

BRITISH STANDARD

Specification for gauge blanks

Part 1: Plug, ring and calliper gauges

ICS 17.040.30

Publishing and copyright information

The BSI copyright notice displayed in this document indicates when the document was last issued.

© BSI 2009

ISBN 978 0 580 68742 6

The following BSI references relate to the work on this standard:

Committee reference TDW/4

Draft for comment 08/30177726 DC

Publication history

First published 1942

Second edition, June 1964

Third edition, November 2008

Amendments issued since publication

Amd. no.	Date	Text affected
C1	October 2009	See foreword

Contents

Foreword *iv*

1 Scope *1*

Section 1: General *2*

2 Removal of sharp edges *2*

3 Centres *2*

4 Stabilization *2*

Section 2: Plain and screw plug gauges renewable end types *3*

5 Gauging members and handles *3*

6 Plain plug gauging members *24*

7 Screw plug gauging members *29*

8 Plug gauges other than cylindrical *37*

Section 3: Plain and screw ring gauges and plain gap gauges, solid types *40*

9 Plain ring gauges *40*

10 Screw ring gauges *40*

11 Plain gap gauges, solid type *45*

Section 4: Adjustable screw ring gauges *47*

12 General *47*

13 Dimensions for adjustable screw ring gauge blanks for parallel threads *48*

Annexes

Annex A (informative) Types of gauges *57*

Annex B (informative) Recommendations for adjustable calliper gauges *60*

Bibliography *62*

List of figures

Figure 1 – Protected centre *2*

Figure 2 – Collet type plain plug gauges (Range: above 0.015 in up to and including 0.760 in) *4*

Figure 3 – Collet type screw plug gauges (Range: above 0.030 in up to and including 0.760 in) *5*

Figure 4 – Taper lock plug gauges *15*

Figure 5 – Trilock plain cylindrical plug gauges (Range: above 1.510 in up to and including 2.510 in) *17*

Figure 6 – Trilock screw plug gauges (Range: above 1.510 in up to and including 2.510 in) *18*

Figure 7 – Trilock plain cylindrical plug gauges (Range: above 2.510 in up to and including 8.010 in) *19*

Figure 8 – Trilock screw plug gauges (Range: above 2.510 in up to and including 8.010 in) *20*

Figure 9 – Annular design ball handle type plug gauges (Range: above 8.010 in up to and including 12.010 in) *22*

Figure 10 – Annular plug gauges – Bar handle types *23*

Figure 11 – Ball handles *28*

Figure 12 – Example of built-up gap gauge *46*

Figure 13 – Adjustable screw ring gauge, showing details of construction *47*

Figure 14 – Range: 0.059 in up to and including 0.150 in *48*

Figure 15 – Ranges: above 0.150 in up to and including 0.510 in, GO and NOT GO, all pitches; above 0.510 in up to and including 4.760 in, GO and NOT GO, fine pitches; above 0.510 in up to and including 4.760 in, NOT GO only, coarse pitches 49

Figure 16 – Range: above 0.510 in up to and including 4.760 in, GO only, coarse pitches 49

Figure 17 – Range: above 4.760 in up to and including 8.010 in 49

Figure B.1 – Adjustable calliper types 61

List of tables

Table 1 – Collet type plug gauge handles (Range: above 0.015 in up to and including 0.760 in) 6

Table 2 – Double end collet type plug gauge handles – Details of body 7

Table 3 – Collet type plug gauge handles – Details of capping nut 8

Table 4 – Single end collet type plug gauge handles – Details of body 9

Table 5 – Collet type plug gauge nuts 10

Table 6 – Collet type plug gauge collets 11

Table 7 – Taper lock handle nos. 000 to 5 16

Table 8 – Trilock handles (Range: above 1.510 in up to and including 8.010 in) 21

Table 9 – Collet type plain cylindrical plug gauging members (Range: above 0.015 in up to and including 0.760 in) 24

Table 10 – Taper lock plain cylindrical plug gauging members 25

Table 11 – Trilock plain cylindrical plug gauging members 26

Table 12 – Annular design plain cylindrical plug gauging members (Range: above 8.010 in up to and including 12.010 in) 27

Table 13 – Collet type screw plug gauging members (Range: above 0.030 in up to and including 0.760 in) 29

Table 14 – Taper lock screw plug and single length setting plug gauging members (Range: above 0.059 in up to and including 2.510 in) 30

Table 15 – Taper lock fine pitch instrument thread plug gauging members (Range: above 0.059 in up to and including 2.510 in) 31

Table 16 – Taper lock double length setting plug gauging members (Range: above 0.059 in up to and including 2.510 in) 32

Table 17 – Trilock screw plug gauging members (Range: above 1.510 in up to and including 8.010 in) 33

Table 18 – Trilock fine pitch instrument thread plug gauging members (Range: above 1.510 in up to and including 2.510 in) 34

Table 19 – Trilock double length setting plug gauging members (Range: above 1.510 in up to and including 8.010 in) 35

Table 20 – Annular screw plug gauging members (Range: above 8.010 in up to and including 12.010 in) 36

Table 21 – Segmental cylindrical gauges (Range: above 1.260 in up to and including 8.010 in) 37

Table 22 – Spherical ended rod gauges (Range: above 0.510 in up to and including 12.01 in) 39

Table 23 – Plain ring gauges – solid type (Range: up to and including 12.260 in) 41

Table 24 – Screw ring gauges – solid type (Range: up to and including 12.260 in) 43

