23.00
10	24	32	268.00	268.00	536.00	1	23.00
12	24	28	268.00	268.00	536.00	1	23.00
1/4	20	28	337.00	337.00	674.00	2	24.00
5/16	18	24	337.00	337.00	674.00	2	24.00
3/8	16	24	339.00	339.00	678.00	3	25.00
7/16	14	20	339.00	339.00	678.00	3	25.00
1/2	13	20	339.00	339.00	678.00	3	25.00
9/16	12	18	349.00	349.00	698.00	4	31.00
5/8	11	18	358.00	358.00	716.00	4	31.00
3/4	10	16	358.00	358.00	716.00	4	31.00

Chrome plate for 1/4" & larger – add 25%.

Left Hand Thread Setting Plugs 2A & 3A

SIZE & PITCH			GO 2A, 3A	NOGO 2A, 3A	HANDLES		DOUBLE END
					NO.	PRICE	
4	40	48	209.00	209.00	00	13.00	431.00
5	40	44	209.00	209.00	00	13.00	431.00
6	32	40	209.00	209.00	00	13.00	431.00
8	32	36	192.00	192.00	0	13.00	397.00
10	24	32	192.00	192.00	0	13.00	397.00
12	24	28	192.00	192.00	0	13.00	397.00
1/4	20	28	180.00	180.00	1	13.00	373.00
5/16	18	24	180.00	180.00	1	13.00	373.00
3/8	16	24	180.00	180.00	2	13.00	373.00
7/16	14	20	180.00	180.00	2	13.00	373.00
1/2	13	20	180.00	180.00	2	13.00	373.00
9/16	12	18	180.00	180.00	3	13.00	373.00
5/8	11	18	187.00	187.00	3	13.00	387.00
3/4	10	16	192.00	192.00	3	13.00	397.00

For class "W" pitch diameters – add 25%.



**Class "X" Tolerance
Precision Lapped**

Inch Reversible Thread Plug Gages

SIZE	GO	2B, 3B NOGO	HANDLES		DOUBLE END
			NO.	PRICE	
0-80 UNF	95.00	95.00	1W	15.00	205.00
1-64 UNC	95.00	95.00	1W	15.00	205.00
1-72 UNF	95.00	95.00	1W	15.00	205.00
2-56 UNC	86.00	86.00	2W	15.00	187.00
2-64 UNF	86.00	86.00	2W	15.00	187.00
3-48 UNC	84.00	84.00	2W	15.00	183.00
3-56 UNF	84.00	84.00	2W	15.00	183.00
4-40 UNC	78.00	78.00	2W	15.00	171.00
4-48 UNF	78.00	78.00	2W	15.00	171.00
5-40 UNC	70.00	70.00	2W	15.00	155.00
5-44 UNF	70.00	70.00	2W	15.00	155.00
6-32 UNC	70.00	70.00	2W	15.00	155.00
6-40 UNF	70.00	70.00	2W	15.00	155.00
8-32 UNC	70.00	70.00	2W	15.00	155.00
8-36 UNF	70.00	70.00	2W	15.00	155.00
10-24 UNC	70.00	70.00	3W	17.00	157.00
10-32 UNF	70.00	70.00	3W	17.00	157.00
12-24 UNC	70.00	70.00	3W	17.00	157.00
12-28 UNF	70.00	70.00	3W	17.00	157.00
1/4-20 UNC	65.00	65.00	3W	17.00	147.00
1/4-28 UNF	65.00	65.00	3W	17.00	147.00
5/16-18 UNC	65.00	65.00	4W	19.00	149.00
5/16-24 UNF	65.00	65.00	4W	19.00	149.00
3/8-16 UNC	70.00	70.00	4W	19.00	159.00
3/8-24 UNF	70.00	70.00	4W	19.00	159.00
7/16-14 UNC	70.00	70.00	5W	19.00	159.00
7/16-20 UNF	70.00	70.00	5W	19.00	159.00
1/2-13 UNC	70.00	70.00	5W	19.00	159.00
1/2-20 UNF	70.00	70.00	5W	19.00	159.00
9/16-12 UNC	82.00	82.00	6W	20.00	184.00
9/16-18 UNF	82.00	82.00	6W	20.00	184.00
5/8-11 UNC	82.00	82.00	6W	20.00	184.00
5/8-18 UNF	82.00	82.00	6W	20.00	184.00
3/4-10 UNC	91.00	91.00	7W	22.00	204.00
3/4-16 UNF	91.00	91.00	7W	22.00	204.00

For chrome plate – add 30%.

TiN coated available for #4 and larger.

Metric Reversible Thread Plug Gages

METRIC SIZE	6H GO	6H NO GO	HANDLES		DOUBLE END
			NO.	PRICE	
M1.6 x 0.35	109.00	109.00	1W	15.00	221.00
M2 x 0.4	103.00	103.00	2W	15.00	221.00
M2.5 x 0.45	103.00	103.00	2W	15.00	221.00
M3 x 0.5	88.00	88.00	2W	15.00	191.00
M3.5 x 0.6	80.00	80.00	2W	15.00	175.00
M4 x 0.7	80.00	80.00	2W	15.00	175.00
M5 x 0.8	80.00	80.00	3W	17.00	177.00
M6 x 1.0	70.00	70.00	3W	17.00	157.00
M8 x 1.25	70.00	70.00	4W	19.00	159.00
M8 x 1.0	70.00	70.00	4W	19.00	159.00
M10 x 1.5	71.00	71.00	4W	19.00	161.00
M10 x 1.25	71.00	71.00	4W	19.00	161.00
M12 x 1.75	74.00	74.00	5W	19.00	167.00
M12 x 1.5	74.00	74.00	5W	19.00	167.00
M12 x 1.25	74.00	74.00	5W	19.00	167.00
M12 x 1.0	88.00	88.00	5W	19.00	195.00
M14 x 2.0	85.00	85.00	6W	20.00	190.00
M14 x 1.5	85.00	85.00	6W	20.00	190.00
M16 x 2.0	88.00	88.00	7W	22.00	198.00
M16 x 1.5	88.00	88.00	7W	22.00	198.00
M18 x 1.5	97.00	97.00	7W	22.00	216.00

For chrome plate – add 30%.

TiN coated available for M3 and larger.



**Class "X" Tolerance
Precision Lapped**

Metric Thread Plug Gages – Regular & TiN Coated

METRIC SIZE	REGULAR TOOL STEEL			TIN COATED HIGH SPEED STEEL			HANDLES	
	6H GO	6H NOGO	DOUBLE END	6H GO	6H NOGO	DOUBLE END	NO.	PRICE
	M1.6 x 0.35	72.00	72.00	157.00	158.00	158.00	329.00	000
M1.8 x 0.35	72.00	72.00	157.00	257.00	257.00	527.00	000	13.00
M2 x 0.4	72.00	72.00	157.00	149.00	149.00	311.00	000	13.00
M2.2 x 0.45	72.00	72.00	157.00	257.00	257.00	527.00	000	13.00
M2.5 x 0.45	65.00	65.00	143.00	140.00	140.00	293.00	00	13.00
M3 x 0.5	65.00	65.00	143.00	134.00	134.00	281.00	00	13.00
M3.5 x 0.6	57.00	57.00	127.00	217.00	217.00	447.00	00	13.00
M4 x 0.7	57.00	57.00	127.00	115.00	115.00	243.00	0	13.00
M4.5 x 0.75	57.00	57.00	127.00	205.00	205.00	423.00	0	13.00
M5 x 0.8	57.00	57.00	127.00	115.00	115.00	243.00	0	13.00
M6 x 1.0	47.00	47.00	107.00	102.00	102.00	217.00	1	13.00
M7 x 1.0	47.00	47.00	107.00	202.00	202.00	417.00	1	13.00
M8 x 1.25	47.00	47.00	107.00	102.00	102.00	217.00	1	13.00
M8 x 1.0	47.00	47.00	107.00	102.00	102.00	217.00	1	13.00
M10 x 1.5	50.00	50.00	113.00	113.00	113.00	239.00	2	13.00
M10 x 1.25	50.00	50.00	113.00	113.00	113.00	239.00	2	13.00
M10 x 1.0	60.00	60.00	133.00	154.00	154.00	321.00	2	13.00
M10 x 0.75	60.00	60.00	133.00	246.00	246.00	505.00	2	13.00
M12 x 1.75	55.00	55.00	123.00	123.00	123.00	259.00	2	13.00
M12 x 1.5	55.00	55.00	123.00	123.00	123.00	259.00	2	13.00
M12 x 1.25	55.00	55.00	123.00	123.00	123.00	259.00	2	13.00
M12 x 1.0	62.00	62.00	137.00	168.00	168.00	349.00	2	13.00
M14 x 2.0	60.00	60.00	133.00	202.00	202.00	417.00	3	13.00
M14 x 1.5	60.00	60.00	133.00	202.00	202.00	417.00	3	13.00
M15 x 1.0	65.00	65.00	143.00	238.00	238.00	489.00	3	13.00
M16 x 2.0	62.00	62.00	137.00	216.00	216.00	445.00	3	13.00
M16 x 1.5	62.00	62.00	137.00	216.00	216.00	445.00	3	13.00
M17 x 1.0	68.00	68.00	149.00	262.00	262.00	537.00	3	13.00
M18 x 2.5	70.00	70.00	153.00	244.00	244.00	501.00	3	13.00
M18 x 1.5	70.00	70.00	153.00	244.00	244.00	501.00	3	13.00
M20 x 2.5	78.00	78.00	169.00	256.00	256.00	525.00	3	13.00
M20 x 1.5	78.00	78.00	169.00	256.00	256.00	525.00	3	13.00
M20 x 1.0	92.00	92.00	197.00	274.00	274.00	561.00	3	13.00
M22 x 2.5	78.00	78.00	169.00	267.00	267.00	547.00	4	13.00
M22 x 1.5	78.00	78.00	169.00	267.00	267.00	547.00	4	13.00
M24 x 3.0	86.00	86.00	185.00	287.00	287.00	587.00	4	13.00
M24 x 2.0	86.00	86.00	185.00	287.00	287.00	587.00	4	13.00
M27 x 3.0	115.00	115.00	243.00	300.00	300.00	613.00	4	13.00
M27 x 2.0	115.00	115.00	243.00	300.00	300.00	613.00	4	13.00
M30 x 3.5	156.00	156.00	326.00	363.00	363.00	740.00	5	14.00
M30 x 2.0	146.00	146.00	306.00	342.00	342.00	698.00	5	14.00
M30 x 1.5	146.00	146.00	306.00	342.00	342.00	698.00	5	14.00
M33 x 3.5	146.00	146.00	306.00	382.00	382.00	778.00	5	14.00
M33 x 2.0	146.00	146.00	306.00	374.00	374.00	762.00	5	14.00
M35 x 1.5	164.00	164.00	342.00	374.00	374.00	762.00	5	14.00
M36 x 4.0	173.00	173.00	360.00	418.00	418.00	850.00	5	14.00
M36 x 3.0	173.00	173.00	360.00	397.00	397.00	808.00	5	14.00
M36 x 2.0	173.00	173.00	360.00	397.00	397.00	808.00	5	14.00
M39 x 4.0	192.00	192.00	404.00	390.00	390.00	800.00	5 1/2	20.00
M39 x 3.0	192.00	192.00	404.00	378.00	378.00	776.00	5 1/2	20.00
M39 x 2.0	192.00	192.00	404.00	365.00	365.00	750.00	5 1/2	20.00



