

TRADE COMBINE

20, Industrial House, 51/53, Nagdevi Cross Lane, Mumbai: 400 003. INDIA.

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E-mail: tradecombine@vsnl.net Website: www.tradecombine.com

I.S.O. METRIC THREAD GAUGES

BAKER

I. INDIAN STANDARD (IS)

BASIC DIMENSIONS : IS 4218 PART III : 1999

: IS 4218 PART IV : 2001

GAUGING PRACTICE : IS 2334 : 2001

II. INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)

BASIC DIMENSIONS : ISO 724 : 1993

GAUGING PRACTICE : ISO 965/1 : 1998

RIGHT HAND		THREAD PLUGS D/E GO & NOTGO		THREAD RINGS GO OR NOTGO		RIGHT HAND		THREAD PLUGS D/E GO & NOTGO		THREAD RINGS GO OR NOTGO				
NOMINAL DIAMETER	PITCH	CLASS 6H RS.		CLASS 6g RS.		NOMINAL DIAMETER	PITCH	CLASS 6H RS.		CLASS 6g RS.				
1	0.25	5H	2180	6h	8210	8	1.25	890	980	8	1.25	890	980	
							0.75	1310	1470			0.75	1310	1470
							0.5	1980	-			0.5	1980	-
1.1	0.25	5H	2180	6h	8210	9	1.25	890	980	9	1.25	890	980	
1.2	0.25	5H	2180	6h	8210		1	890	980			1	890	980
1.4	0.3	5H	1770	6h	8210		0.75	1310	1470			0.75	1310	1470
1.6	0.35		1770		4670		0.5	1980	-			0.5	1980	-
1.7	0.35		2200		4670	10	1.5	920	1020	10	1.5	920	1020	
1.8	0.35		1770		4670		1.25	890	980			1.25	890	980
2	0.4		1060		1840		1	890	980			1	890	980
2.2	0.45		1060		1840	11	0.75	1310	1470	11	0.75	1310	1470	
	0.25		1610		-		0.5	1980	-			0.5	1980	-
2.3	0.4		1330		-		1.5	920	1020			1.5	920	1020
2.5	0.45		1060		1450	12	1	890	980	12	1	890	980	
	0.35		1610		-		0.75	1310	-			0.75	1310	-
2.6	0.45		1330		1830		1.75	920	1020			1.75	920	1020
3	0.5		890		980	13	1.5	920	1020	13	1.5	920	1020	
	0.35		1310		1470		1.25	890	980			1.25	890	980
3.5	0.6		890		980		1	890	980			1	890	980
	0.35		1310		1470	14	0.75	1310	-	14	0.75	1310	-	
4	0.7		890		980		0.5	1980	-			0.5	1980	-
	0.5		1310		1470		1.5	1440	2130			1.5	1440	2130
	0.75		1310		1470	15	1	1440	2130	15	1	1440	2130	
4.5	0.75		890		980		2	1240	1740			2	1240	1740
	0.5		1310		-		1.5	1040	1120			1.5	1040	1120
5	0.8		890		980	16	1.25	1040	1120	16	1.25	1040	1120	
	0.5		1310		1470		1	1040	1120			1	1040	1120
	0.75		1310		1470		0.75	1550	-			0.75	1550	-
5.5	0.5		1310		-	17	1.5	1300	1460	17	1.5	1300	1460	
6	1		890		980		1	1300	1460			1	1300	1460
	0.75		1310		1470		2	1240	1740			2	1240	1740
	0.5		1980		-	18	1.5	1040	1120	18	1.5	1040	1120	
7	1		890		980		1	1040	1120			1	1040	1120
	0.75		1310		1470		1.25	1550	-			1.25	1550	-
	0.5		1980		-	19	0.75	2580	-	19	0.75	2580	-	
							1.5	1400	1800			1.5	1400	1800
							1	1400	1800			1	1400	1800
						20	2.5	1660	1930	20	2.5	1660	1930	
							2	1400	1880			2	1400	1880
							1.5	1290	1320			1.5	1290	1320
						20	1	1290	1320	20	1	1290	1320	
							1.5	1790	2520			1.5	1790	2520
							1	1790	250			1	1790	250
						20	2.5	1660	2460	20	2.5	1660	2460	
							2	1400	2400			2	1400	2400
							1.5	1290	1690			1.5	1290	1690
						20	1	1290	1690	20	1	1290	1690	