Table 25 – Plain gap gauges – solid type (Range: above $\frac{1}{4}$ in up to and including $10\frac{3}{4}$ in) 45

Table 26 – Adjustable screw ring gauges (Range: 0.059 in up to and including 4.760 in; also fine pitch instrument thread ring gauges 0.059 in up to and including 0.240 in) 50

Table 27 – Fine-pitch instrument thread adjustable screw ring gauges (Range: above 0.240 in up to and including 2.510 in) 52

Table 28 – Adjustable screw ring gauges (Range: above 4.760 in up to and including 8.010 in) 53

Table 29 – Adjustable screw ring gauge adjusting screws 54

Table 30 – Adjustable screw ring gauge sleeves 55

Table 31 – Adjustable screw ring gauge locking screws 56

Table A.1 – Check gauges for taper lock gauging members and handles (see A.3.1) 59

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 62, an inside back cover and a back cover.

Foreword

This British Standard is published by BSI and came into effect on 30 November 2008. It was prepared by Technical Committee TDW/4, *Technical product realization*.

Supersession

This Part of BS 1044 supersedes BS 1044-1:1964, which is withdrawn.

Relationship with other publications

Tolerances for the plain limit gauges and screw thread gauges are specified in BS 969 and BS 919, respectively.

Regarding the methods of manufacturing gauges and their measurement to verify their accuracy, attention is drawn to the National Physical Laboratory's "Notes on Screw Gauges" [1].

Information about this document

This Part of BS 1044 has been fully revised to bring it up to date.

The start and finish of text introduced or altered by Corrigendum No. 1 is indicated in the text by tags C1 C1.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is "shall".

Commentary, explanation and general informative material is presented in notes in smaller italic type, and does not constitute a normative element.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

1 Scope

This British Standard specifies requirements for gauge blanks for plug, ring and calliper gauges.

Those features of design necessary to ensure interchangeability are specified in some detail, while general information on other features is included for guidance in the manufacture of these gauges.

Section 1 specifies general requirements for the manufacture of gauges.

Section 2 relates to plain and screw plug gauges and setting plugs.

Section 3 deals with solid plain and screw ring gauges and solid plain gap gauges.

Section 4 deals with adjustable screw ring gauges.

The various types of gauges are listed in Annex A. Recommendations for adjustable plain and screw calliper gauges are given in Annex B.

Section 1: General

2 Removal of sharp edges

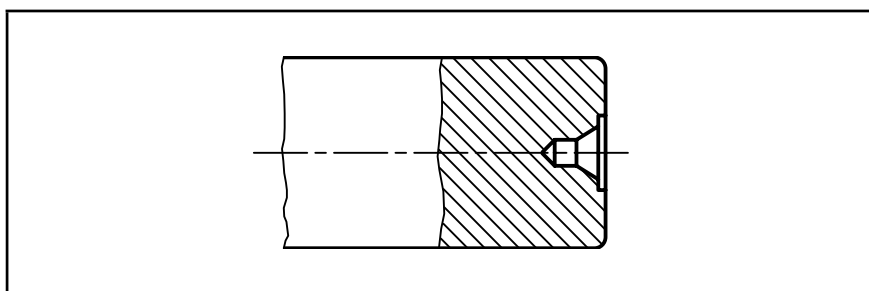
All non-gauging sharp edges shall be removed.

3 Centres

Large internal centres shall be avoided. The length of the cone shall be kept short.

The mouth of the internal centre, wherever practicable, shall be protected by a small recess $\frac{1}{32}$ in or $\frac{1}{16}$ in deep as shown in Figure 1.

Figure 1 **Protected centre**



4 Stabilization

Blanks can be supplied in the soft or hard condition. Hardened steel blanks, more particularly those of the larger sizes, shall be stabilized before they are completed.

NOTE 1 When blanks are required to be hardened throughout, e.g. for threading, this should be as specified by the purchaser.

NOTE 2 A recommended stabilizing treatment is to heat the gauges to 150 °C and maintain them at this temperature for approximately 10 h followed by slow cooling.

Section 2: Plain and screw plug gauges renewable end types

5 Gauging members and handles

NOTE 1 The lengths recommended for the handles of plug gauges are those suitable for gauges for normal applications. Where gauges have to be used in confined situations, longer or shorter handles may be desirable.

NOTE 2 When gauging members are worn out or discarded for any other reason, new gauging members may be fitted to the handles. This is an economical feature since, with reasonable care, the handles will last indefinitely. Information on gauging members and handles is given in A.3.

5.1 Collet type plug gauges

The general construction of gauging members and handles for collet type plug gauges shall be in accordance with Figure 2 and Figure 3, as applicable. The dimensions of trilock plug gauges shall conform to Table 1 to Table 6, as applicable.

Collets in sizes 1W and 2W shall be made of brass and those for the larger sizes of aluminium.

NOTE Handles for collet type gauges are hexagonal with clamping nuts, and are provided in both single end and double end types.