Class “X” Tolerance Precision Lapped

Metric gages made to ANSI B1.16 dimensions.

Blanks conform to ANSI B47.1 dimensions.

For chrome plate (on regular steel) – add 30%.

Metric Thread Rings



Class "X" Tolerance, Precision Lapped

METRIC SIZE	6g GO	6g NO GO	SET	HOLDERS	
				NO.	PRICE
M1.6 x 0.35	219.00	219.00	438.00	1	23.00
M1.8 x 0.35	219.00	219.00	438.00	1	23.00
M2 x 0.4	189.00	189.00	378.00	1	23.00
M2.2 x 0.45	189.00	189.00	378.00	1	23.00
M2.5 x 0.45	189.00	189.00	378.00	1	23.00
M3 x 0.5	162.00	162.00	324.00	1	23.00
M3.5 x 0.6	162.00	162.00	324.00	1	23.00
M4 x 0.7	157.00	157.00	314.00	1	23.00
M4.5 x 0.75	157.00	157.00	314.00	1	23.00
M5 x 0.8	157.00	157.00	314.00	1	23.00
M6 x 1.0	139.00	139.00	278.00	2	24.00
M7 x 1.0	139.00	139.00	278.00	2	24.00
M8 x 1.25	139.00	139.00	278.00	2	24.00
M8 x 1.0	139.00	139.00	278.00	2	24.00
M10 x 1.5	150.00	150.00	300.00	3	25.00
M10 x 1.25	150.00	150.00	300.00	3	25.00
M10 x 1.0	158.00	158.00	316.00	3	25.00
M10 x 0.75	158.00	158.00	316.00	3	25.00
M12 x 1.75	161.00	161.00	322.00	3	25.00
M12 x 1.5	161.00	161.00	322.00	3	25.00
M12 x 1.25	161.00	161.00	322.00	3	25.00
M12 x 1.0	180.00	180.00	360.00	3	25.00
M14 x 2.0	180.00	180.00	360.00	4	31.00
M14 x 1.5	180.00	180.00	360.00	4	31.00
M15 x 1.0	180.00	180.00	360.00	4	31.00
M16 x 2.0	180.00	180.00	360.00	4	31.00
M16 x 1.5	180.00	180.00	360.00	4	31.00
M17 x 1.0	244.00	244.00	488.00	4	31.00

METRIC SIZE	6g GO	6g NO GO	SET	HOLDERS	
				NO.	PRICE
M18 x 2.5	251.00	251.00	502.00	4	31.00
M18 x 1.5	251.00	251.00	502.00	4	31.00
M20 x 2.5	304.00	304.00	608.00	4	31.00
M20 x 1.5	304.00	304.00	608.00	4	31.00
M20 x 1.0	318.00	318.00	636.00	4	31.00
M22 x 2.5	296.00	296.00	592.00	5	43.00
M22 x 1.5	296.00	296.00	592.00	5	43.00
M24 x 3.0	343.00	343.00	686.00	5	43.00
M24 x 2.0	343.00	343.00	686.00	5	43.00
M27 x 3.0	357.00	357.00	714.00	5	43.00
M27 x 2.0	357.00	357.00	714.00	5	43.00
M30 x 3.5	385.00	385.00	770.00	6	55.00
M30 x 2.0	361.00	361.00	722.00	6	55.00
M30 x 1.5	361.00	361.00	722.00	6	55.00
M33 x 3.5	417.00	417.00	834.00	6	55.00
M33 x 2.0	401.00	401.00	802.00	6	55.00
M35 x 1.5	427.00	427.00	854.00	6	55.00
M36 x 4.0	464.00	464.00	928.00	6	55.00
M36 x 3.0	464.00	464.00	928.00	6	55.00
M36 x 2.0	464.00	464.00	928.00	6	55.00
M39 x 4.0	474.00	474.00	948.00	6	55.00
M39 x 3.0	474.00	474.00	948.00	6	55.00
M39 x 2.0	474.00	474.00	948.00	6	55.00

Metric gages made to ANSI B1.16 dimensions.
Blanks conform to ANSI B47.1 dimensions.
For chrome plate for M6 and larger – add 50%.

Metric Thread Setting Plugs



Class "X" Pitch Diameters "W" Lead & Angles, Precision Lapped

METRIC SIZE	6g GO	6g NO GO	HANDLES		DOUBLE END
			NO.	PRICE	
M1.6 x 0.35	156.00	156.00	000	13.00	325.00
M1.8 x 0.35	156.00	156.00	000	13.00	325.00
M2 x 0.4	142.00	142.00	000	13.00	297.00
M2.2 x 0.45	142.00	142.00	000	13.00	297.00
M2.5 x 0.45	142.00	142.00	00	13.00	297.00
M3 x 0.5	135.00	135.00	00	13.00	283.00
M3.5 x 0.6	135.00	135.00	00	13.00	283.00
M4 x 0.7	132.00	132.00	0	13.00	277.00
M4.5 x 0.75	132.00	132.00	0	13.00	277.00
M5 x 0.8	132.00	132.00	0	13.00	277.00
M6 x 1.0	123.00	123.00	1	13.00	259.00
M7 x 1.0	123.00	123.00	1	13.00	259.00
M8 x 1.25	123.00	123.00	1	13.00	259.00
M8 x 1.0	123.00	123.00	1	13.00	259.00
M10 x 1.5	130.00	130.00	2	13.00	273.00
M10 x 1.25	130.00	130.00	2	13.00	273.00
M10 x 1.0	140.00	140.00	2	13.00	293.00
M10 x 0.75	140.00	140.00	2	13.00	293.00
M12 x 1.75	135.00	135.00	2	13.00	283.00
M12 x 1.5	135.00	135.00	2	13.00	283.00
M12 x 1.25	135.00	135.00	2	13.00	283.00
M12 x 1.0	142.00	142.00	2	13.00	297.00
M14 x 2.0	159.00	159.00	3	13.00	331.00
M14 x 1.5	159.00	159.00	3	13.00	331.00
M15 x 1.0	159.00	159.00	3	13.00	331.00
M16 x 2.0	159.00	159.00	3	13.00	331.00
M16 x 1.5	159.00	159.00	3	13.00	331.00
M17 x 1.0	180.00	180.00	3	13.00	373.00

METRIC SIZE	6g GO	6g NO GO	HANDLES		DOUBLE END
			NO.	PRICE	
M18 x 2.5	173.00	173.00	3	13.00	359.00
M18 x 1.5	173.00	173.00	3	13.00	359.00
M20 x 2.5	174.00	174.00	3	13.00	361.00
M20 x 1.5	174.00	174.00	3	13.00	361.00
M20 x 1.0	200.00	200.00	3	13.00	413.00
M22 x 2.5	228.00	228.00	4	13.00	469.00
M22 x 1.5	228.00	228.00	4	13.00	469.00
M24 x 3.0	233.00	233.00	4	13.00	479.00
M24 x 2.0	233.00	233.00	4	13.00	479.00
M27 x 3.0	249.00	249.00	4	13.00	511.00
M27 x 2.0	249.00	249.00	4	13.00	511.00
M30 x 3.5	272.00	272.00	5	14.00	558.00
M30 x 2.0	252.00	252.00	5	14.00	518.00
M30 x 1.5	252.00	252.00	5	14.00	518.00
M33 x 3.5	293.00	293.00	5	14.00	600.00
M33 x 2.0	293.00	293.00	5	14.00	600.00
M35 x 1.5	302.00	302.00	5	14.00	618.00
M36 x 4.0	316.00	316.00	5	14.00	646.00
M36 x 3.0	316.00	316.00	5	14.00	646.00
M36 x 2.0	316.00	316.00	5	14.00	646.00
M39 x 4.0	350.00	350.00	5 1/2	20.00	720.00
M39 x 3.0	350.00	350.00	5 1/2	20.00	720.00
M39 x 2.0	350.00	350.00	5 1/2	20.00	720.00

Metric gages made to ANSI B1.16 dimensions.
Blanks conform to ANSI B47.1 dimensions.
For class "W" pitch diameters – add 25%.