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BAKER I.S.O.METRIC THREAD GAUGES

RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO	RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO
NOMINAL DIAMETER	PITCH	CLASS 6H RS.	CLASS 6g RS.	NOMINAL DIAMETER	PITCH	CLASS 6H RS.	CLASS 6g RS.
21	1.5	1790	3220	40	3	2610	3310
	1	1790	3220		2	2110	2840
22	2.5	1660	2460	42	1.5	1940	2730
	2	1400	2400		1	2910	4090
	1.5	1290	1690		4.5	3750	4320
24	1	1290	1690	45	4	3750	3960
	3	1660	2580		3	3160	3960
	2	1400	2180		2	2420	3560
	1.5	1290	1980		1.5	2230	3420
25	1	1290	1980	48	1	3330	5120
	2	1560	2400		4.5	3750	4320
	1.5	1440	2140		4	3750	3960
26	1	1440	2140	50	3	3160	3960
	1.5	1600	2140		2	2420	3560
27	1	2390	3220	52	1.5	2230	3420
	3	2120	3170		1	3330	5120
28	2	1740	2410	55	5	4390	4320
	1.5	1600	2140		4	3750	3960
	1	1600	2140		3	3160	3960
29	2	1740	2410	58	2	2420	3420
	1.5	1600	2140		1.5	2230	3420
30	1	1600	2140	60	1	3330	5120
	1.5	2390	3220		4	4580	5180
	3.5	3150	3310		3	3750	5180
	3	2610	3310		1.5	2650	4430
32	2	2110	2840	62	5.5	4580	5620
	1.5	1940	2730		4	4580	5180
	1	2910	4090		3	3750	5180
33	1	2910	4090	64	2	2870	4620
	3.5	3150	3310		1.5	2650	4430
	3	2610	3310		4	4580	5180
	2	2110	2840		3	3750	5180
34	1.5	1940	2730	66	2	2870	4620
	1	2910	4090		1.5	2650	4430
35	1.5	1940	2730	68	4	4580	5180
	1	2910	4090		3	3750	5180
	4	3150	3310		2	2870	4620
36	3	2610	3310	70	1.5	2650	4430
	2	2110	2840		4	4580	5180
	1.5	1940	2730		3	3750	5180
	1	2910	4090		2	2870	4620
38	1.5	1940	2730	72	1.5	2650	4430
	1	2910	4090		4	4580	5180
39	4		3310	74	3	3750	5180
	3		3310		2	2870	4620
	2		2840		1.5	2650	4430
	1.5		2730		4	4580	5180
40	1		4090	76	3	3750	5180
	1		4090		2	2870	4620

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RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO	RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO
NOMINAL DIAMETER	PITCH	CLASS 6H RS.	CLASS 6g RS.	NOMINAL DIAMETER	PITCH	CLASS 6H RS.	CLASS 6g RS.
150	6	15960	16450	180	6	19660	19820
	4	10640	13700		4	14960	16540
	3	10640	13700		3	14960	16540
	2	8150	11030		2	11440	12960
	1.5	7810	10570		1.5	10960	12420
155	6	15960	16450	185	6	19660	19820
	4	10640	13700		4	14960	16540
	3	10640	13700		3	14960	16540
	2	9020	11030		2	11440	12960
	1.5	8650	10570		1.5	10960	12420
160	6	15960	16450		6	19660	19820
	4	10640	13700		4	14960	16540
	3	10640	13700		3	14960	16540
	2	9020	11030		2	11440	12960
	1.5	8650	10570		1.5	10960	12420
165	6	18160	18050		6	24070	21830
	4	12970	15060		4	17210	18190
	3	12970	15060		3	17210	18190
	2	9910	11760		2	13180	14230
	1.5	9500	11270		1.5	12630	13640
170	6	18160	18050	200	6	24070	21830
	4	12970	15060		4	17210	18190
	3	12970	15060		3	17210	18190
	2	9910	11760		2	13180	14230
	1.5	9500	11270		1.5	12630	13640
175	6	18160	18050				
	4	12970	15060				
	3	12970	15060				
	2	9910	11760				
	1.5	9500	11270				