Figure 2 Collet type plain plug gauges (Range: above 0.015 in up to and including 0.760 in)

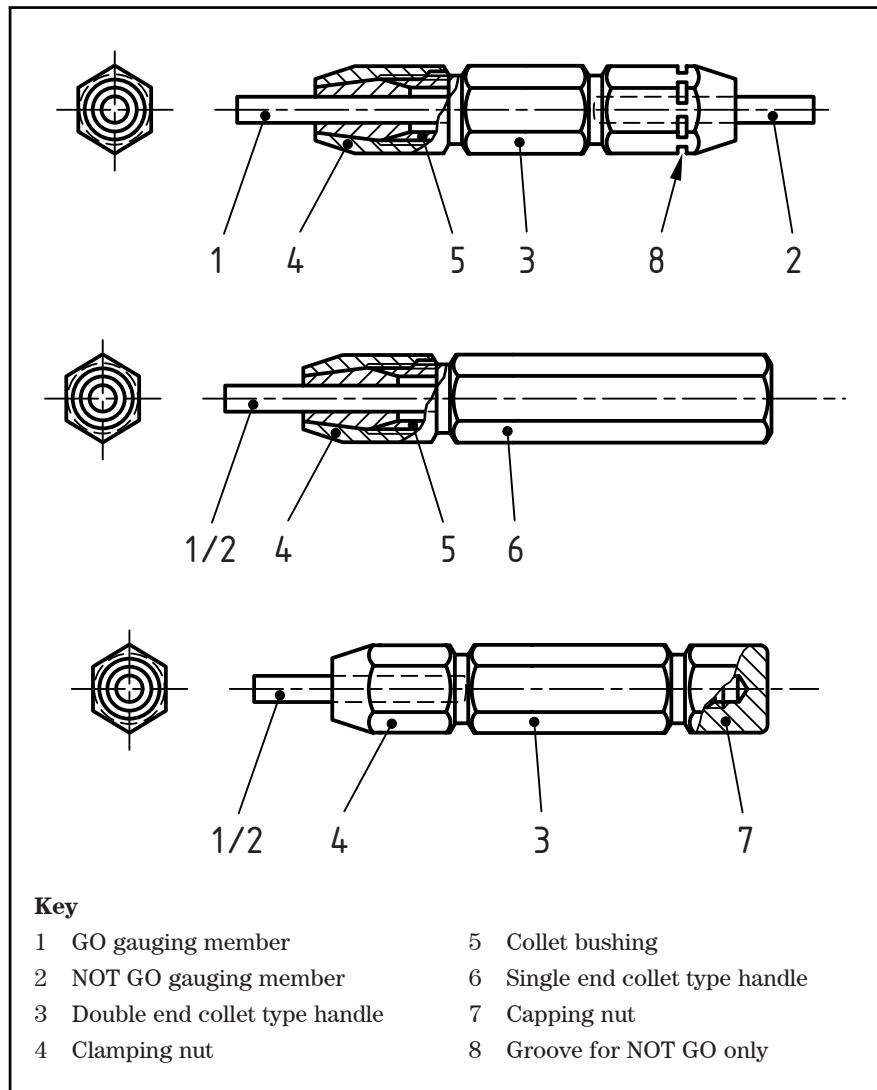


Figure 3 Collet type screw plug gauges (Range: above 0.030 in up to and including 0.760 in)

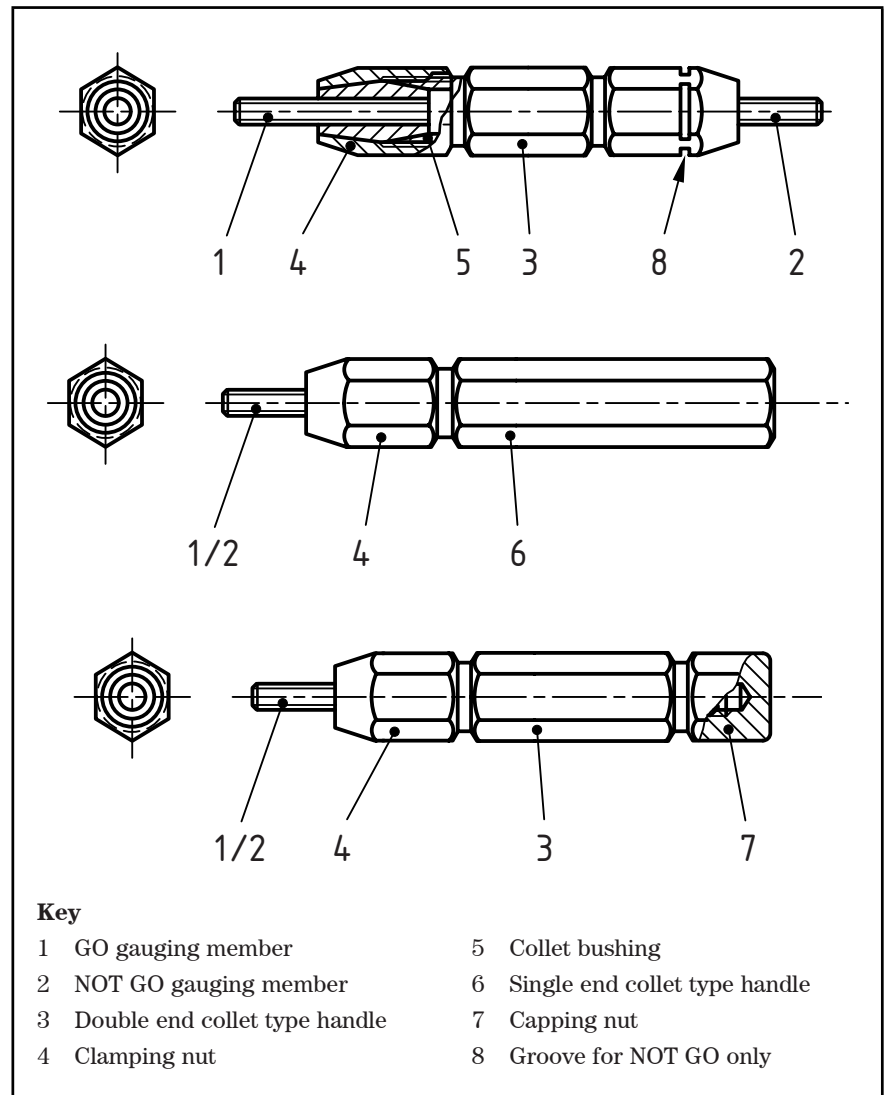
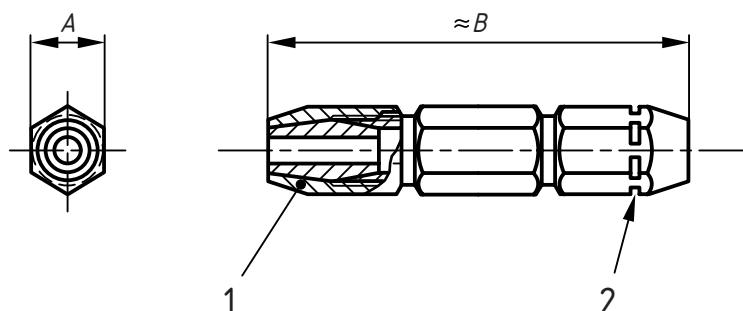
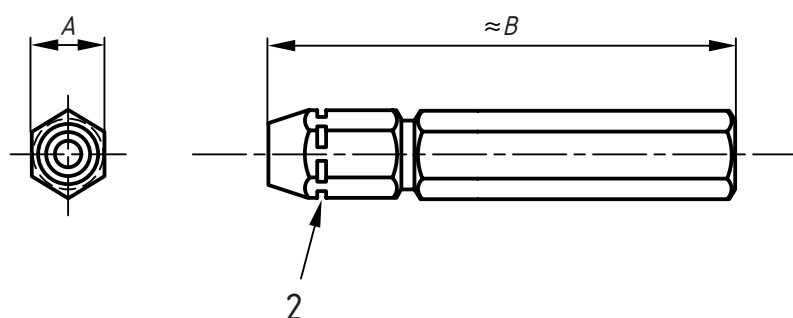


