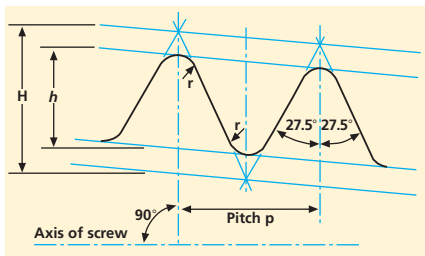


TAPER PLUG AND RING GAUGES TO BS21 AND 1S07/2

Gauges for testing pipe threads where pressure tight joints are made on the threads to BS 21: 1985, and ISO 7/2 1982.

BS 21 specifies requirements of pipe threads for joints made pressure tight by the mating of threads, and are taper external, taper internal, parallel external and parallel internal threads.

The thread form is based on the Whitworth profile. The taper is 1:16 on diameter, normal to the axis.



The pipe fittings range in size from 1/16 to 6.0.

There are two systems for gauging pipe threads specified in this standard.

System A gauges are intended for use where there are additional production control methods to ensure accuracy of the threads. **System B** gauges are intended for use where there may be no other adequate method of production control.

System A comprises two types of gauge. A taper full form screw ring, and a taper full form screw plug.

When gauging taper external threads with the taper full form screw ring, the small end of the product thread should lie within the plus and minus tolerance of the small end of the ring.

When gauging taper or parallel internal threads with the taper full form plug, the end of the product thread should lie within the plus and minus tolerance from the gauge plane step of the plug.

System B comprises four types of gauge. A taper full form screw ring, a taper full form screw plug, a taper plain ring, and a taper plain plug.

When gauging taper external threads with the taper full form ring or with

the taper plain ring, the small end of the product thread should lie between the faces, or flush with either face of the step on the gauge.

When gauging taper or parallel internal threads with the taper full form screw plug or with the taper plain plug, the end face of the product should lie between the faces, or flush with either face of the step on the gauge.

When using any of the above gauges, assembly should be handtight only, taking care not to use excessive force.

Designations

External taper threads and taper ring gauges are designated R (1/4)

Internal taper threads and taper plug gauges are designated Rc (1/4)

SIZE	BS 21	
	PLUG Rc	RING R
1/16	0480	0481
1/8	0482	0483
1/4	0484	0485
3/8	0486	0487
1/2	0488	0489
3/4	0490	0491
1	0492	0493
1 1/4	0494	0495
1 1/2	0496	0497
2	0498	0499

Internal parallel threads and parallel plug gauges are designated Rp (1/4)

Go/Not Go parallel screw rings can be supplied to test special parallel external threads for gas appliances where pressure tight seals are made on machined faces. The size range for threads is 1/8 to 2.0. These threads are designated Rs (1/4)

Go/Not Go parallel screw plugs can be supplied to test parallel internal threads.

The manufacturing limits for these parallel gauges will be as specified in BS 919: Pt. 2: 1971.

ISO 7/2 specifies one gauging system only for testing pipe threads.

The standard specifies three types of gauge. A full form taper screw ring, a full form taper screw plug, both used for testing the product thread, and a modified form taper screw check plug for testing the ring during manufacture, and for testing wear following use.

Whilst the gauges in this standard are manufactured to the same basic product diameters as the BS 21 pipe thread, and are designed to carry out the same gauging function, there are differences in design, and differences in the gauge manufacturing limits.

SIZE	ISO 7/2	
	PLUG Rc	RING R
1/16	0480 ISO	0481 ISO
1/8	0482 ISO	0483 ISO
1/4	0484 ISO	0485 ISO
3/8	0486 ISO	0487 ISO
1/2	0488 ISO	0489 ISO
3/4	0490 ISO	0491 ISO
1	0492 ISO	0493 ISO
1 1/4	0494 ISO	0495 ISO
1 1/2	0496 ISO	0497 ISO
2	0498 ISO	0499 ISO

Because of these differences care should be taken when ordering to specify to which standard the gauges are required.



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Calibration Services available on all our products.