Taper Pipe Plug Gages

SIZE	NPT L1	NPTF L1	NPTF L3	NPTF 6-STEP PLAIN	ANPT L1	ANPT L3	ANPT 6-STEP PLAIN	HANDLE	
								NO.	PRICE
1/16-27	123.00	158.00	165.00	233.00	179.00	187.00	227.00	1	13.00
1/8-27	97.00	127.00	134.00	233.00	128.00	135.00	227.00	2	13.00
1/4-18	102.00	133.00	139.00	233.00	149.00	156.00	227.00	3	13.00
3/8-18	111.00	158.00	167.00	233.00	179.00	184.00	227.00	3	13.00
1/2-14	127.00	182.00	188.00	233.00	193.00	199.00	227.00	4	13.00
3/4-14	144.00	201.00	210.00	249.00	210.00	217.00	238.00	4	13.00
1"-11 1/2	161.00	222.00	232.00	269.00	240.00	245.00	272.00	5	14.00
1 1/4-11 1/2	179.00	250.00	250.00	296.00	260.00	260.00	287.00	5	14.00
1 1/2-11 1/2	202.00	284.00	284.00	334.00	293.00	293.00	313.00	5	14.00
2"-11 1/2	246.00	329.00	329.00	451.00	341.00	341.00	437.00	5	14.00
2 1/2-8	295.00	522.00	522.00	693.00	546.00	546.00	670.00	6	20.00
3"-8	356.00	588.00	588.00	760.00	643.00	643.00	799.00	6	20.00
3 1/2-8	526.00							7	24.00
4"-8	603.00							7	24.00
5"-8	824.00							7	24.00
6"-8	983.00							7	24.00



NPT and NPTF plug gages are single step.
 For NPT or NPTF 2-step or 3-step design – add \$40.00 per step.
 ANPT L1 & L3 plug gages are 1-step design per SAE AS71051.

For TiN coated Pipe Plug prices – call Swanson.

Taper Pipe Ring Gages

SIZE	NPT L1	NPTF L1 THIN	NPTF L2 THICK	NPTF 6-STEP PLAIN	ANPT L1 THIN	ANPT L2 THICK	ANPT 6-STEP PLAIN
1/16-27	249.00	260.00	362.00	434.00	370.00	434.00	490.00
1/8-27	189.00	227.00	337.00	434.00	323.00	393.00	490.00
1/4-18	189.00	216.00	362.00	434.00	315.00	406.00	490.00
3/8-18	201.00	212.00	352.00	434.00	315.00	396.00	490.00
1/2-14	227.00	235.00	367.00	434.00	284.00	412.00	490.00
3/4-14	253.00	262.00	408.00	484.00	308.00	453.00	548.00
1"-11 1/2	289.00	305.00	443.00	484.00	398.00	492.00	548.00
1 1/4-11 1/2	320.00	325.00	481.00	528.00	398.00	532.00	598.00
1 1/2-11 1/2	379.00	390.00	526.00	607.00	434.00	585.00	685.00
2"-11 1/2	452.00	551.00	608.00	678.00	625.00	676.00	765.00
2 1/2-8	529.00	597.00	727.00	802.00	666.00	809.00	906.00
3"-8	666.00	679.00	861.00	982.00	759.00	960.00	1107.00
3 1/2-8	935.00						
4"-8	1072.00						
5"-8	1286.00						
6"-8	1523.00						



N.P.T. – American National Pipe Thread Series
N.P.T.F. – National Taper Pipe Dryseal Series
A.N.P.T. – Aeronautical Tapered Pipe Thread Series
 For Master Plug and Ring prices – call Swanson.

NPSM Straight Pipe Thread Gages



SIZE	WORK PLUGS NPSM-2B				SET PLUGS NPSM-2A				RINGS NPSM-2A	
	GO or NOGO	HANDLE		DOUBLE END	GO or NOGO	HANDLE		DOUBLE END	GO or NOGO	SET
		NO.	PRICE			NO.	PRICE			
1/8-27	145.00	2	13.00	303.00	180.00	2	13.00	373.00	363.00	726.00
1/4-18	131.00	3	13.00	275.00	180.00	3	13.00	373.00	349.00	698.00
3/8-18	142.00	3	13.00	297.00	192.00	3	13.00	397.00	358.00	716.00
1/2-14	146.00	4	13.00	305.00	209.00	4	13.00	431.00	363.00	726.00
3/4-14	146.00	4	13.00	305.00	246.00	4	13.00	505.00	372.00	744.00
1"-11 1/2	173.00	5	14.00	360.00	305.00	5	14.00	624.00	401.00	802.00
1 1/4-11 1/2	213.00	5 1/2	20.00	446.00	343.00	5 1/2	20.00	706.00	472.00	944.00
1 1/2-11 1/2	239.00	5 1/2	20.00	498.00	361.00	5 1/2	20.00	742.00	519.00	1038.00
2" 11-1/2	274.00	6	20.00	568.00	415.00	6	20.00	850.00	583.00	1166.00
2 1/2-8	326.00	7	24.00	700.00*	470.00	7	24.00	988.00*	690.00	1380.00
3"-8	412.00	7	24.00	872.00*	581.00	7	24.00	1210.00*	861.00	1722.00

For chrome plate: work plugs – add 30%.
rings – add 50%.

* 2 Handles

For TiN coated thread work plugs – call Swanson.

NPSF Straight Pipe Thread Plug Gages

SIZE	GO or NOGO	HANDLE		DOUBLE END
		NO.	PRICE	
1/16-27	131.00	1	13.00	275.00
1/8-27	145.00	2	13.00	303.00
1/4-18	131.00	3	13.00	275.00
3/8-18	142.00	3	13.00	297.00
1/2-14	146.00	4	13.00	305.00
3/4-14	146.00	4	13.00	305.00
1" 11 1/2	173.00	5	14.00	360.00



For chrome plate – add 30%

For TiN coated thread plug gages – call Swanson.

BSPP (Modified) Parallel Pipe Thread Gages

SIZE	WORK PLUGS "G"				SET PLUGS "G" - CLASS "B"				RINGS- CLASS "B"	
	GO or NOGO	HANDLE		DOUBLE END	GO or NOGO	HANDLE		DOUBLE END	GO or NOGO	SET
		NO.	PRICE			NO.	PRICE			
1/16-28	131.00	1	13.00	275.00	180.00	1	13.00	373.00	337.00	674.00
1/8-28	145.00	2	13.00	303.00	180.00	2	13.00	373.00	363.00	726.00
1/4-19	131.00	3	13.00	275.00	180.00	3	13.00	373.00	369.00	738.00
3/8-19	155.00	3	13.00	323.00	218.00	3	13.00	449.00	372.00	744.00
1/2-14	146.00	4	13.00	305.00	209.00	4	13.00	431.00	363.00	726.00
3/4-14	146.00	4	13.00	305.00	246.00	4	13.00	505.00	372.00	744.00
1"-11	173.00	5	14.00	360.00	305.00	5	14.00	624.00	401.00	802.00
1 1/4-11	213.00	5 1/2	20.00	446.00	343.00	5 1/2	20.00	706.00	472.00	944.00
1 1/2-11	239.00	5 1/2	20.00	498.00	361.00	5 1/2	20.00	742.00	519.00	1038.00
2"-11	274.00	6	20.00	568.00	415.00	6	20.00	850.00	583.00	1166.00
2 1/2-11	326.00	7	24.00	700.00*	470.00	7	24.00	988.00*	690.00	1380.00
3"-11	412.00	7	24.00	872.00*	581.00	7	24.00	1162.00*	861.00	1722.00

* 2 Handles

Note:

- 55° Whitworth thread form, modified with truncated crest and cleared root, for the inspection of product threads to ISO228-1 or BS2779.
- G (internal and external straight).
- There are two classes of external threads: "A" (close fit) and "B" (free fit). Class "B" is used unless Class "A" is specified. Call for Class "A" ring and set plug gage pricing.

For TiN coated thread work plugs – call Swanson.



BSPT (Modified) Taper Pipe Thread Gages

SIZE	WORK PLUGS "Rc" or "Rp" - SYSTEM "A"				RINGS "R" SYSTEM "A"
	WORK PLUG ONLY	HANDLE		WORK PLUG WITH HANDLE	
		NO.	PRICE		
1/16-28	237.00	1	13.00	250.00	CALL FACTORY
1/8-28	258.00	2	13.00	271.00	
1/4-19	237.00	3	13.00	250.00	
3/8-19	273.00	3	13.00	286.00	
1/2-14	259.00	4	13.00	272.00	
3/4-14	259.00	4	13.00	272.00	
1"-11	300.00	5	14.00	314.00	
1 1/4-11	360.00	5	14.00	374.00	
1 1/2-11	399.00	5	14.00	413.00	
2"-11	451.00	5	14.00	465.00	
2 1/2-11	529.00	6	20.00	549.00	
3"-11	658.00	6	20.00	678.00	



Note:

- 55° Whitworth thread form, modified with truncated crest and cleared root, to BS21. For the inspection of product threads to BS21, BS EN10226-1, and ISO7-1.
- Rc (internal taper), Rp (internal straight) and R (external taper).
- Call for system "B" gage pricing.
- Plug gages have one step at basic gage plane.

For TiN coated thread work plugs – call Swanson.