Table 1 **Collet type plug gauge handles**
(Range: above 0.015 in up to and including 0.760 in)

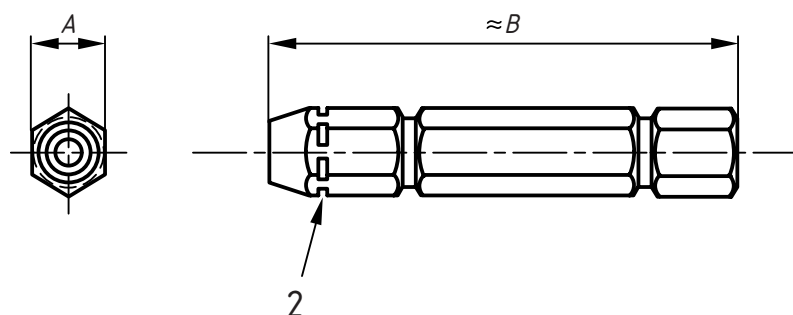
a) Double end type



b) Single end type (preferred)



c) Single end type (alternative)



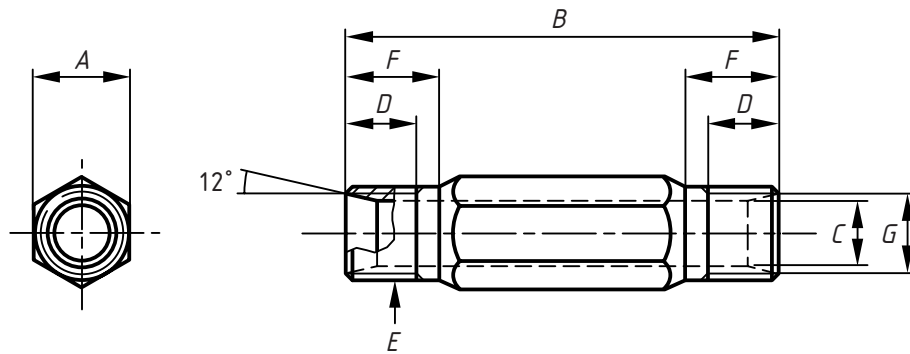
NOTE The alternative single end type is a double end type converted to suit single end applications.

Key

1 Suitable bushing or collet to hold gauging members firmly 2 Groove for NOT GO only

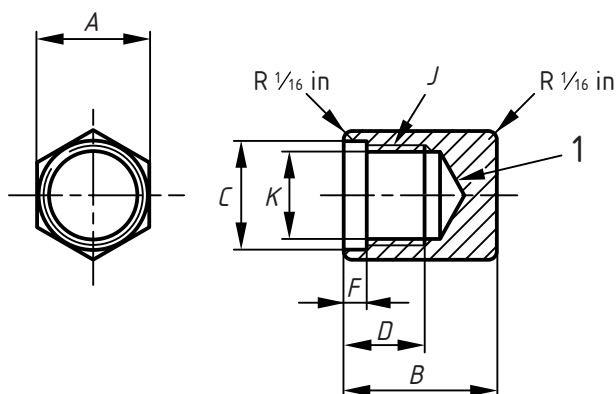
1	2	3	4	5	6	7
Handle size No.			Size range, nominal		A	B
Double end	Single end	Single end (alt.)	Above	To and including		
1 W	1 W-S	1 W-A	0.015	0.075	$\frac{1}{4}$	$1\frac{29}{32}$
2 W	2 W-S	2 W-A	0.075	0.180	$\frac{3}{8}$	$2\frac{15}{32}$
3 W	3 W-S	3 W-A	0.180	0.281	$\frac{9}{16}$	$3\frac{1}{8}$
4 W	4 W-S	4 W-A	0.281	0.406	$\frac{11}{16}$	$3\frac{19}{32}$
5 W	5 W-S	5 W-A	0.406	0.510	$\frac{13}{16}$	$4\frac{3}{16}$
6 W	6 W-S	6 W-A	0.510	0.635	$\frac{15}{16}$	$4\frac{17}{32}$
7 W	7 W-S	7 W-A	0.635	0.760	$1\frac{1}{16}$	$4\frac{21}{32}$

