

DIMENSION OF THREAD RING GAUGES FOR CLASS ‘6g’

		GO THREAD RING GAUGE					NOT GO THREAD RING GAUGE				
NOMINAL mm	PITCH P mm	MINO R ø mm	TOL ± µm	PITCH ø	TOL ± µm	MAJOR ø MIN mm	MINOR ø mm	TOL ± µm	PITCH ø	TOL ± µm	MAJOR ø MIN mm
1	0.25 0.2	0.729 0.783	5 4	0.840 0.874	5 4	1.025 1.020	0.730 0.778	10 8	0.780 0.818	5 4	1.007 1.006
* 1.1	0.25 0.2	0.829 0.883	5 4	0.940 0.974	5 4	1.125 1.120	0.830 0.878	10 8	0.880 0.918	5 4	1.107 1.106
* 1.2	0.25 0.2	0.929 0.983	5 4	1.040 1.074	5 4	1.225 1.220	0.930 0.978	10 8	0.980 1.018	5 4	1.207 1.206
* 1.4	0.3 0.2	1.075 1.183	5 4	1.207 1.274	5 4	1.429 1.420	1.084 1.178	10 8	1.144 1.218	5 4	1.407 1.406
1.6	0.35 0.2	1.202 1.366	5 4	1.356 1.457	5 4	1.613 1.603	1.216 1.359	10 8	1.286 1.399	5 4	1.588 1.589
1.8	0.35 0.2	1.402 1.566	5 4	1.556 1.657	5 4	1.813 1.803	1.416 1.559	10 8	1.486 1.599	5 4	1.788 1.789
2	0.4 0.25	1.548 1.711	5 5	1.723 1.822	5 5	2.017 2.007	1.569 1.709	10 10	1.649 1.759	5 5	1.988 1.989
2.2	0.45 0.25	1.693 1.911	5 5	1.890 2.022	5 5	2.219 2.207	1.722 1.909	10 10	1.812 1.959	5 5	2.187 2.189
2.5	0.45 0.25	1.993 2102	5 5	2.190 2.256	5 5	2.519 2.513	2.022 2.116	10 10	2.112 2.186	5 5	2.487 2.488
3	0.5 0.35	2.439 2.602	5 5	2.657 2.756	5 5	3.023 3.013	2.475 2.612	10 10	2.575 2.682	5 5	2.987 2.988
3.5	0.6 0.35	2.829 3.102	7 5	3.087 3.256	7 5	3.531 3.513	2.877 3.112	14 10	2.997 3.182	7 5	3.488 3.488
4	0.7 0.5	3.220 3.439	7 5	3.521 3.657	7 5	4.037 4.023	3.286 3.475	14 10	3.426 3.575	7 5	3.987 3.987
4.5	0.75 0.5	3.666 3.939	7 5	3.989 4.157	7 5	4.541 4.523	3.744 3.975	14 10	3.894 4.075	7 5	4.487 4.487
5	0.8 0.5	4.110 4.439	7 5	4.454 4.657	7 5	5.043 5.023	4.194 4.475	14 10	4.354 4.575	7 5	4.985 4.987
5.5	0.5	4.939	5	5.157	5	5.523	4.975	10	5.075	5	5.487
6	1 0.75	4.891 5.166	7 7	5.322 5.489	7 7	6.055 6.041	5.005 5.234	10	5.205 5.384	7 7	5.983 5987
7	1.0 0.75	5.891 6.166	7 7	6.322 6.489	7 7	7.055 7.041	6.005 6.234	14 14	6.205 6.384	7 7	6.983 6.987
8	1.25 1 0.75	6.619 6.891 7.166	7 7 7	7.158 7.322 7.489	7 7 7	8.071 8.055 8.041	6.785 7.005 7.234	14 14 14	7.035 7.205 7.384	7 7 7	7.981 7.983 7.987
9	1.25 1 0.75	7.619 7.891 8.166	7 7 7	8.158 8.322 8.489	7 7 7	9.071 9.055 9.041	7.785 8.005 8.234	14 14 14	8.035 8.205 8.384	7 7 7	8.981 8.983 8.987
10	1.25 1.25 1 0.75	8.344 8.619 8.891 9.166	9 7 7 7	8.986 9.158 9.322 9.489	9 7 7 7	10.087 10.071 10.055 10.041	8.553 8.785 9.005 9.234	18 14 14 14	8.853 9.035 9.205 9.384	9 7 7 7	9.979 9.981 9.983 9.987
11	1.5 1 0.75	9.344 9.891 10.166	9 7 7	9.986 10.322 10.489	9 7 7	11.087 11.055 11.041	9.553 10.005 10.234	18 14 14	9.853 10.205 10.384	9 7 7	10.979 10.983 10.987

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	GO THREAD RING GAUGE						NOT GO THREAD RING GAUGE				