Flexible Hole Location Gages

INCH	
SIZE	PRICE
0-80 UNF	219.00
1-64 UNC	207.00
1-72 UNF	215.00
2-56 UNC	201.00
2-64 UNF	207.00
3-48 UNC	193.00
3-56 UNF	201.00
4-40 UNC	168.00
4-48 UNF	176.00
5-40 UNC	179.00
5-44 UNF	170.00
6-32 UNC	181.00
6-40 UNF	183.00
8-32 UNC	171.00
8-36 UNF	179.00
10-24 UNC	170.00
10-32 UNF	171.00
12-24 UNC	168.00
12-28 UNF	170.00
1/4-20 UNC	145.00
1/4-28 UNF	148.00
5/16-18 UNC	145.00
5/16-24 UNF	148.00
3/8-16 UNC	160.00
3/8-24 UNF	161.00
7/16-14 UNC	154.00
7/16-20 UNF	161.00
1/2-13 UNC	164.00
1/2-20 UNF	170.00
9/16-12 UNC	161.00
9/16-18 UNF	170.00
5/8-11 UNC	168.00
5/8-18 UNF	175.00
3/4-10 UNC	175.00
3/4-16 UNF	179.00
7/8-9 UNC	204.00
7/8-14 UNF	215.00
1"-8 UNC	291.00
1"-12 UNF	291.00

METRIC	
SIZE	PRICE
M1.6 x 0.35	237.00
M2 x 0.4	227.00
M2.5 x 0.45	227.00
M3 x 0.5	222.00
M3.5 x 0.6	222.00
M4 x 0.7	215.00
M5 x 0.8	198.00
M6 x 1.0	176.00
M8 x 1.25	175.00
M8 x 1.0	175.00
M10 x 1.5	182.00
M10 x 1.25	183.00
M10 x 0.75	248.00
M12 x 1.75	193.00
M12 x 1.5	193.00
M12 x 1.25	198.00
M12 x 1.0	198.00
M14 x 2.0	204.00
M14 x 1.5	204.00
M15 x 1.0	204.00
M16 x 2.0	204.00
M16 x 1.5	215.00
M17 x 1.0	219.00
M18 x 1.5	219.00
M20 x 2.5	219.00
M20 x 1.5	222.00
M20 x 1.0	222.00
M22 x 2.5	241.00
M22 x 1.5	241.00
M24 x 3.0	263.00
M24 x 2.0	263.00



Hole Location Gages (also referred to as Centerline Hole Location Plugs, or Flex Plugs) are used to measure the location of a tapped hole in a part, typically with a CMM. They are also used to determine centerline to centerline distances of threaded holes.

- Slotted at 90° increments to ensure positive location on the thread flanks, regardless of hole size (sizes over #10 or M5)
- Sizes #10 (M5) and smaller are solid with a front tapered thread section to cover the entire product tolerance (class 2B or 6H)
- The .2500" +/- .0001" (6.35mm +/- .0025mm) shank is concentric to the threaded section within .0002 T.I.R. prior to slotting
- For inspecting the location of a threaded hole in a part
- For determining centerline to centerline distances of threaded holes

Calibrated Thread Measuring Wires

60° Thread

(n) THREADS PER INCH	(G) NOMINAL BEST WIRE DIAMETER	(C) NOMINAL CONSTANT
120	.00481	.00722
100	.00577	.00866
96	.00601	.00902
90	.00642	.00962
80	.00722	.01083
72	.00802	.01203
64	.00902	.01353
56	.01031	.01546
50	.01155	.01732
48	.01203	.01804
44	.01312	.01968
40	.01443	.02165
36	.01604	.02406
32	.01804	.02706
30	.01925	.02887
28	.02062	.03093
27	.02138	.03208
26	.02221	.03331
24	.02406	.03608
22	.02624	.03936
20	.02887	.04330
18	.03208	.04811
16	.03608	.05413
14	.04124	.06186
13	.04441	.06662
12	.04811	.07217
11-1/2	.05020	.07531
11	.05249	.07873
10	.05774	.08660
9	.06415	.09623
8	.07217	.10825
7-1/2	.07698	.11547
7	.08248	.12372
6	.09623	.14434
5-1/2	.10497	.15746
5	.11547	.17321
4-1/2	.12830	.19245
4	.14434	.21651
3-1/2	.16496	.24744
3-1/4	.17765	.26647
3	.19245	.28868
2-3/4	.20995	.31492
2	.28868	.43301

60° Metric Thread

PITCH mm	NOMINAL BEST WIRE DIAMETER mm	NOMINAL CONSTANT mm
.2	.1155	.1732
.225	.1299	.1949
.25	.1443	.2165
.3	.1732	.2598
.35	.2021	.3031
.4	.2309	.3464
.45	.2598	.3897
.5	.2887	.4330
.6	.3464	.5196
.7	.4041	.6062
.75	.4330	.6495
.8	.4619	.6928
.9	.5196	.7794
1.0	.5774	.8660
1.25	.7217	1.0825
1.5	.8660	1.2990
1.75	1.0104	1.5155
2.0	1.1547	1.7321
2.5	1.4434	2.1651
3.0	1.7321	2.5981
3.5	2.0207	3.0311
4.0	2.3094	3.4641
4.5	2.5981	3.8971
5.0	2.8868	4.3301
5.5	3.1754	4.7631
6.0	3.4641	5.1962
7.0	4.0415	6.0622
8.0	4.6188	6.9282
9.0	5.1962	7.7942
10.0	5.7735	8.6603

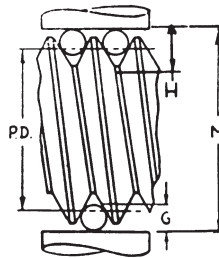
Special Thread Wires +/- 20 Millionths

ABOVE - INCLUDING
.004 - .005"
.1016mm - .1270mm
.005 - .007"
.1270mm - .1778mm
.007 - .010"
.1778mm - .2540mm
.010 - .135"
.2540mm - 3.429mm
.135 - .260"
3.429mm - 6.604mm
.260 - .385"
6.604mm - 9.779mm
.385 - .510"
9.779mm - 12.954mm
.510 - .635"
12.954mm - 16.129mm
.635 - .760"
16.129mm - 19.304mm
.760 - 1.010"
19.304mm - 25.654mm

Certificate of accuracy
included with each set
CALL FOR PRICES

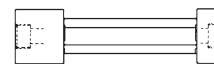
29° Acme Best Wires

THREADS PER INCH (n)	DIAMETER BEST SIZE WIRE
1	.51645
1-1/3	.38734
1-1/2	.34430
1-3/4	.29511
2	.25823
2-1/2	.20658
3	.17215
3-1/2	.14756
4	.12911
4-1/2	.11477
5	.10329
5-1/2	.09390
6	.08608
7	.07378
8	.06456
9	.05738
10	.05164
12	.04304
14	.03689
16	.03228
18	.02869
20	.02582



Measured Pitch Diameter (PD) =
Measurement over Wires (M) –
Constant (C)

Cylindrical Plug Gages



Reversible Style

SIZE ABOVE – INCLUDING	CLASS	TOL.	GO OR NO GO LENGTH	HANDLE #
.010 to .075 .254mm to 1.91mm	XX	.00002	2"	1W
	X	.00004		1W
	Y	.00007		1W
	Z	.00010		1W
.075 to .180 1.91mm to 4.57mm	XX	.00002	2"	2W
	X	.00004		2W
	Y	.00007		2W
	Z	.00010		2W
.180 to .281 4.57mm to 7.14mm	XX	.00002	2"	3W
	X	.00004		3W
	Y	.00007		3W
	Z	.00010		3W
.281 to .406 7.14mm to 10.31mm	XX	.00002	2"	4W
	X	.00004		4W
	Y	.00007		4W
	Z	.00010		4W
.406 to .510 10.31mm to 12.95mm	XX	.00002	2"	5W
	X	.00004		5W
	Y	.00007		5W
	Z	.00010		5W
.510 to .635 12.95mm to 16.13mm	XX	.00002	2"	6W
	X	.00004		6W
	Y	.00007		6W
	Z	.00010		6W
.635 to .760 16.13mm to 19.30mm	XX	.00002	2"	7W
	X	.00004		7W
	Y	.00007		7W
	Z	.00010		7W
.760 to .825 19.30mm to 20.96mm	XX	.00002	2"	8W
	X	.00004		8W
	Y	.00007		8W
	Z	.00010		8W
.825 to 1.010 20.96mm to 25.65mm	XX	.00003	2"	8W
	X	.00006		8W
	Y	.00009		8W
	Z	.00012		8W

Trilock Style

SIZE ABOVE – INCLUDING	CLASS	TOL.	GO LENGTH	NO GO LENGTH	HANDLE #
.760 to .947 19.30mm to 24.05mm	XX	.00003	1-1/4"	3/4"	2-1/2
	X	.00006			2-1/2
	Y	.00009			2-1/2
	Z	.00012			2-1/2
.947 to 1.135 24.05mm to 28.83mm	XX	.00003	1-3/8"	3/4"	3-1/2
	X	.00006			3-1/2
	Y	.00009			3-1/2
	Z	.00012			3-1/2
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-1/2"	3/4"	4-1/2
	X	.00006			4-1/2
	Y	.00009			4-1/2
	Z	.00012			4-1/2
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	1-7/8"	7/8"	5-1/2
	X	.00008			5-1/2
	Y	.00012			5-1/2
	Z	.00016			5-1/2
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	2"	7/8"	6
	X	.00008			6
	Y	.00012			6
	Z	.00016			6
2.510 to 3.510 63.75mm to 89.15mm	XX	.00005	2"	1"	7
	X	.00010			7
	Y	.00015			7
	Z	.00020			7
3.510 to 4.510 89.15mm to 114.55mm	XX	.00005	2-1/8"	1"	7
	X	.00010			7
	Y	.00015			7
	Z	.00020			7
4.510 to 6.510 114.55mm to 165.35mm	XX	.000065	2-1/8"	1"	7
	X	.00013			7
	Y	.00019			7
	Z	.00025			7
6.510 to 8.010 165.35mm to 203.45mm	XX	.00008	2-1/8"	1"	7
	X	.00016			7
	Y	.00024			7
	Z	.00032			7

Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

**Chrome and Carbide
also available**

CALL SWANSON FOR PRICING

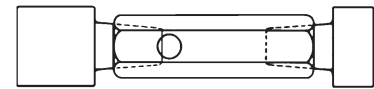
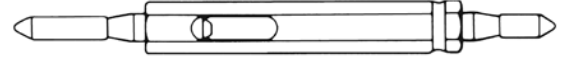
How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. GO or NO GO.
5. Handles (Single or Double End).
6. Marking.