NOTES:

I] THREAD PLUGS

- 1 PRICE FOR DIAMETER 0.50mm TO 0.90mm ON REQUEST.
- 2 FOR SIZES 1mm TO 1.4mm AS PER SPECIFICATION STANDARD CLASS RECOMMENDED IS 5H.
- 3 PRICE FOR THREAD PLUG OTHER THAN 6H CLASS, AND 25% ON 6H THREAD PLUG.
- 4 PRICE FOR LEFT HAND THREAD PLUG, ADD 100% ON RIGHT HAND THREAD PLUG.
- 5 PRICE FOR NON - STANDARD DIAMETER-PITCH COMBINATIONS AND DIAMETERS ABOVE 200mm ON REQUEST.

II] THREAD RINGS

- 1 PRICE FOR DIMETER 0.55mm TO 0.90mm ON REQUEST.
- 2 PRICE FOR THREAD RING OTHER THAN 6g, CLASS, DIAMETER UPTO 24mm ADD 50% ON 6g THREAD RING.
- 3 PRICE FOR THREAD RING OTHER THAN 6g, CLASS, DIAMETER ABOVE 24mm ADD 25% ON 6g THREAD RING.
- 4 PRICE FOR LEFT HAND THREAD RING, DIAMETER UP TO 24mm ADD 125% ON RIGHT HAND THREAD RING AND MINIMUM ORDER QUANTITY 3 NOS.
- 5 PRICE FOR LEFT HAND THREAD RING, DIAMETER 25mm AND ABOVE, ADD 100% ON RIGHT HAND THREAD RING.
- 6 PRICE FOR NON - STANDARD DIAMETER - PITCH COMBINATIONS AND DIAMETERS ABOVE 200mm ON REQUEST.

III] CERTIFICATE OF CALIBRATION IS SUPPLIED WITH EACH GAUGE, TRACEABLE TO N.P.L. STANDARDS.