NORMAL mm	PITCH P mm	MINOR mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJOR ø mm	MINOR ø mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJOR ø MIN mm
12	1.75	10.072	9	10.821	9	12.103	10.320	18	10.670	9	11.977
	1.5	10.344	9	10.986	9	12.087	10.545	18	10.845	9	11.979
	1.25	10.619	9	11.152	9	12.073	10.769	18	11.019	9	11.983
	1	10.891	7	11.322	7	12.055	10.999	14	11.199	7	11.983
14	2	11.797	9	12.655	9	14.117	12.094	18	12.494	9	13.973
	1.5	12.344	9	12.986	9	14.087	12.545	18	12.845	9	13.979
	1.25	12.619	9	13.152	9	14.073	12.769	18	13.019	9	13.983
	1	12.891	7	13.322	7	14.055	12.999	14	13.199	7	13.983
15	1.5	13.344	9	13.986	9	15.087	13.545	18	13.845	9	14.979
	1	13.891	7	14.322	7	15.055	13.999	14	14.199	7	14.983
16	2	13.797	9	14.655	9	16.117	14.094	18	14.494	9	15.973
	1.5	14.344	9	14.986	9	16.087	14.545	18	14.845	9	15.979
	1	14.891	7	15.322	7	16.055	14.999	14	15.199	7	15.983
17	1.5	15.344	9	15.986	9	17.087	15.545	18	15.845	9	16.979
	1	15.891	7	16.322	7	17.055	15.999	14	16.199	7	16.983
18	2.5	15.252	9	16.326	9	18.149	15.655	18	16.155	9	17.969
	2	15.797	9	16.655	9	18.177	16.094	18	16.494	9	17.973
	1.5	16.344	9	16.986	9	18.087	16.545	18	16.845	9	17.979
	1	16.891	7	17.322	7	18.055	16.999	14	17.199	7	17.983
20	2.5	17.252	9	18.326	9	20.149	17.655	18	18.155	9	19.969
	2	17.797	9	18.655	9	20.117	18.094	18	18.494	9	19.973
	1.5	18.344	9	18.986	9	20.087	18.545	18	18.845	9	19.979
	1	18.891	7	19.322	7	20.055	18.999	14	19.199	7	19.983
22	2.5	19.252	9	20.326	9	22.149	19.655	18	20.155	9	21.969
	2	19.797	9	20.655	9	22.117	20.094	18	20.494	9	21.973
	1.5	20.344	9	20.986	9	22.087	20.545	18	20.845	9	21.979
	1	20.891	7	21.322	7	22.055	20.999	14	21.199	7	21.983
24	3	20.704	9	21.995	9	24.180	21.194	18	21.794	9	23.963
	2	21.797	9	22.655	9	24.117	22.084	18	22.484	9	23.973
	1.5	22.344	9	22.986	9	24.087	22.535	18	22.835	9	23.979
	1	22.891	7	23.322	7	24.055	22.992	14	23.192	7	23.983
25	2	22.797	9	23.655	9	25.117	23.084	18	23.484	9	24.973
	1.5	23.344	9	23.986	9	25.087	23.535	18	23.835	9	24.979
	1	23.891	7	24.322	7	25.055	23.992	14	23.192	7	24.983
26	1.5	24.344	9	24.986	9	26.087	24.535	18	24.835	9	25.979
27	3	23.704	9	24.995	9	27.180	24.194	18	24.794	9	26.963
	2	24.797	9	25.655	9	27.117	25.084	18	25.484	9	26.973
	1.5	25.344	9	25.986	9	27.087	25.535	18	25.835	9	26.979
	1	25.891	7	26.322	7	27.055	25.992	14	26.192	7	26.983
28	2	25.797	9	26.655	9	28.117	26.084	18	26.484	9	27.973
	1.5	26.344	9	26.986	9	28.087	26.535	18	26.835	9	27.979
	1	26.891	7	27.322	7	28.055	26.992	14	27.192	7	27.983
30	3.5	26.158	11.5	27.662	11.5	30.214	26.7505	23	27.4505	11.5	29.961
	3	26.704	9	27.995	9	30.180	27.194	18	27.794	9	29.963
	2	27.797	9	28.655	9	30.117	28.084	18	28.484	9	29.973
	1.5	28.344	9	28.986	9	30.087	28.535	18	28.835	9	29.979