Taperlock Cylindrical Plug Gages

SIZE ABOVE – INCLUDING	CLASS	TOL.	GO LENGTH	NO GO LENGTH	HANDLE #
.059 to .105 1.50mm to 2.67mm	XX	.00002	3/8"	3/16"	000
	X	.00004			000
	Y	.00007			000
	Z	.00010			000
.105 to .150 2.67mm to 3.81mm	XX	.00002	3/8"	7/32"	00
	X	.00004			00
	Y	.00007			00
	Z	.00010			00
.150 to .230 3.81mm to 5.84mm	XX	.00002	13/32"	9/32"	0
	X	.00004			0
	Y	.00007			0
	Z	.00010			0
.230 to .365 5.84mm to 9.27mm	XX	.00002	3/4"	5/16"	1
	X	.00004			1
	Y	.00007			1
	Z	.00010			1
.365 to .510 9.27mm to 12.95mm	XX	.00002	1"	3/8"	2
	X	.00004			2
	Y	.00007			2
	Z	.00010			2
.510 to .825 12.95mm to 20.96mm	XX	.00002	1-1/4"	1/2"	3
	X	.00004			3
	Y	.00007			3
	Z	.00010			3
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	1-1/2"	5/8"	4
	X	.00006			4
	Y	.00009			4
	Z	.00012			4
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-5/8"	3/4"	5
	X	.00006			5
	Y	.00009			5
	Z	.00012			5



Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

**Chrome and Carbide
also available**

CALL SWANSON FOR PRICING

How to Order

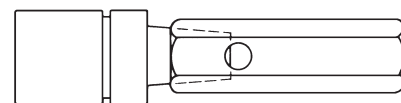
Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
4. GO or NO GO.
5. Handles (Single or Double End).
6. Marking.

Progressive Cylindrical Plug Gages

Taperlock Style

SIZE ABOVE – INCLUDING	CLASS	TOL.	MEMBER LENGTH	GO LENGTH	NO GO LENGTH	HANDLE #
.105 to .150 2.67mm to 3.81mm	XX	.00002	23/32"	3/8"	7/32"	00
	X	.00004				00
	Y	.00007				00
	Z	.00010				00
.150 to .230 3.81mm to 5.84mm	XX	.00002	13/16"	13/32"	9/32"	0
	X	.00004				0
	Y	.00007				0
	Z	.00010				0
.230 to .365 5.84mm to 9.27mm	XX	.00002	1-3/16"	3/4"	5/16"	1
	X	.00004				1
	Y	.00007				1
	Z	.00010				1
.365 to .510 9.27mm to 12.95mm	XX	.00002	1-1/2"	1"	3/8"	2
	X	.00004				2
	Y	.00007				2
	Z	.00010				2
.510 to .825 12.95mm to 20.96mm	XX	.00002	1-7/8"	1-1/4"	1/2"	3
	X	.00004				3
	Y	.00007				3
	Z	.00010				3
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	2-1/8"	1-3/8"	5/8"	4
	X	.00006				4
	Y	.00009				4
	Z	.00012				4
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	2-3/8"	1-1/2"	3/4"	5
	X	.00006				5
	Y	.00009				5
	Z	.00012				5



The Progressive Style is a Single End Gage having GO and NO GO members combined to make complete inspection of a hole possible with one insertion.

Direction of Tolerances

GO – Unilateral (Plus)
NO GO – Unilateral (Minus)

**Chrome and Carbide
also available**

Trilock Style

SIZE ABOVE – INCLUDING	CLASS	TOL.	MEMBER LENGTH	GO LENGTH	NO GO LENGTH	HANDLE #
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	2-7/8"	1-7/8"	7/8"	5-1/2
	X	.00008				5-1/2
	Y	.00012				5-1/2
	Z	.00016				5-1/2
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	3"	2"	7/8"	6
	X	.00008				6
	Y	.00012				6
	Z	.00016				6
2.510 to 3.510 63.75mm to 89.15mm	XX	.00005	3"	2"	7/8"	7
	X	.00010				7
	Y	.00015				7
	Z	.00020				7
3.510 to 4.510 89.15mm to 114.55mm	XX	.00005	3-1/8"	2-1/8"	7/8"	7
	X	.00010				7
	Y	.00015				7
	Z	.00020				7

**CALL SWANSON FOR
PRICING**

How to Order

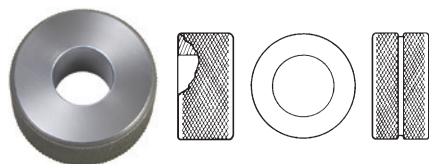
Please specify:

1. Quantity desired.
2. Exact diameter(s).
3. Tolerance.
5. Handles
6. Marking.

Cylindrical Ring Gages

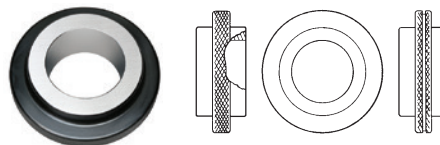
Solid Type

Sizes .040" - 1.510" (1.02mm-38.35mm)



Flanged Type

Sizes Above 1.510" (38.35mm)



SIZE ABOVE - INCLUDING	CLASS	TOL.	WIDTH	O.D.
.040 to .150 1.02mm to 3.81mm	XX	.00002	3/16"	15/16"
	X	.00004		
	Y	.00007		
	Z	.00010		
.150 to .230 3.81mm to 5.84mm	XX	.00002	3/8"	15/16"
	X	.00004		
	Y	.00007		
	Z	.00010		
.230 to .365 5.84mm to 9.27mm	XX	.00002	9/16"	1-1/8"
	X	.00004		
	Y	.00007		
	Z	.00010		
.365 to .510 9.27mm to 12.95mm	XX	.00002	3/4"	1-3/8"
	X	.00004		
	Y	.00007		
	Z	.00010		
.510 to .825 12.95mm to 20.96mm	XX	.00002	15/16"	1-3/4"
	X	.00004		
	Y	.00007		
	Z	.00010		
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	1-1/8"	2-1/8"
	X	.00006		
	Y	.00009		
	Z	.00012		
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-5/16"	2-1/2"
	X	.00006		
	Y	.00009		
	Z	.00012		

SIZE ABOVE - INCLUDING	CLASS	TOL.	WIDTH	O.D.
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	1-1/2"	4"
	X	.00008		
	Z	.00016		
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	1-1/2"	4-1/2"
	X	.00008		
	Z	.00016		
2.510 to 3.010 63.75mm to 76.45mm	XX	.00005	1-1/2"	5"
	X	.00010		
	Z	.00020		
3.010 to 3.510 76.45mm to 89.15	XX	.00005	1-1/2"	5-1/2"
	X	.00010		
	Z	.00020		
3.510 to 4.010 89.15mm to 101.85mm	XX	.00005	1-1/2"	6-3/8"
	X	.00010		
	Z	.00020		
4.010 to 4.760 101.85mm to 120.90mm	XX	.00005	1-1/2"	7-1/4"
	X	.00010		
	Z	.00020		
4.760 to 5.510 120.90mm to 139.95mm	XX	.000065	1-1/2"	8-1/4"
	X	.00013		
	Z	.00025		
5.510 to 6.260 139.95mm to 159.00mm	XX	.000065	1-1/2"	9-1/4"
	X	.00013		
	Z	.00025		
6.260 to 7.010 159.00mm to 178.05mm	XX	.00008	1-1/2"	10-1/4"
	X	.00016		
	Z	.00032		
7.010 to 7.760 178.05mm to 197.10mm	XX	.00008	1-1/2"	11-1/4"
	X	.00016		
	Z	.00032		
7.760 to 8.510 197.10mm to 216.15mm	XX	.00008	1-1/2"	12-1/4"
	X	.00016		
	Z	.00032		

How to Order

- Please specify:
1. Quantity desired.
 2. Exact diameter(s).
 3. Tolerance.
 4. GO or NO GO or MASTER.
 5. Marking.

Plain Cylindrical Ring Gages conform to established AGD specifications. GO and NO GO Rings are made from blanks of the same dimension. An annular groove in the periphery of the NO GO ring distinguishes it from the GO Ring.