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UNIFIED THREAD GAUGES

BAKER

AMERICAN STANDARD

BASIC DIMENSIONS & GAUGING PRACTICE : ANSI /ASME B 1.2 - 1983

RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO	RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO
NOMINAL DIAMETER	THREADS PER PITCH	CLASS 2B RS.	CLASS 2A RS.	NOMINAL DIAMETER	THREADS PER PITCH	CLASS 2B RS.	CLASS 2A RS.
0	80 UNF	3970	6740	4-Mar	10 UNC	1820	2480
1	64 UNC	3400	5780		16 UNF	1550	1660
	72 UNF	3400	5780		12 UN	2330	-
2	56 UNC	2260	3750	13/16	20 UNEF	2330	3320
	64 UNF	2820	5610		12 UN	2330	-
3	48 UNC	2260	2970		16 UN	2330	-
	56 UNF	2820	4450	20 UNEF	2330	-	
4	40 UNC	1060	1430	7/8	9 UNC	2470	2480
	48 UNF	1060	1430		14 UNF	1550	1660
5	40 UNC	1060	1430		12 UN	2330	-
	6	32 UNC	1060	1430	16 UN	2330	-
8		40 UNF	1060	1430	20 UNEF	2330	-
	10	32 UNC	1060	1430	15/16	12 UN	2330
12		36 UNF	1060	1430		16 UN	2330
	1/4	24 UNC	1060	1430		20 UNEF	2330
24 UNC		1060	1430	1	8 UNC	2470	4140
28 UNF		1060	1430		12 UNF	1550	2610
28 UNC	1060	1430	14 UN		2330	3920	
5/16	32 UNEF	1570	2860	16 UN	2330	3920	
	18 UNC	1060	1430	20 UNEF	2330	3920	
3/8	32 UNEF	1570	-	1.1/16	8 UN	3670	5290
	16 UNC	1060	1430		12 UN	2060	2610
	24 UNF	1060	1430		16 UN	2060	2610
7/16	32 UNEF	1570	2860	18 UNEF	3530	4960	
	14 UNC	1100	1560	1.1/8	7 UNC	3670	5290
	20 UNF	1060	1430		12 UNF	2060	2610
28 UNEF	1570	-	16 UN		2060	2610	
1/2	13 UNC	1100	1560	1.3/16	18 UNEF	3530	4960
	20 UNF	1060	1430		8 UN	3670	5290
	28 UNEF	1570	-		12 UN	2060	2610
9/16	12 UNC	1240	2420	1.1/4	16 UN	2060	2610
	18 UNF	1240	1660		18 UNEF	3530	4960
	20 UN	1850	-		7 UNC	3670	5290
	24 UNEF	1850	-		8 UN	3670	5290
5/8	11 UNC	1820	2480	1.5/16	12 UNF	2340	3280
	18 UNF	1550	1660		16 UN	2340	3280
	20 UN	2330	-		18 UNEF	3530	4960
	24 UNEF	2330	-		20 UN	3530	4960
11/16	12 UNC	2330	-	1.3/8	8 UN	3670	5290
	16 UN	2330	-		12 UN	2340	3280
	20 UN	2330	-		16 U	2340	3280
	24 UNEF	2330	-		18 UNEF	3530	4960
				20 UN	3530	4960	

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RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO	RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO OR NOTGO
NOMINAL DIAMETER	THREADS PER INCH	CLASS 2B RS.	CLASS 2A RS.	NOMINAL DIAMETER	THREADS PER INCH	CLASS 2B RS.	CLASS 2A RS.
1.7/16	6 UN	3670	5290	2.3/8	8 UN	5260	6840
	8 UN	3670	5290		12 UN	3700	5120
	12 UN	2340	3280	2.1/2	16 UN	3700	5120
	16 UN	2340	3280		4 UNC	6280	8210
	18 UNEF	3530	4960		8 UN	5260	6840
20 UN	3530	4960	12 UN	3700	5120		
1.1/2	6 UNC	3670	5290	2.5/8	16 UN	3700	5120
	8 UN	3670	5290		8 UN	5260	6840
	12 UN	2340	3280		12 UN	3700	5120
	16 UN	2340	3280	2.3/4	16 UN	3700	5120
	18 UNEF	3530	4960		4 UNC	6280	8210
1.9/16	20 UN	3530	4960	8 UN	5260	6840	
	6 UN	4190	6040	12 UN	3700	5120	
	8 UN	4190	6040	2.7/8	16 UN	3700	5120
	12 UN	3110	3770		8 UN	5260	6840
	16 UN	3110	3770		12 UN	3700	5120
1.5/8	18 UNEF	3840	5650	3	16 UN	3700	5120
	20 UN	3840	5650		4 UNC	7880	10250
	6 UN	4190	6040	8 UN	6640	8540	
	8 UN	3110	3770	3.1/4	12 UN	4670	6400
	12 UN	3110	3770		16 UN	4670	6400
16 UN	3110	3770	4 UNC		7880	10250	
1.3/4	18 UNEF	3840	5650	8 UN	6640	8540	
	20 UN	3840	5650	12 UN	4670	6400	
	5 UNC	5060	7520	3.1/2	16 UN	4670	6400
	8 UN	4190	6040		4 UNC	9990	12840
	12 UN	3110	3770		8 UN	8330	10720
1.7/8	16 UN	3110	3770	12 UN	5880	8030	
	20 UN	3840	5650	3.3/4	16 UN	5880	8030
	8 UN	4190	6040		4 UNC	9990	12840
	12 UN	3110	3770		8 UN	8330	10720
	2	16 UN	3110	3770	4	12 UN	5880
20 UN		3840	5650	16 UN		5880	8030
4.5 UNC		5060	7520	4 UNC		9990	12840
8 UN		4190	6040	8 UN	8330	10720	
12 UN		3110	3770	12 UN	5880	8030	
2.1/4	20 UN	3840	5650	16 UN	5880	8030	
	4.5 UNC	6280	8210				
	8 UN	5260	6840				
	12 UN	3700	5120				
	16 UN	3700	5120				