	1	28.891	7	29.322	7	30.055	28.992	14	29.192	7	29.983

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	GO THREAD RING GAUGE						NOT GO THREAD RING GAUGE				
NORMA L mm	PITCH P mm	MINO R mm	TOL ±µm	PITCH φ mm	TOL ±µm	MAJOR φ mm	MINOR φ mm	TOL ±µm	PITCH φ mm	TOL ±µm	MAJOR φ MIN mm
32	2	29.797	9	30.655	9	32.117	30.084	18	30.484	9	31.973
	1.5	30.344	9	30.986	9	32.087	30.535	18	30.835	9	31.979
33	3.5	29.158	11.5	30.662	11.5	33.214	29.7505	23	30.4505	11.5	32.961
	3	29.704	9	30.995	9	33.180	30.194	18	30.794	9	32.963
	2	30.797	9	31.655	9	33.117	31.084	18	31.484	9	32.973
	1.5	31.344	9	31.986	9	33.087	31.535	18	31.835	9	32.979
35	1.5	33.344	9	33.986	9	35.087	33.535	18	33.835	9	34.979
36	4	31.610	11.5	33.330	11.5	36.242	32.3065	23	33.1065	11.5	35.954
	3	32.704	9	33.995	9	36.180	33.194	18	33.794	9	35.963
	2	33.797	9	34.655	9	36.117	34.084	18	34.484	9	35.973
	1.5	34.344	9	34.986	9	36.087	34.535	18	34.835	9	35.979
38	1.5	36.344	9	36.986	9	38.087	36.535	18	36.835	9	37.979
39	4	34.610	11.5	36.330	11.5	39.242	35.3065	23	36.1065	11.5	38.954
	3	35.704	9	36.995	9	39.180	36.194	18	36.794	9	38.963
	2	36.797	9	37.655	9	39.117	37.084	18	37.484	9	38.973
	1.5	37.344	9	37.986	9	39.087	37.535	18	37.835	9	38.979
40	3	36.704	9	37.995	9	40.180	37.194	18	37.794	9	39.963
	2	37.797	9	38.655	9	40.117	38.084	18	38.484	9	39.973
	1.5	38.344	9	38.986	9	40.087	38.535	18	38.835	9	39.979
42	4.5	37.066	11.5	39.002	11.5	42.276	37.8665	23	38.7665	11.5	41.951
	4	37.610	11.5	39.330	11.5	42.242	38.3065	23	39.1065	11.5	41.954
	3	38.704	9	39.995	9	42.180	39.194	18	39.794	9	41.963
	2	39.797	9	40.655	9	42.117	40.084	18	40.484	9	41.973
	1.5	40.344	9	40.986	9	42.087	40.535	18	40.835	9	41.979
45	4.5	40.066	11.5	42.002	11.5	45.276	40.8665	23	41.7665	11.5	44.951
	4	40.610	11.5	42.330	11.5	45.242	41.3065	23	42.1065	11.5	44.954
	3	41.704	9	42.995	9	45.180	42.194	18	42.794	9	44.963
	2	42.797	9	43.655	9	45.117	43.084	18	43.484	9	44.973
	1.5	43.344	9	43.986	9	45.087	43.535	18	43.835	9	44.979
48	5	42.516	11.5	44.669	11.5	48.304	43.4195	23	44.4195	11.5	47.943
	4	43.610	11.5	45.330	11.5	48.242	44.2945	23	45.0945	11.5	47.954
	3	44.704	11.5	45.991	11.5	48.183	45.1795	23	45.7795	11.5	47.966
	2	45.797	9	46.655	9	48.117	46.074	18	46.474	9	47.973
	1.5	46.344	9	46.986	9	48.087	46.525	18	46.825	9	47.979
50	3	46.704	11.5	47.991	11.5	50.183	47.1795	23	47.7795	11.5	49.966
	2	47.797	9	48.655	9	50.117	48.074	18	48.474	9	49.973
	1.5	48.344	9	48.986	9	50.087	48.525	18	48.825	9	49.979
52	5	46.516	11.5	48.669	11.5	52.304	47.4195	23	48.4195	11.5	51.943
	4	47.610	11.5	49.330	11.5	52.242	48.2945	23	49.0945	11.5	51.954
	3	48.704	11.5	49.991	11.5	52.183	49.1795	23	49.7795	11.5	51.966
	2	49.797	9	50.655	9	52.117	50.074	18	50.474	9	51.973