Direction of Tolerances

- MASTER – Bilateral (Split)
GO – Unilateral (Minus)
NO GO – Unilateral (Plus)

Chrome and Carbide also available

CALL SWANSON FOR PRICING

Master Setting Discs

SIZE ABOVE - INCLUDING	CLASS	TOL.	STYLE 1 LENGTH	STYLE 2 LENGTH	STYLE 3 LENGTH
.105 to .150 2.67mm to 3.81mm	XX	.00002	3/4"	3/4"	3/8"
	X	.00004			
	Y	.00007			
	Z	.00010			
.150 to .230 3.81mm to 5.84mm	XX	.00002	7/8"	7/8"	7/16"
	X	.00004			
	Y	.00007			
	Z	.00010			
.230 to .365 5.84mm to 9.27mm	XX	.00002	1"	1"	1/2"
	X	.00004			
	Y	.00007			
	Z	.00010			
.365 to .510 9.27mm to 12.95mm	XX	.00002	1-1/8"	1-1/8"	9/16"
	X	.00004			
	Y	.00007			
	Z	.00010			
.510 to .825 12.95mm to 20.96mm	XX	.00002	1-1/4"	1-1/4"	5/8"
	X	.00004			
	Y	.00007			
	Z	.00010			
.825 to 1.135 20.96mm to 28.83mm	XX	.00003	1-3/8"	1-3/8"	11/16"
	X	.00006			
	Y	.00009			
	Z	.00012			
1.135 to 1.510 28.83mm to 38.35mm	XX	.00003	1-5/8"	1-5/8"	13/16"
	X	.00006			
	Y	.00009			
	Z	.00012			
1.510 to 2.010 38.35mm to 51.05mm	XX	.00004	1-7/8"	1-7/8"	7/8"
	X	.00008			
	Y	.00012			
	Z	.00016			
2.010 to 2.510 51.05mm to 63.75mm	XX	.00004	2"	2"	7/8"
	X	.00008			
	Y	.00012			
	Z	.00016			
2.510 to 3.010 63.75mm to 76.45mm	XX	.00005	2-1/8"	2-1/8"	1"
	X	.00010			
	Y	.00015			
	Z	.00020			
3.010 to 4.510 76.45mm to 114.55mm	XX	.00005	2-1/4"	2-1/4"	1"
	X	.00010			
	Y	.00015			
	Z	.00020			
4.510 to 6.510 114.55mm to 165.35mm	XX	.000065	2-1/4"	2-1/4"	1"
	X	.00013			
	Y	.00019			
	Z	.00025			
6.510 to 8.010 165.35mm to 203.45mm	XX	.00008	2-1/4"	2-1/4"	1"
	X	.00016			
	Y	.00024			
	Z	.00032			

Style #1



Style #2



Style #3



Master Setting Discs are used for setting comparators, snap gages and other precision gages and are furnished with insulating grips to prevent heat distortion.

Direction of Tolerances

Unless otherwise specified, the gagemaker's tolerance will be applied bilaterally (split 1/2 plus 1/2 minus) on Styles #1 and #3. On Style #2 tolerances will be unilateral, minus on the "GO" section and plus on the "NO GO" section.

Chrome and Carbide also available

How to Order

Please specify:

1. Quantity desired.
2. Exact diameter(s).*
3. Style.
4. Tolerance and direction.
5. Marking.

* Two diameters on Style #2

CALL SWANSON FOR PRICING

Pitch Diameters – Thread Plug Gages



Table I
Classes 2B, 3B

Nominal Size	Go Basic All Classes All Series	UNIFIED PITCH DIAMETERS					Nominal Size	Go Basic All Classes All Series	UNIFIED PITCH DIAMETERS				
		No Go		X Tol. Go = + No Go = -	X Lead Tol.	X ± Half Angle Tol.			No Go		X Tol. Go = + No Go = -	X Lead Tol.	X ± Half Angle Tol.
		CL. 2B	CL. 3B						CL. 2B	CL. 3B			
#0-80 UNF	.0519	.0542	.0536	.0002	.0002	0°30'	9/16-24 UNEF	.5354	.5405	.5392	.0003	.0003	0°15'
#1-64 UNC	.0629	.0655	.0648	.0002	.0002	0°30'	5/8-11 UNC	.5660	.5732	.5714	.0003	.0003	0°10'
#1-72 UNF	.0640	.0665	.0659	.0002	.0002	0°30'	5/8-18 UNF	.5889	.5949	.5934	.0003	.0003	0°10'
#2-56 UNC	.0744	.0772	.0765	.0002	.0002	0°30'	5/8-24 UNEF	.5979	.6031	.6018	.0003	.0003	0°15'
#2-64 UNF	.0759	.0786	.0779	.0002	.0002	0°30'	11/16-24 UNEF	.6604	.6656	.6643	.0003	.0003	0°15'
#3-48 UNC	.0855	.0885	.0877	.0002	.0002	0°30'	3/4-10 UNC	.6850	.6927	.6907	.0003	.0003	0°10'
#3-56 UNF	.0874	.0902	.0895	.0002	.0002	0°30'	3/4-16 UNF	.7094	.7159	.7143	.0003	.0003	0°10'
#4-40 UNC	.0958	.0991	.0982	.0002	.0002	0°20'	3/4-20 UNEF	.7175	.7232	.7218	.0003	.0003	0°15'
#4-48 UNF	.0985	.1016	.1008	.0002	.0002	0°30'	13/16-20 UNEF	.7800	.7857	.7843	.0003	.0003	0°15'
#5-40 UNC	.1088	.1121	.1113	.0002	.0002	0°20'	7/8-9 UNC	.8028	.8110	.8089	.0003	.0003	0°10'
#5-44 UNF	.1102	.1134	.1126	.0002	.0002	0°20'	7/8-14 UNF	.8286	.8356	.8339	.0003	.0003	0°10'
#6-32 UNC	.1177	.1214	.1204	.0003	.0003	0°15'	7/8-20 UNEF	.8425	.8482	.8468	.0003	.0003	0°15'
#6-40 UNF	.1218	.1252	.1243	.0002	.0002	0°20'	15/16-20 UNEF	.9050	.9109	.9094	.0003	.0003	0°15'
#8-32 UNC	.1437	.1475	.1465	.0003	.0003	0°15'	1"-8 UNC	.9188	.9276	.9254	.0004	.0004	0°05'
#8-36 UNF	.1460	.1496	.1487	.0002	.0002	0°20'	1"-12 UNF	.9459	.9535	.9516	.0003	.0003	0°10'
#10-24 UNC	.1629	.1672	.1661	.0003	.0003	0°15'	1"-14 UNS	.9536	.9609	.9590	.0003	.0003	0°10'
#10-32 UNF	.1697	.1736	.1726	.0003	.0003	0°15'	1"-20 UNEF	.9675	.9734	.9719	.0003	.0003	0°15'
#12-24 UNC	.1889	.1933	.1922	.0003	.0003	0°15'	11/16-12 UN	1.0084	1.0158	1.0139	.0003	.0003	0°10'
#12-28 UNF	.1928	.1970	.1959	.0003	.0003	0°15'	11/16-18 UNEF	1.0264	1.0326	1.0310	.0003	.0003	0°10'
#12-32 UNEF	.1957	.1998	.1988	.0003	.0003	0°15'	1 1/8-7 UNC	1.0322	1.0416	1.0393	.0004	.0004	0°05'
1/4-20 UNC	.2175	.2224	.2211	.0003	.0003	0°15'	1 1/8-12 UNF	1.0709	1.0787	1.0768	.0003	.0003	0°10'
1/4-28 UNF	.2268	.2311	.2300	.0003	.0003	0°15'	1 1/8-18 UNEF	1.0889	1.0951	1.0935	.0003	.0003	0°10'
1/4-32 UNEF	.2297	.2339	.2328	.0003	.0003	0°15'	1 3/16-12 UN	1.1334	1.1409	1.1390	.0003	.0003	0°10'
5/16-18 UNC	.2764	.2817	.2803	.0003	.0003	0°10'	1 3/16-18 UNEF	1.1514	1.1577	1.1561	.0003	.0003	0°10'
5/16-24 UNF	.2854	.2902	.2890	.0003	.0003	0°15'	1 1/4-7 UNC	1.1572	1.1668	1.1644	.0004	.0004	0°05'
5/16-32 UNEF	.2922	.2964	.2953	.0003	.0003	0°15'	1 1/4-12 UNF	1.1959	1.2039	1.2019	.0003	.0003	0°10'
3/8-16 UNC	.3344	.3401	.3387	.0003	.0003	0°10'	1 1/4-18 UNEF	1.2139	1.2202	1.2186	.0003	.0003	0°10'
3/8-24 UNF	.3479	.3528	.3516	.0003	.0003	0°15'	1 5/16-12 UN	1.2584	1.2659	1.2640	.0003	.0003	0°10'
3/8-32 UNEF	.3547	.3591	.3580	.0003	.0003	0°15'	1 5/16-18 UNEF	1.2764	1.2827	1.2811	.0003	.0003	0°10'
7/16-14 UNC	.3911	.3972	.3957	.0003	.0003	0°10'	1 3/8-6 UNC	1.2667	1.2771	1.2745	.0004	.0004	0°05'
7/16-20 UNF	.4050	.4104	.4091	.0003	.0003	0°15'	1 3/8-12 UNF	1.3209	1.3291	1.3270	.0003	.0003	0°10'
7/16-28 UNEF	.4143	.4189	.4178	.0003	.0003	0°15'	1 3/8-18 UNEF	1.3389	1.3452	1.3436	.0003	.0003	0°10'
1/2-13 UNC	.4500	.4565	.4548	.0003	.0003	0°10'	1 7/16-12 UN	1.3834	1.3910	1.3891	.0003	.0003	0°10'
1/2-20 UNF	.4675	.4731	.4717	.0003	.0003	0°15'	1 7/16-18 UNEF	1.4014	1.4079	1.4062	.0003	.0003	0°10'
1/2-28 UNEF	.4768	.4816	.4804	.0003	.0003	0°15'	1 1/2-6 UNC	1.3917	1.4022	1.3996	.0004	.0004	0°05'
9/16-12 UNC	.5084	.5152	.5135	.0003	.0003	0°10'	1 1/2-12 UNF	1.4459	1.4542	1.4522	.0003	.0003	0°10'
9/16-18 UNF	.5264	.5323	.5308	.0003	.0003	0°10'	1 1/2-18 UNEF	1.4639	1.4704	1.4687	.0003	.0003	0°10'