Table 2 Double end collet type plug gauge handles – Details of body



1	2	3	4	5	6	7	8	9	10
Handle size No.	Size range, nominal		A	B	C	D	E	F	G
	Above	Up to and including							
1 W	in 0.015	in 0.075	in $\frac{1}{4}$	in $1\frac{5}{16}$	in $\frac{3}{32}$	in $\frac{9}{32}$	12-32 UNEF-2A	in $\frac{21}{64}$	in 0.151
2 W	0.075	0.180	$\frac{3}{8}$	$1\frac{27}{32}$	$\frac{3}{16}$	$\frac{5}{16}$	$\frac{5}{16}$ -32 UNEF-2A	$\frac{7}{16}$	0.235
3 W	0.180	0.281	$\frac{9}{16}$	$2\frac{1}{8}$	$\frac{19}{64}$	$\frac{13}{32}$	$\frac{1}{2}$ -28 UNEF-2A	$\frac{1}{2}$	0.348
4 W	0.281	0.406	$\frac{11}{16}$	$2\frac{19}{32}$	$\frac{27}{64}$	$\frac{7}{16}$	$\frac{5}{8}$ -28 UN-2A	$\frac{5}{8}$	0.473
5 W	0.406	0.510	$\frac{13}{16}$	$3\frac{1}{16}$	$\frac{33}{64}$	$\frac{5}{8}$	$\frac{3}{4}$ -28 UN-2A	$\frac{3}{4}$	0.588
6 W	0.510	0.635	$\frac{15}{16}$	$3\frac{1}{4}$	$\frac{41}{64}$	$\frac{5}{8}$	$\frac{7}{8}$ -28 UN-2A	$\frac{3}{4}$	0.740
7 W	0.635	0.760	$1\frac{1}{16}$	$3\frac{3}{8}$	$\frac{49}{64}$	$\frac{5}{8}$	1-28 UN-2A	$\frac{3}{4}$	0.865

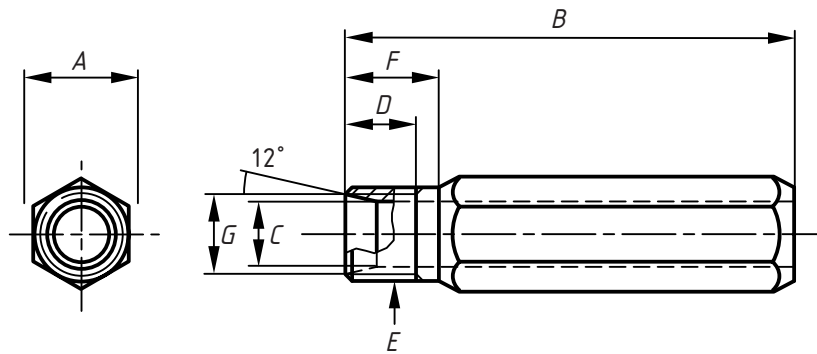
Table 3 Collet type plug gauge handles – Details of capping nut

**Key**

1 118° drill point

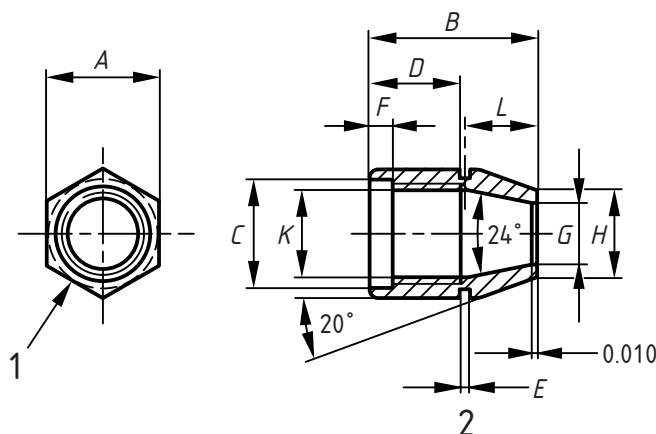
1	2	3	4	5	6	7	8	9	10
Handle size No.	Size range, nominal		A	B	C	D	F	J	K
	Above	Up to and including							
1 W-A	in 0.015	in 0.075	in $\frac{1}{4}$	in $\frac{5}{8}$	in 0.220 0.230	in $\frac{5}{16}$	$\frac{3}{32}$	in 12-32 UNEF-2B	in 0.182 2 0.189 5
2 W-A	0.075	0.180	$\frac{3}{8}$	$\frac{11}{16}$	0.316 0.326	$\frac{3}{8}$	$\frac{1}{8}$	$\frac{5}{16}$ -32 UNEF-2B	0.278 7 0.286 1
3 W-A	0.180	0.281	$\frac{9}{16}$	$\frac{15}{16}$	0.504 0.514	$\frac{7}{16}$	$\frac{1}{8}$	$\frac{1}{2}$ -28 UNEF-2B	0.461 3 0.469 7
4 W-A	0.281	0.406	$\frac{11}{16}$	$1\frac{1}{16}$	0.630 0.640	$\frac{9}{16}$	$\frac{1}{4}$	$\frac{5}{8}$ -28 UN-2B	0.586 3 0.594 7
5 W-A	0.406	0.510	$\frac{13}{16}$	$1\frac{1}{4}$	0.755 0.765	$\frac{11}{16}$	$\frac{3}{16}$	$\frac{3}{4}$ -28 UN-2B	0.711 3 0.719 7
6 W-A	0.510	0.635	$\frac{15}{16}$	$1\frac{9}{32}$	0.880 0.890	$\frac{11}{16}$	$\frac{3}{16}$	$\frac{7}{8}$ -28 UN-2B	0.836 3 0.844 7
7 W-A	0.635	0.760	$1\frac{1}{16}$	$1\frac{9}{32}$	1.005 1.015	$\frac{11}{16}$	$\frac{3}{16}$	1-28 UN-2B	0.961 3 0.969 7