	1.5	50.344	9	50.986	9	52.087	50.525	18	50.825	9	51.979
55	4	50.610	11.5	52.330	11.5	55.242	51.2945	23	52.0945	11.5	54.954
	3	51.704	11.5	52.991	11.5	55.183	52.1795	23	52.7795	11.5	54.966
	2	52.797	9	53.655	9	55.117	53.074	18	53.474	9	54.973
	1.5	53.344	9	53.986	9	55.087	53.525	18	53.825	9	54.979

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	GO THREAD RING GAUGE						NOT GO THREAD RING GAUGE				
NORMA L mm	PITCH P mm	MINO R mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJOR ø mm	MINOR ø Mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJORø MIN mm
56	5.5	49.971	11.5	53.341	11.5	56.336	50.9765	23	52.0765	11.5	55.939
	4	51.610	11.5	53.330	11.5	56.242	52.2945	23	53.0945	11.5	55.954
	3	52.704	11.5	53.991	11.5	56.183	53.1795	23	53.7795	11.5	55.966
	2	53.797	9	54.655	9	56.117	54.074	18	54.474	9	55.973
	1.5	54.344	9	54.986	9	56.087	54.525	18	54.825	9	55.979
58	4	53.610	11.5	55.330	11.5	58.242	54.2945	23	55.0945	11.5	57.954
	3	54.704	11.5	55.991	11.5	58.183	55.1795	23	55.7795	11.5	57.966
	2	55.797	9	56.655	9	58.117	56.074	18	56.474	9	57.973
	1.5	56.344	9	56.986	9	58.087	56.525	18	56.825	9	57.979
60	5.5	53.971	11.5	56.341	11.5	60.336	54.9765	23	56.0765	11.5	59.939
	4	55.610	11.5	57.330	11.5	60.242	56.2945	23	57.0945	11.5	59.954
	3	56.704	11.5	57.991	11.5	60.183	57.1795	23	57.7795	11.5	59.966
	2	57.797	9	58.655	9	60.117	58.074	18	58.474	9	59.973
	1.5	58.344	9	58.986	9	60.087	58.525	18	58.825	9	59.979
62	4	57.610	11.5	59.330	11.5	62.242	58.2945	23	59.0945	11.5	61.954
	3	58.704	11.5	59.991	11.5	62.183	59.1795	23	59.7795	11.5	61.966
	2	59.797	9	60.555	9	62.117	60.074	18	60.474	9	61.973
	1.5	60.344	9	60.986	9	62.087	60.525	18	60.825	9	61.979
64	6	57.425	11.5	60.011	11.5	64.367	58.5315	23	59.7315	11.5	63.934
	4	59.610	11.5	61.330	11.5	64.242	60.2945	23	61.0945	11.5	63.954
	3	60.704	11.5	61.991	11.5	64.183	61.1795	23	61.7795	11.5	63.966
	2	61.797	9	62.655	9	64.117	62.074	18	62.474	9	63.973
	1.5	62.344	9	62.986	9	64.087	62.525	18	62.825	9	63.979
65	4	60.610	11.5	62.330	11.5	65.242	61.2945	23	62.0945	11.5	64.954
	3	61.704	11.5	62.991	11.5	65.183	62.1795	23	62.7795	11.5	64.966
	2	62.797	9	63.655	9	65.117	63.074	18	63.474	9	64.973
	1.5	63.344	9	63.986	9	65.087	63.525	18	63.825	9	64.979
68	6	61.425	11.5	64.011	11.5	68.367	62.5315	23	63.7315	11.5	67.934
	4	63.610	11.5	65.330	11.5	68.242	64.2945	23	65.0945	11.5	67.954
	3	64.704	11.5	65.991	11.5	68.183	65.1795	23	65.7795	11.5	67.966
	2	65.797	9	66.655	9	68.117	66.074	18	66.474	9	67.973
	1.5	66.344	9	66.986	9	68.087	66.525	18	66.825	9	67.979
70	6	63.425	11.5	66.011	11.5	70.367	64.5315	23	65.7315	11.5	69.934
	4	65.610	11.5	67.330	11.5	70.242	66.2945	23	67.0945	11.5	69.954