NOTES:

I] THREAD PLUGS

- 1 PRICE FOR THREAD PLUG OTHER THAN 2B CLASS, ADD 25% ON 2B THREAD PLUG.
- 2 PRICE FOR LEFT HAND THREAD PLUG, ADD 100% ON RIGHT HAND THREAD PLUG.
- 3 PRICE FOR NON-STANDARD DIAMETER-TPI COMBINATIONS AND DIAMETERS ABOVE 4" ON REQUEST.

II] THREAD RINGS

- 1 PRICE FOR THREAD RING OTHER THAN 2A CLASS, DIAMETER UPTO 1" ADD 50% ON 2A THREAD RING.
- 2 PRICE FOR THREAD RING OTHER THAN 2A CLASS, DIAMETER ABOVE 1" ADD 25% ON 2A THREAD RING.
- 3 PRICE FOR LEFT HAND THREAD RING, DIAMETER UPTO 7/8" ADD 125% ON RIGHT HAND THREAD RING. AND MINIMUM ORDER QUANTITY 3 NOS.
- 4 PRICE FOR LEFT HAND THREAD RING, DIAMETER 1" AND ABOVE, ADD 100% ON RIGHT HAND THREAD RING.

5 PRICE FOR NON-STANDARD DIAMETER-TPI COMBINATIONS AND DIAMETERS ABOVE 4" ON REQUEST.

III] CERTIFICATE OF CALIBRATION IS SUPPLIED WITH EACH GAUGE, TRACEABLE TO N.P.L. STANDARDS.

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I.S.O PARALLEL PIPE THREAD GAUGES (B.S.P.)

BAKER

I. INDIAN STANDARD (IS)

BASIC DIMENSIONS : IS 2643 : 1999
 GAUGING PRACTICE : IS 10216 : 1988

II. INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)

BASIC DIMENSIONS : ISO:228 PART I - 2000
 GAUGING PRACTICE : ISO:228 PART II - 1987

RIGHT HAND		THREAD PLUGS D/E GO & NOTGO	THREAD RINGS GO (CLASS A & CLASS B) OR NOTGO (CLASS B)
NOMINAL DIAMETER	THREADS PER INCH	CLASS GENERAL RS.	CLASS B RS.
G 1/8	28	1320	2310
G 1/4	19	1320	2310
G 3/8	14	1320	2310
G 1/2	14	1670	3390
G 5/8	14	1670	3390
G 3/4	14	1670	3390
G 7/8	11	1670	3390
G 1	11	2700	4530
G 1.1/8	11	2700	4530
G 1.1/4	11	2700	4530
G 1.3/8	11	2700	4530
G 1.1/2	11	2700	4530
G 1.3/4	11	3000	5400
G 2	11	3000	5690
G 2.1/4	11	3350	5690
G 2.1/2	11	3350	5690
G 2.3/4	11	4160	7130
G 3	11	4160	7130
G 3.1/2	11	5190	8930
G 4	11	5190	8930
G 5	11	7470	11170
G 6	11	1120	13940

NOTES:

I] THREAD RINGS

1. PRICE FOR NOTGO THREAD RING OF CLASS-A, DIAMETER UPTO G 3/8 ADD 50% ON CLASS B THREAD RING.
2. PRICE FOR NOTGO THREAD RING OF CLASS-A, DIAMETER G 1/2 AND ABOVE ADD 25% ON CLASS B THREAD RING.