Pitch Diameters – Thread Ring & Setting Plug Gages



Table II
Classes 2A, 3A

Nominal Size	UNIFIED PITCH DIAMETERS					Nominal Size	UNIFIED PITCH DIAMETERS				
	Class 2A		Class 3A		X Tol. Go = - No Go = +		Class 2A		Class 3A		X Tol. Go = - No Go = +
	Go	No Go	Go	No Go			Go	No Go	Go	No Go	
#0-80 UNF	.0514	.0496	.0519	.0506	.0002	9/16-24 UNEF	.5342	.5303	.5354	.5325	.0003
#1-64 UNC	.0623	.0603	.0629	.0614	.0002	5/8-11 UNC	.5644	.5589	.5660	.5619	.0003
#1-72 UNF	.0634	.0615	.0640	.0626	.0002	5/8-18 UNF	.5875	.5828	.5889	.5854	.0003
#2-56 UNC	.0738	.0717	.0744	.0728	.0002	5/8-24 UNEF	.5967	.5927	.5979	.5949	.0003
#2-64 UNF	.0753	.0733	.0759	.0744	.0002	11/16-24 UNEF	.6592	.6552	.6604	.6574	.0003
#3-48 UNC	.0848	.0825	.0855	.0838	.0002	3/4-10 UNC	.6832	.6773	.6850	.6806	.0003
#3-56 UNF	.0867	.0845	.0874	.0858	.0002	3/4-16 UNF	.7079	.7029	.7094	.7056	.0003
#4-40 UNC	.0950	.0925	.0958	.0939	.0002	3/4-20 UNEF	.7162	.7118	.7175	.7142	.0003
#4-48 UNF	.0978	.0954	.0985	.0967	.0002	13/16-20 UNEF	.7787	.7743	.7800	.7767	.0003
#5-40 UNC	.1080	.1054	.1088	.1069	.0002	7/8-9 UNC	.8009	.7946	.8028	.7981	.0003
#5-44 UNF	.1095	.1070	.1102	.1083	.0002	7/8-14 UNF	.8270	.8216	.8286	.8245	.0003
#6-32 UNC	.1169	.1141	.1177	.1156	.0003	7/8-20 UNEF	.8412	.8368	.8425	.8392	.0003
#6-40 UNF	.1210	.1184	.1218	.1198	.0002	15/16-20 UNEF	.9036	.8991	.9050	.9016	.0003
#8-32 UNC	.1428	.1399	.1437	.1415	.0003	1"-8 UNC	.9168	.9100	.9188	.9137	.0004
#8-36 UNF	.1452	.1424	.1460	.1439	.0002	1"-12 UNF	.9441	.9382	.9459	.9415	.0003
#10-24 UNC	.1619	.1586	.1629	.1604	.0003	1"-14 UNS	.9519	.9463	.9536	.9494	.0003
#10-32 UNF	.1688	.1658	.1697	.1674	.0003	1"-20 UNEF	.9661	.9616	.9675	.9641	.0003
#12-24 UNC	.1879	.1845	.1889	.1863	.0003	1 1/16-12 UN	1.0067	1.0010	1.0084	1.0042	.0003
#12-28 UNF	.1918	.1886	.1928	.1904	.0003	1 1/16-18 UNEF	1.0250	1.0203	1.0264	1.0228	.0003
#12-32 UNEF	.1948	.1917	.1957	.1933	.0003	1 1/8-7 UNC	1.0300	1.0228	1.0322	1.0268	.0004
1/4-20 UNC	.2164	.2127	.2175	.2147	.0003	1 1/8-12 UNF	1.0691	1.0631	1.0709	1.0664	.0003
1/4-28 UNF	.2258	.2225	.2268	.2243	.0003	1 1/8-18 UNEF	1.0875	1.0828	1.0889	1.0853	.0003
1/4-32 UNEF	.2287	.2255	.2297	.2273	.0003	1 3/16-12 UN	1.1317	1.1259	1.1334	1.1291	.0003
5/16-18 UNC	.2752	.2712	.2764	.2734	.0003	1 3/16-18 UNEF	1.1499	1.1450	1.1514	1.1478	.0003
5/16-24 UNF	.2843	.2806	.2854	.2827	.0003	1 1/4-7 UNC	1.1550	1.1476	1.1572	1.1517	.0004
5/16-32 UNEF	.2912	.2880	.2922	.2898	.0003	1 1/4-12 UNF	1.1941	1.1879	1.1959	1.1913	.0003
3/8-16 UNC	.3331	.3287	.3344	.3311	.0003	1 1/4-18 UNEF	1.2124	1.2075	1.2139	1.2103	.0003
3/8-24 UNF	.3468	.3430	.3479	.3450	.0003	1 5/16-12 UN	1.2567	1.2509	1.2584	1.2541	.0003
3/8-32 UNEF	.3537	.3503	.3547	.3522	.0003	1 5/16-18 UNEF	1.2749	1.2700	1.2764	1.2728	.0003
7/16-14 UNC	.3897	.3850	.3911	.3876	.0003	1 3/8-6 UNC	1.2643	1.2563	1.2667	1.2607	.0004
7/16-20 UNF	.4037	.3995	.4050	.4019	.0003	1 3/8-12 UNF	1.3190	1.3127	1.3209	1.3162	.0003
7/16-28 UNEF	.4132	.4096	.4143	.4116	.0003	1 3/8-18 UNEF	1.3374	1.3325	1.3389	1.3353	.0003
1/2-13 UNC	.4485	.4435	.4500	.4463	.0003	1 7/16-12 UN	1.3816	1.3757	1.3834	1.3790	.0003
1/2-20 UNF	.4662	.4619	.4675	.4643	.0003	1 7/16-18 UNEF	1.3999	1.3949	1.4014	1.3977	.0003
1/2-28 UNEF	.4757	.4720	.4768	.4740	.0003	1 1/2-6 UNC	1.3893	1.3812	1.3917	1.3856	.0004
9/16-12 UNC	.5068	.5016	.5084	.5045	.0003	1 1/2-12 UNF	1.4440	1.4376	1.4459	1.4411	.0003
9/16-18 UNF	.5250	.5205	.5264	.5230	.0003	1 1/2-18 UNEF	1.4624	1.4574	1.4639	1.4602	.0003

Pitch Diameters – (STI) Screw Thread Insert Plug Gages



Table III
Classes 2B, 3B

Nominal Size	PITCH DIAMETERS			X Tol. Go = + No Go = -
	GO	2B NO GO	3B NO GO	
#4-40 UNC	.1283	.1308	.1299	.0002
#4-48 UNF	.1256	.1279	.1271	.0002
#5-40 UNC	.1413	.1438	.1430	.0002
#6-32 UNC	.1583	.1611	.1601	.0003
#6-40 UNF	.1543	.1569	.1560	.0002
#8-32 UNC	.1843	.1872	.1862	.0003
#8-36 UNF	.1821	.1849	.1840	.0002
#10-24 UNC	.2170	.2203	.2192	.0003
#10-32 UNF	.2103	.2133	.2123	.0003
#12-24 UNC	.2430	.2464	.2453	.0003
1/4-20 UNC	.2825	.2864	.2851	.0003
1/4-28 UNF	.2732	.2765	.2754	.0003
5/16-18 UNC	.3486	.3529	.3515	.0003
5/16-24 UNF	.3395	.3433	.3421	.0003
3/8-16 UNC	.4156	.4203	.4189	.0003
3/8-24 UNF	.4020	.4059	.4047	.0003
7/16-14 UNC	.4839	.4890	.4875	.0003
7/16-20 UNF	.4700	.4744	.4731	.0003
1/2-13 UNC	.5499	.5554	.5537	.0003
1/2-20 UNF	.5325	.5371	.5357	.0003
9/16-12 UNC	.6167	.6225	.6208	.0003
9/16-18 UNF	.5986	.6035	.6020	.0003
5/8-11 UNC	.6841	.6903	.6885	.0003
5/8-18 UNF	.6611	.6661	.6646	.0003
3/4-10 UNC	.8149	.8216	.8196	.0003
3/4-16 UNF	.7906	.7961	.7945	.0003

Pitch Diameters – Metric Thread Gages



**Table IV (Internal)
Thread Plug Gages**

SIZE mm	PITCH mm	PITCH DIAMETERS		
		Go (Basic)	No Go 4H	No Go 6H
M1.6	0.35	1.373	1.426	1.458
M1.8	0.35	1.573	1.626	1.658
M2	0.4	1.740	1.796	1.830
M2.2	0.45	1.908	1.968	2.003
M2.5	0.45	2.208	2.268	2.303
M3	0.5	2.675	2.738	2.775
M3.5	0.6	3.110	3.181	3.222
M4	0.7	3.545	3.620	3.663
M4.5	0.75	4.013	4.088	4.131
M5	0.8	4.480	4.560	4.605
M6	1	5.350	5.445	5.500
M7	1	6.350	6.445	6.500
M8	1.25	7.188	7.288	7.348
M8	1	7.350	7.445	7.500
M10	1.5	9.026	9.138	9.206
M10	1.25	9.188	9.288	9.348
M12	1.75	10.863	10.988	11.063
M12	1.25	11.188	11.300	11.368
M14	2	12.701	12.833	12.913
M14	1.5	13.026	13.144	13.216
M16	2	14.701	14.833	14.913
M16	1.5	15.026	15.144	15.216
M18	2.5	16.376	16.516	16.600
M18	1.5	17.026	17.144	17.216
M20	2.5	18.376	18.516	18.600
M20	1.5	19.026	19.144	19.216
M22	2.5	20.376	20.516	20.600
M22	1.5	21.026	21.144	21.216
M24	3	22.051	22.221	22.316
M24	2	22.701	22.841	22.925
M27	3	25.051	25.221	25.316
M27	2	25.701	25.841	25.925
M30	3.5	27.727	27.907	28.007
M30	2	28.701	28.841	28.925
M33	3.5	30.727	30.907	31.007
M33	2	31.701	31.841	31.925
M36	4	33.402	33.592	33.702
M36	3	34.051	34.221	34.316
M39	4	36.402	36.592	36.702
M39	3	37.051	37.221	37.316