Table 4 Single end collet type plug gauge handles – Details of body



1	2	3	4	5	6	7	8	9	10
Handle size No.	Size range, nominal		A	B	C	D	E	F	G
	Above	Up to and including							
1 W-S	0.015	0.075	$\frac{1}{4}$	$1\frac{5}{8}$	$\frac{3}{32}$	$\frac{9}{32}$	12-32 UNEF-2A	$\frac{21}{64}$	0.151
2 W-S	0.075	0.180	$\frac{3}{8}$	$2\frac{5}{32}$	$\frac{3}{16}$	$\frac{5}{16}$	$\frac{5}{16}$ -32 UNEF-2A	$\frac{7}{16}$	0.235
3 W-S	0.180	0.281	$\frac{9}{16}$	$2\frac{5}{8}$	$\frac{19}{64}$	$\frac{13}{32}$	$\frac{1}{2}$ -28 UNEF-2A	$\frac{1}{2}$	0.348
4 W-S	0.281	0.406	$\frac{11}{16}$	$3\frac{3}{32}$	$\frac{27}{64}$	$\frac{7}{16}$	$\frac{5}{8}$ -28 UN-2A	$\frac{5}{8}$	0.473
5 W-S	0.406	0.510	$\frac{13}{16}$	$3\frac{5}{8}$	$\frac{33}{64}$	$\frac{5}{8}$	$\frac{3}{4}$ -28 UN-2A	$\frac{3}{4}$	0.588
6 W-S	0.510	0.635	$\frac{15}{16}$	$3\frac{7}{8}$	$\frac{41}{64}$	$\frac{5}{8}$	$\frac{7}{8}$ -28 UN-2A	$\frac{3}{4}$	0.740
7 W-S	0.635	0.760	$1\frac{1}{16}$	4	$\frac{49}{64}$	$\frac{5}{8}$	1-28 UN-2A	$\frac{3}{4}$	0.865

