

Gauges

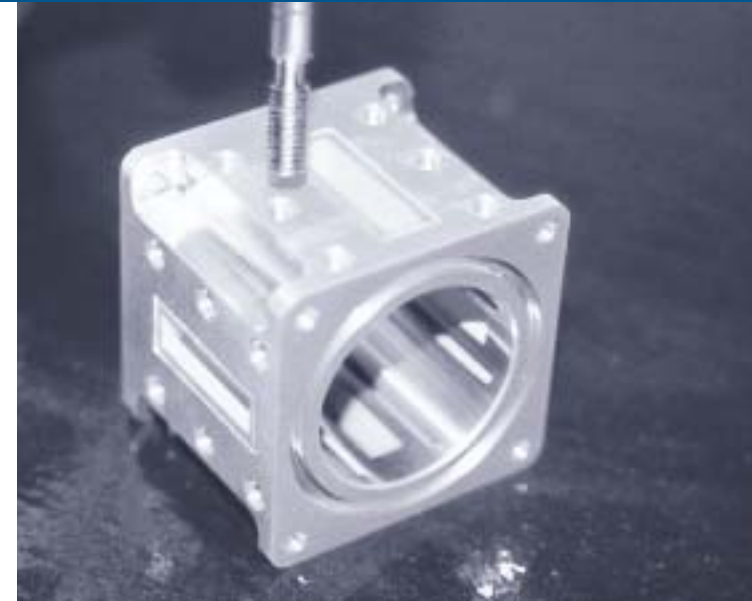
Recoil Thread Gauges

Thread gauging is recommended wherever precision threads are required. The quality of the tapped hole which accommodates the insert determines the finished size and hole quality after the insert has been installed. If the finished tapped hole gauges satisfactorily, the installed insert will be within the thread tolerance.

Technical Information

Recoil gauges 1/2" M12 and below have at least a .0002" or 5um wear allowance on the Go nib. Gauge handle and all gauge nibs are marked with the extreme product limits for particular size and class of fit.

Where precision is required, 3B gauges should be used. When using locking inserts, 3B gauges should be used as close precision is required.



Recoil Inch Gauge Part Numbers

Unified Coarse

NOMINAL THREAD SIZE	WORKING GAUGES	
	3B Close Fit	2B Medium Fit
2 (.086) - 56	63523	63522
3 (.099) - 48	63533	63532
4 (.112) - 40	63543	63542
5 (.125) - 40	63553	63552
6 (.138) - 32	63563	63562
8 (.138) - 32	63583	63582
10 (.190) - 24	63603	63602
12 (.216) - 24	63623	63622
1/4 (.2500) - 20	63043	63042
5/16 (.3125) - 18	63053	63052
3/8 (.3750) - 16	63063	63062
7/16 (.4375) - 14	63073	63072
1/2 (.5000) - 13	63083	63082
9/16 (.5625) - 12	63093	63092
5/8 (.6250) - 11	63103	63102
11/16 (.6875) - 11	63113	63112
3/4 (.7500) - 10	63123	63122
7/8 (.8750) - 9	63143	63142
1 (1.0000) - 8	63163	63162
1-1/8 (1.1250) - 7	63183	63182
1-1/4 (1.2500) - 7	63203	63202
1-3/8 (1.3750) - 6	63223	63222
1-1/2 (1.5000) - 6	63243	63242

Unified Fine

NOMINAL THREAD SIZE	WORKING GAUGES	
	3B Close Fit	2B Medium Fit
3 (.099) - 56	64533	64532
4 (.112) - 48	64543	64542
6 (.138) - 40	64563	64562
8 (.164) - 36	64583	64582
10 (.190) - 32	64603	64602
1/4 (.2500) - 28	64043	64042
5/16 (.3125) - 24	64053	64052
3/8 (.3750) - 24	64063	64062
7/16 (.4375) - 20	64073	64072
1/2 (.5000) - 20	64083	64082
9/16 (.5625) - 18	64093	64092
5/8 (.6250) - 18	64103	64102
3/4 (.7500) - 16	64123	64122
7/8 (.8750) - 14	64143	64142
1 (1.0000) - 12	64163	64162
1 (1.0000) - 14	64163-14	64162-14
1-1/8 (1.1250) - 12	64183	64182
1-1/4 (1.2500) - 12	64203	64202
1-3/8 (1.3750) - 12	64223	64222
1-1/2 (1.5000) - 12	64243	64242

Gauges

Fits and Tolerances

Recoil gauges are supplied for two different classes of fit (tolerances). These are close and medium tolerance.

Gauges are used to check the pitch diameter of the tapped hole; the "NoGo" end of the gauge checks the pitch diameter is not too large and the "Go" end checks the pitch diameter is not too small.

THREAD / TOLERANCE	CLOSE	MEDIUM
Metric	4H5H	5H
UN	3B	2B
Imperial	CLOSE	MEDIUM

Recoil Metric Gauge Part Numbers

Metric Coarse

NOMINAL THREAD SIZE	WORKING GAUGES	
	4H5H Closefit	5H Medium Fit
M2 x 0.4	65024	65025
M2.2 x 0.45	65014	65015
M2.5 x 0.45	65254	65255
M3 x 0.5	65034	65035
M3.5 x 0.6	65354	65355
M4 x 0.7	65044	65045
M5 x 0.8	65054	65055
M6 x 1.0	65064	65065
M7 x 1.0	65074	65075
M8 x 1.25	65084	65085
M9 x 1.25	65094	65095
M10 x 1.5	65104	65105
M11 x 1.5	65114	65115
M12 x 1.75	65124	65125
M13 x 1.75	65134	65135
M14 x 2.0	65144	65145
M15 x 2.0	65154	65155
M16 x 2.0	65164	65165
M18 x 2.5	65184	65185
M20 x 2.5	65204	65205
M22 x 2.5	65224	65225
M24 x 3.0	65244	65245
M27 x 3.0	65274	65275
M30 x 3.5	65304	65305
M30 x 3.0	65304-3	65305-3
M36 x 4.0	65364	65365
M39 x 4.0	65394	65395
M42 x 4.5	65424	65425
M42 x 4.0	65424-4	65425-4

Metric Fine

NOMINAL THREAD SIZE	WORKING GAUGES	
	4H5H Closefit	5H Medium Fit
M8 x 1.0	67084	67085
M10 x 1.0	68104	68105
M10 x 1.25	67104	67105
M11 x 1.0	68114	68115
M11 x 1.25	67114	67115
M12 x 1.25	68124	68125
M12 x 1.5	67124	67125
M13 x 1.25	68134	68135
M13 x 1.5	67134	67135
M14 x 1.5	67144	67145
M15 x 1.5	67154	67155
M16 x 1.5	67164	67165
M18 x 1.5	68184	68185
M18 x 2.0	67184	67185
M20 x 1.5	68204	68205
M20 x 2.0	67204	67205
M22 x 1.5	68224	68225
M22 x 2.0	67224	67225
M24 x 1.5	68244	68245
M24 x 2.0	67244	67245
M26 x 1.5	68264	68265
M27 x 1.5	68274	68275
M27 x 2.0	67274	67275
M30 x 1.5	68304	68305
M30 x 2.0	67304	67305
M36 x 1.5	68364	68365
M36 x 3.0	67364	67365
M39 x 2.0	68394	68395
M39 x 3.0	67394	67395
M42 x 2.0	68424	68425
M42 x 3.0	67424	67425