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BAKER

N.P.T. TAPER THREAD GAUGES

AMERICAN STANDARD

BASIC DIMENSIONS & GAUGING PRACTICE: ANSI/ASME B1.20.1-1983 OR H-28 PART II-1957.

RIGHT HAND		N.P.T. BASIC STEP		NPT MIN & MAX STEPS	
NOMINAL DIAMETER	THREADS PER INCH	PLUGS RS.	RINGS RS.	PLUGS RS.	RINGS RS.
1/16"	27	2760	4520	3010	5410
1/8"	27	2760	4520	3010	5410
1/4"	18	2290	4100	2510	4940
3/8"	18	2290	4100	2510	4940
1/2"	14	2290	3580	2510	4290
3/4"	14	2290	3580	2510	4290
1	11.1/2	3060	5520	3400	6600
1.1/4"	11.1/2	3060	5520	3400	6600
1.1/2"	11.1/2	3060	5520	3400	6600
2	11.1/2	4480	6840	4920	8200
2.1/2"	8	5310	7460	5840	8940
3	8	5310	7460	5840	8940
3.1/2"	8	5310	7460	5840	8940
4	8	7990	11230	8780	13490
5	8	8770	12350	9690	14820
6	8	8770	12350	9690	14820

NOTE : DETAILED CERTIFICATE OF CALIBRATION IS SUPPLIED WITH EACH GAUGE, TRACEABLE TO N.P.L. STANDARDS.

N.P.T.F. TAPER THREAD GAUGES

BASIC DIMENSIONS & GAUGING PRACTICE:

ANSI / ASME B 1.20.5 - 1991
(OR - H - 28 PART II - 1957)

RIGHT HAND		TAPER THREAD PLUG				TAPER THREAD RING			
Nominal Diameter	Threads Per Inch	L1 Basic Rs.	L3 Basic Rs.	L1 Step Limit Rs.	L3 Step Limit Rs.	L1 Basic Rs.	L2 Basic Rs.	L1 Step Limit Rs.	L2 Step Limit Rs.
1/16"	27	3020	3300	3320	3610	4970	5420	5960	6490
1/8"	27	3020	3300	3320	3610	4970	5420	5960	6490
1/4"	18	2510	2740	2770	3010	4510	4920	5450	5940
3/8"	18	2510	2740	2770	3010	4510	4920	5450	5940
1/2"	14	2510	2740	2770	3010	3920	4920	4720	5140
3/4"	14	2510	2740	2770	3010	3920	4920	4720	5140
1"	11.1/2	3380	3670	3720	4080	6070	6610	7260	7920
1.1/4"	11.1/3	3380	3670	3720	4080	6070	6610	7260	7920
1.1/2"	11.1/4	3380	3670	3720	4080	6070	6610	7260	7920
2"	11.1/5	4920	5370	5410	5910	7530	8210	9020	9830
2.1/2"	8	5840	6390	6420	7010	8210	8950	9840	10730
3"	8	5840	6390	6420	7010	8210	8950	9840	10730

NOTE : DETAILED CERTIFICATE OF CALIBRATION IS SUPPLIED WITH EACH GAUGE, TRACEABLE TO N.P.L. STANDARDS.

B.S.P.T TAPER THREAD GAUGES

BASIC DIMENSIONS & GAUGING PRACTICE

B.S.21 - 1985

NOMINAL DIAMETER	THREADS PER INCH	PLUGS SYSTEM - B RS.	RING SYSTEM - B RS.
1/8"	28	5760	13100
1/4"	19	4650	12220
3/8"	19	4650	10480
1/2"	14	4650	8300
3/4"	14	4650	8300

1"	11	6580	12050
1.1/4"	11	6580	12050
1.1/2"	11	6580	12050
2"	11	9830	15050
2.1/2"	11	9830	15050
3"	11	9830	15050
4"	11	14800	22590
5"	11	16930	25640
6"	11	16930	25940

NOTE : DETAILED CERTIFICATE OF CALIBRATION IS SUPPLIED WITH EACH GAUGE, TRACEABLE TO N.P.L. STANDARDS.