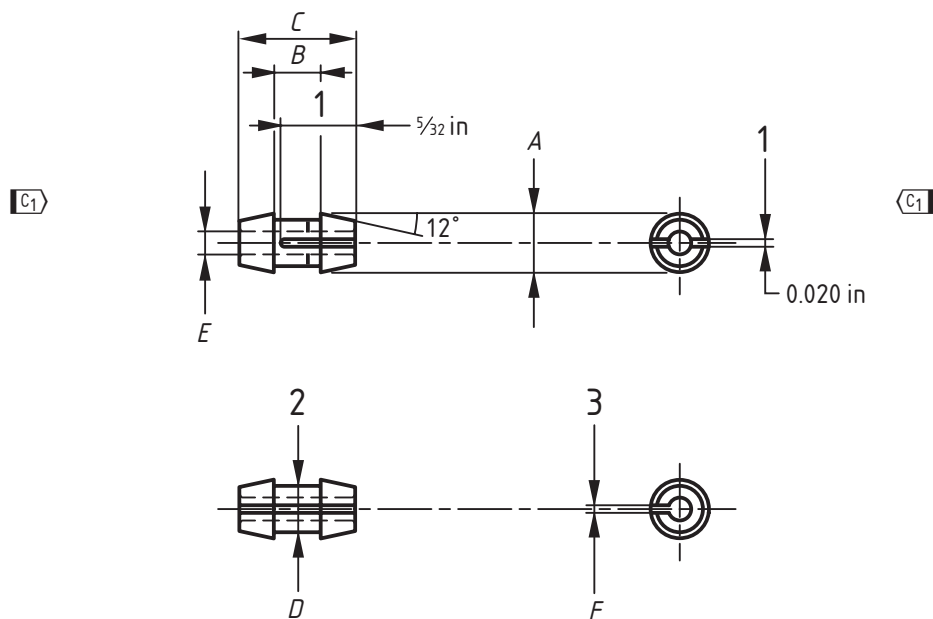
Table 5 Collet type plug gauge nuts

**Key**

- 1 Groove *E* not to cut through flats
 2 *E* for NOT GO only

1	2	3	4	5	6	7	8	9	10	11	12	13	14
Handle size No.	Size range, nominal		<i>A</i>	<i>B</i>	<i>C</i>	<i>D</i>	<i>E</i>	<i>F</i>	<i>G</i>	<i>H</i>	<i>J</i>	<i>K</i>	<i>L</i>
	Above	Up to and including											
1 W	in 0.015	in 0.075	in $\frac{1}{4}$	in $\frac{9}{16}$	in 0.220 0.230	in $\frac{11}{32}$	in $\frac{1}{32}$	in $\frac{3}{32}$	in 0.083 0.078	in $\frac{7}{32}$	12-32 UNEF-2B	in 0.182 2 0.189 5	in $\frac{5}{32}$
2 W	0.075	0.180	$\frac{3}{8}$	$\frac{11}{16}$	0.316 0.326	$\frac{7}{16}$	$\frac{1}{32}$	$\frac{1}{8}$	0.190 0.185	$\frac{5}{16}$	$\frac{5}{16}$ -32 UNEF-2B	0.278 7 0.286 1	$\frac{7}{32}$
3 W	0.180	0.281	$\frac{9}{16}$	$\frac{15}{16}$	0.504 0.514	$\frac{1}{2}$	$\frac{1}{16}$	$\frac{1}{8}$	0.290 0.285	$\frac{7}{16}$	$\frac{1}{2}$ -28 UNEF-2B	0.461 3 0.469 7	$\frac{13}{32}$
4 W	0.281	0.406	$\frac{11}{16}$	$1\frac{1}{16}$	0.630 0.640	$\frac{5}{8}$	$\frac{1}{16}$	$\frac{1}{4}$	0.417 0.412	$\frac{9}{16}$	$\frac{5}{8}$ -28 UN-2B	0.586 3 0.594 7	$\frac{7}{16}$
5 W	0.406	0.510	$\frac{13}{16}$	$1\frac{1}{4}$	0.755 0.765	$\frac{3}{4}$	$\frac{1}{16}$	$\frac{3}{16}$	0.520 0.515	$\frac{21}{32}$	$\frac{3}{4}$ -28 UN-2B	0.711 3 0.719 7	$\frac{1}{2}$
6 W	0.510	0.635	$\frac{15}{16}$	$1\frac{9}{32}$	0.880 0.890	$\frac{13}{16}$	$\frac{1}{16}$	$\frac{3}{16}$	0.645 0.640	$\frac{3}{4}$	$\frac{7}{8}$ -28 UN-2B	0.836 3 0.844 7	$\frac{1}{2}$
7 W	0.635	0.760	$1\frac{1}{16}$	$1\frac{9}{32}$	1.005 1.015	$\frac{13}{16}$	$\frac{1}{16}$	$\frac{3}{16}$	0.770 0.765	$\frac{7}{8}$	1-28 UN-2B	0.961 3 0.969 7	$\frac{1}{2}$

Table 6 Collet type plug gauge collets

**Key**

1 Slot from each end 0.020 in wide $\times \frac{5}{32}$ in deep, where $E < 0.050$ in dia.

2 in 1-W and 2-W only

3 Slot F through collet where $E \geq 0.050$ in dia.

1	2	3	4	5	6	7	8	9	10
Collet No. (E dia.)	Size range, nominal	A		B		C	D	F	
		max.	min.	max.	min.			max.	min.
∇C_1 1-W-.020	in 0.015–0.020	0.168	0.162	0.065	0.059	$\frac{17}{64}$	$\frac{3}{32}$	—	—
1-W-.025	0.020–0.025							—	—
1-W-.030	0.025–0.030							—	—
1-W-.035	0.030–0.035							—	—
1-W-.040	0.035–0.040							—	—
1-W-.045	0.040–0.045							—	—
1-W-.050	0.045–0.050	0.168	0.162	0.065	0.059	$\frac{17}{64}$	$\frac{1}{8}$	0.035	0.015
1-W-.055	0.050–0.055								
1-W-.060	0.055–0.060								
1-W-.065	0.060–0.065								
1-W-.070	0.065–0.070								
1-W-.075 ∇C_1	0.070–0.075								

NOTE Collets to be adjustable for any plug within the respective size ranges tabulated.

Table 6 Collet type plug gauge collets (*continued*)

1	2	3	4	5	6	7	8	9	10
Collet No. (E dia.)	Size range, nominal	A		B		C	D	F	
		max.	min.	max.	min.			max.	min.
2-W.082	in	in	in	in	in	in	in	in	in
2-W.089	0.075–0.082								
2-W.096	0.082–0.089								
2-W.103	0.089–0.096	0.243	0.237	0.190	0.184	$\frac{13}{32}$	$\frac{5}{32}$	0.045	0.025
2-W.110	0.096–0.103								
2-W.117	0.103–0.110								
2-W.124	0.110–0.117								
2-W.131	0.117–0.124								
2-W.138	0.124–0.131								
2-W.145	0.131–0.138								
2-W.152	0.138–0.145								
2-W.159	0.145–0.152	0.243	0.237	0.190	0.184	$\frac{13}{32}$	$\frac{7}{32}$	0.045	0.025
2-W.166	0.152–0.159								
2-W.173	0.159–0.166								
2-W.180	0.166–0.173								
3-W.188	0.173–0.180								
3-W.196	0.180–0.188								
3-W.204	0.188–0.196								
3-W.212	0.196–0.204								
3-W.220	0.204–0.212								
3-W.228	0.212–0.220								
3-W.236	0.220–0.228	0.398	0.392	0.159	0.153	$\frac{9}{16}$	—	0.058	0.038
3-W.244	0.228–0.236								
3-W.252	0.236–0.244								
3-W.261	0.244–0.252								
3-W.271	0.252–0.261								
3-W.281	0.261–0.271								
3-W.281	0.271–0.281								

NOTE Collets to be adjustable for any plug within the respective size ranges tabulated.