	3	66.704	11.5	67.991	11.5	70.183	67.1795	23	67.7795	11.5	69.966
	2	67.797	9	68.655	9	70.117	68.074	18	68.474	9	69.973
	1.5	68.344	9	68.986	9	70.087	68.525	18	68.825	9	69.979
72	6	65.425	11.5	68.011	11.5	72.367	66.5315	23	67.7315	11.5	71.934
	4	67.610	11.5	69.330	11.5	72.242	68.2945	23	69.0945	11.5	71.954
	3	68.704	11.5	69.991	11.5	72.183	69.1795	23	69.7795	11.5	71.966
	2	69.797	9	70.655	9	72.117	70.074	18	70.474	9	71.973
	1.5	70.344	9	70.986	9	72.087	70.525	18	70.825	9	71.979
75	4	70.610	11.5	72.330	11.5	75.242	71.2945	23	72.0945	11.5	74.954
	3	71.704	11.5	72.991	11.5	75.183	72.1795	23	72.7795	11.5	74.966
	2	72.797	9	73.655	9	75.117	73.074	18	73.474	9	74.973
	1.5	73.344	9	73.986	9	75.085	73.525	18	73.825	9	74.979

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NORMA L mm	PITCH P mm	MINO R mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJOR ø mm	MINOR ø mm	TOL ±µm	PITCH ø mm	TOL ±µm	MAJOR ø MIN mm
76	6	69.425	11.5	72.011	11.5	76.367	70.5315	23	71.7315	11.5	75.934
	4	71.610	11.5	73.330	11.5	76.242	72.2945	23	73.0945	11.5	75.954
	3	72.704	11.5	73.991	11.5	76.183	73.1795	23	73.7795	11.5	75.966
	2	73.797	9	74.655	9	76.117	74.074	18	74.474	9	75.973
	1.5	74.344	9	74.986	9	76.087	74.525	18	74.824	9	75.979
78	2	75.797	9	76.655	9	78.117	76.074	18	76.474	9	77.973
80	6	73.425	11.5	76.011	11.5	80.367	74.5315	23	75.7315	11.5	79.934
	4	75.610	11.5	77.330	11.5	80.242	76.2945	23	77.0945	11.5	79.954
	3	76.704	11.5	77.991	11.5	80.183	77.1795	23	77.7795	11.5	79.966
	2	77.797	9	78.655	11.5	80.117	78.074	18	78.474	9	79.973
	1.5	78.344	9	78.986	9	80.087	78.525	18	78.825	9	79.979
82	2	79.797	9	80.655	9	82.117	80.074	18	80.474	9	81.973
85	6	78.425	11.5	81.011	11.5	85.367	79.5315	23	80.7315	11.5	84.934
	4	80.610	11.5	82.330	11.5	85.242	81.2945	23	82.0945	11.5	84.954
	3	81.704	11.5	82.991	11.5	85.183	82.1795	23	82.7795	11.5	84.966
	2	82.797	9	83.655	9	85.117	83.074	18	83.474	9	84.973
90	6	83.425	11.5	86.011	11.5	90.367	84.5315	23	85.7315	11.5	89.934
	4	85.610	11.5	87.330	11.5	90.242	86.2945	23	87.0945	11.5	89.954
	3	86.704	11.5	87.991	11.5	90.183	87.1795	23	87.7795	11.5	89.966
	2	87.797	9	88.655	9	90.117	88.074	18	88.474	9	89.973
95	6	88.425	11.5	91.011	11.5	95.367	89.5115	23	90.7115	11.5	94.934
	4	90.610	11.5	92.330	11.5	95.242	91.2805	23	92.0805	11.5	94.954
	3	91.704	11.5	92.991	11.5	95.183	92.1675	23	92.7675	11.5	94.966
	2	92.797	9	93.655	9	95.117	93.064	18	93.464	9	94.973
100	6	93.425	11.5	96.011	11.5	100.367	94.5115	23	95.7115	11.5	99.934
	4	95.610	11.5	97.330	11.5	100.242	96.2805	23	97.0805	11.5	99.954
	3	96.704	11.5	97.991	11.5	100.183	97.1675	23	97.7675	11.5	99.966
	2	97.797	9	98.655	9	100.117	98.064	18	98.464	9	99.973

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