**Table V (External)
Thread Ring & Setting
Plug Gages**

SIZE mm	PITCH mm	PITCH DIAMETERS		
		Go 4g & 6g	No Go 4g	No Go 6g
M1.6	0.35	1.354	1.314	1.291
M1.8	0.35	1.554	1.514	1.491
M2	0.4	1.721	1.679	1.654
M2.2	0.45	1.888	1.843	1.817
M2.5	0.45	2.188	2.143	2.117
M3	0.5	2.655	2.607	2.580
M3.5	0.6	3.089	3.036	3.004
M4	0.7	3.523	3.467	3.433
M4.5	0.75	3.991	3.935	3.901
M5	0.8	4.456	4.396	4.361
M6	1	5.324	5.253	5.212
M7	1	6.324	6.253	6.212
M8	1.25	7.160	7.085	7.042
M8	1	7.324	7.253	7.212
M10	1.5	8.994	8.909	8.862
M10	1.25	9.160	9.085	9.042
M12	1.75	10.829	10.734	10.679
M12	1.25	11.160	11.075	11.028
M14	2	12.663	12.563	12.503
M14	1.5	12.994	12.904	12.854
M16	2	14.663	14.563	14.503
M16	1.5	14.994	14.904	14.854
M18	2.5	16.334	16.228	16.164
M18	1.5	16.994	16.904	16.854
M20	2.5	18.334	18.228	18.164
M20	1.5	18.994	18.904	18.854
M22	2.5	20.334	20.228	20.164
M22	1.5	20.994	20.904	20.854
M24	3	22.003	21.878	21.803
M24	2	22.663	22.557	22.493
M27	3	25.003	24.878	24.803
M27	2	25.663	25.557	25.493
M30	3.5	27.674	27.542	27.462
M30	2	28.663	28.557	28.493
M33	3.5	30.674	30.542	30.462
M33	2	31.663	31.557	31.493
M36	4	33.342	33.202	33.118
M36	3	34.003	33.878	33.803
M39	4	36.342	36.202	36.118
M39	3	37.003	36.878	36.803

Note: To obtain inch values for pitch diameters multiply by .03937.

Pitch Diameters – Straight Pipe Gages



Table VI

PIPE SIZE	MEMBER	PITCH DIAMETERS FOR STRAIGHT PIPE GAGES						
		THREAD PLUG GAGES					THREAD RING GAGES	
		NPSF	NPSI	NPSL	NPSC	NPSM-2B	NPSM-2A	NPSL
1/16-27	Go	.2768	.2791					
	No Go	.2803	.2826					
1/8-27	Go	.3692	.3715	.3863	.3701	.3736	.3725	.3840
	No Go	.3727	.3750	.3898	.3771	.3783	.3689	.3805
1/4-18	Go	.4852	.4886	.5073	.4864	.4916	.4903	.5038
	No Go	.4904	.4938	.5125	.4968	.4974	.4859	.4986
3/8-18	Go	.6205	.6240	.6444	.6218	.6270	.6256	.6409
	No Go	.6257	.6292	.6496	.6322	.6329	.6211	.6357
1/2-14	Go	.7700	.7745	.8008	.7717	.7784	.7769	.7963
	No Go	.7767	.7812	.8075	.7851	.7851	.7718	.7896
3/4-14	Go	.9805	.9850	1.0112	.9822	.9889	.9873	1.0067
	No Go	.9872	.9917	1.0179	.9956	.9958	.9820	1.0000
1"-11 1/2	Go	1.2284	1.2338	1.2658	1.2305	1.2386	1.2369	1.2604
	No Go	1.2365	1.2420	1.2739	1.2468	1.2462	1.2311	1.2523
1 1/4-11 1/2	Go			1.6106	1.5752	1.5834	1.5816	1.6051
	No Go			1.6187	1.5915	1.5912	1.5756	1.5970
1 1/2-11 1/2	Go			1.8495	1.8142	1.8223	1.8205	1.8441
	No Go			1.8576	1.8305	1.8302	1.8144	1.8360
2"-11 1/2	Go			2.3234	2.2881	2.2963	2.2944	2.3180
	No Go			2.3315	2.3044	2.3044	2.2882	2.3099

NPSM–National Pipe Straight Mechanical–These external and internal threads are intended for free-fitting mechanical joints where there are no internal pressures. The product is gaged with straight Go and No Go plug and ring gages.

NPSL–National Pipe Straight Locknut–These external and internal threads are intended to produce a thread having the largest diameter that is possible to cut on standard pipe. The product is gaged with straight Go and No Go plug and ring gages.

NH–National Fire-Hose Coupling Threads–These external and internal threads are intended for fire hose, garden hose, chemical engine and booster hose. The product is gaged with straight Go and No Go plug and ring gages.

NPSH–National Hose Coupling Threads–These external and internal threads are intended for steam, air, water, and all other hose connections to be made up with standard pipe threads. The product is gaged with straight Go and No Go plug and ring gages.

NPSC–National Pipe Straight Coupling–These internal threads are intended to form low pressure tight joints when assembled with NPT external threads by using a sealer. The product may be gaged with a NPT plug gage or with straight Go and No Go plug gages.

NPSF–Dryseal American Standard Fuel–These internal threads are intended for use in soft or ductile materials for assembly with NPTF external threads without using a sealer. The product may be gaged with NPTF-LI basic notch plug gage or with straight Go and No Go plug gages.

NPSI–Dryseal American Standard Intermediate–These internal threads are intended for use in hard or brittle materials for assembly with PTF-SAE short external threads but may also be assembled with full length NPTF external threads. The product may be gaged with a NPTF-LI basic notch plug gage or with straight Go and No Go plug gages.

NOTE: NPSM and NPSF Series Gages are available from stock.

ANSI Thread Series Designations

DESIGNATIONS	THREAD SERIES
UN	Unified National, Constant Pitch, 60°, Inch
UNC	Unified National Coarse, 60°, Inch
UNF	Unified National Fine, 60°, Inch
UNEF	Unified National Extra Fine, 60°, Inch
UNS	Unified National Special, 60°, Inch
N, NC, NF, NEF, NS	American National, 60°, Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special
UNJ, UNJC, UNJF, UNJEF, UNJS	Unified National, 60° Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special, with .18042P Controlled Root Radius on External Thread
UNR, UNRC, UNRF, UNREF, UNRS	Unified National, 60° Inch, Constant Pitch, Coarse, Fine, Extra Fine & Special, with .144P Controlled Root Radius on External Thread
ACME-G, ACME-C	Acme, General Purpose and Centralizing, 29°
AMO	American Microscopic Objective, 55°, Inch
NC5, NC5HF, NC5CSF, NC5ONF, NC5IF, NC5INF	American National Coarse Interference Fit, 60°, Inch, HF – Hard Ferrous, CSF – Copper or Soft Ferrous, ONF – Other Nonferrous, IF – Entire Ferrous, INF – Entire Nonferrous
M	Metric, 60°
MJ	Metric, 60° with .15P to .18P Controlled Root Radius on External Thread
UNM	Unified National Miniature, 60° Metric
ANPT	Aeronautical National Pipe Taper, 60° Taper, Inch
NPT	National (American) Pipe Taper, 60° Taper, Inch
NPTF	National (American) Pipe Taper Fuel, Dryseal, 60° Taper, Inch
PTF-SAE SHORT	National (American) Pipe Taper Fuel Short, Dryseal, 60° Taper, Inch
F-PTF	National (American) Pipe Taper Fuel Short Fine, Dryseal, 60° Taper, Inch
NPSL	National (American) Pipe Straight Locknut, 60° Taper, Inch
NPSM	National (American) Pipe Straight Mechanical, 60° Taper, Inch
NPSC	National (American) Pipe Straight Coupling, 60° Taper, Inch
NPSF	National (American) Pipe Straight Fuel, 60° Taper, Inch
NPSI	National (American) Pipe Straight Intermediate, 60° Taper, Inch
NPSH	National (American) Pipe Straight Hose, 60° Taper, Inch, for Hose Couplings
NH	National (American) Pipe Straight Hose, 60° Taper, Inch, for Fire Hose Couplings
NHR	National (American) Pipe Straight Hose, 60° Taper, Inch, for Garden Hose Applications
NGT, SGT	National Gas Taper & Special Gas Taper, 60° Taper, Inch
NGO	National Gas Outlet, 60° Straight, Inch
NGS	National Gas Straight, 60° Straight, Inch
SPL-PTF	National (American) Pipe Taper Fuel Short, Special Diameter – Pitch Combination Dryseal, 60° Taper, Inch
STUB ACME	Stub Acme, 29° Inch, reduced thread height of standard Acme
BUTT	Buttress, "PULL" type 45° clearance flank leading / 7° load flank, Inch
PUSH-BUTT	Buttress, "PUSH" type 7° load flank leading / 45° clearance flank, Inch
STI	Helical Coil Screw Thread Insert, Inch and Metric
R (BSPT), Rc (BSPT), Rp	British Standard Pipe For Pressure Tight Joints, - Rc (internal taper), Rp (Internal straight) and R (External taper) 55° Whitworth Form, Inch
G (BSPP)	British Standard Pipe For Non-Pressure Tight Joints, - - G (Internal and external straight) 55° Whitworth Form, Inch
BA	British Association, 47.5°
BSF	British Association Standard Fine Pitch, 55° Whitworth Form, Inch
BSW	British Association Standard Whitworth Coarse Pitch, 55° Whitworth Form, Inch
AWWA	American Water Works Association, for Underground Service Line Fittings, Taper and Straight 60°, Inch
DIN	Deutsches Institut für Normung, German Institute for Standardization
JIS	Japanese Industrial Standard
ISO	International Standards Organization

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