Table 6 Collet type plug gauge collets (*continued*)

1	2	3	4	5	6	7	8	9	10
Collet No. (E dia.)	Size range, nominal	A		B		C	D	F	
		max.	min.	max.	min.			max.	min.
4-W.291	0.281–0.291	0.518	0.512	0.159	0.153	$\frac{17}{32}$	—	0.058	0.038
4-W.301	0.291–0.301								
4-W.311	0.301–0.311								
4-W.321	0.311–0.321								
4-W.331	0.321–0.331								
4-W.341	0.331–0.341								
4-W.351	0.341–0.351								
4-W.361	0.351–0.361								
4-W.371	0.361–0.371								
4-W.382	0.371–0.382								
4-W.394	0.382–0.394								
4-W.406	0.394–0.406								
5-W.420	0.406–0.420	0.643	0.637	0.159	0.153	$\frac{19}{32}$	—	0.072	0.052
5-W.436	0.420–0.436								
5-W.450	0.436–0.450								
5-W.465	0.450–0.465								
5-W.480	0.465–0.480								
5-W.495	0.480–0.495								
5-W.510	0.495–0.510								
6-W.532	0.510–0.532	0.788	0.782	0.174	0.168	$\frac{11}{16}$	—	0.072	0.052
6-W.547	0.532–0.547								
6-W.563	0.547–0.563								
6-W.579	0.563–0.579								
6-W.594	0.579–0.594								
6-W.610	0.594–0.610								
6-W.625	0.610–0.625								
6-W.640	0.625–0.640								

NOTE Collets to be adjustable for any plug within the respective size ranges tabulated.

Table 6 Collet type plug gauge collets (*continued*)

1	2	3	4	5	6	7	8	9	10
Collet No. (<i>E</i> dia.)	Size range, nominal	<i>A</i>		<i>B</i>		<i>C</i>	<i>D</i>	<i>F</i>	
		max.	min.	max.	min.			max.	min.
$\overline{C_1}$ 7-W-.656	0.640–0.656	in	in	in	in	in	in	in	in
7-W-.672	0.656–0.672								
7-W-.688	0.672–0.688								
7-W-.704	0.688–0.704	0.909	0.903	0.174	0.168	$\frac{11}{16}$	—	0.135	0.115
7-W-.719	0.704–0.719								
7-W-.735	0.719–0.735								
7-W-.750	0.735–0.750								
7-W-.760 $\overline{C_1}$	0.750–0.765								
<i>NOTE</i> Collets to be adjustable for any plug within the respective size ranges tabulated.									

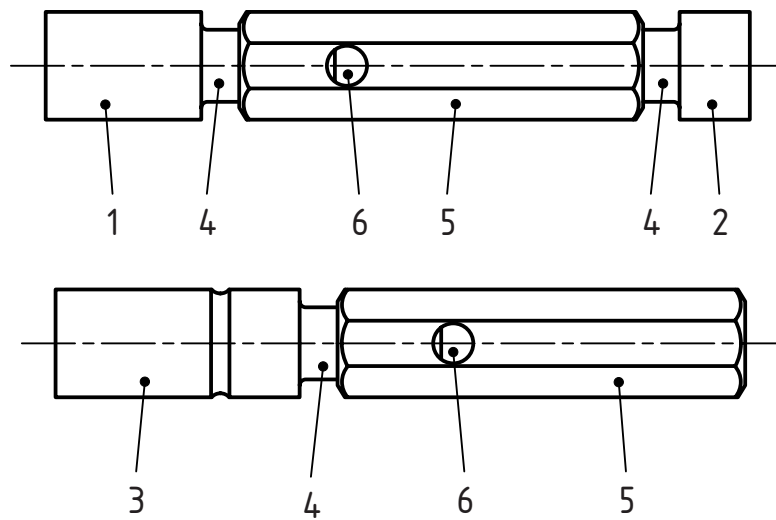
5.2 Taper lock plug gauges

The general details of construction for gauging members and handles for taper lock plug gauges shall be in accordance with Figure 4. The dimensions of gauging members and handles for taper lock plug gauges shall conform to Table 7.

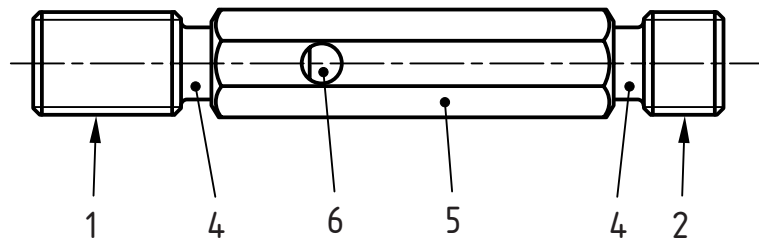
NOTE Handles for taper lock gauges are of the hexagonal type. They may be of unhardened steel, light alloy or plastics, but plastics handles should be provided with steel sleeves.

Figure 4 Taper lock plug gauges

a) Taper lock plain cylindrical plug gauges (Range: above 0.059 in up to and including 2.510 in)



b) Taper lock screw plug gauge (Range: above 0.059 in up to and including 1.510 in)



Key

- | | |
|------------------------------|----------------------|
| 1 GO gauging member | 4 Shank |
| 2 NOT GO gauging member | 5 Taper lock handle |
| 3 Progressive gauging member | 6 Drift slot or hole |