STRAIGHT THREAD INSPECTION- External & Internal Thread Height

GAGEMAKER

Thread Height Gage- TH-3000 Series

Thread Height:

Thread height is the distance from the crest to the root measured perpendicular to the pipe axis. Depth of the helical thread groove is measured perpendicular to the thread crest & root cones on ACME, Stub ACME, Stub ACME Models 1 & 2, UN/UNR Series, 7*x 45 Buttress, & Metric. Incorrect thread height may be caused by a chipped, broken, or incorrectly ground insert.

Purpose:

The TH-3000 Series of gages inspect variations in external & internal thread height for a variety of thread forms. The gages use a precision contact point, which seats in the thread of the part during inspection. The actual thread height can be read from the gages indicator.

TH-3001V

TH-3010

Thread Height Inspection with TH-3000 Series

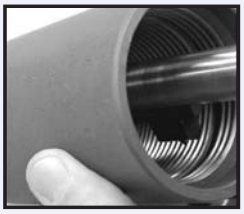
Internal Setup

1. TH-3010 does not require removal of any parts before zeroing. As a setting standard, simply place the anvil of the gage on a flat surfce. ***For size 16 and larger, set the zero by using the perfect thread root as a setting standard.***

2. Turn the indicator dial to align the needle with zero.

3. Tighten the indicator Bezel clamp.

Internal Gage Operation



1. Insert the gage into the threaded part.

2. Position the contact point in the root of the thread and rest the anvil on the thread crests.

3. Tilt the gage from side to side to locate the largest indicator reading.

4. Record any deviations on an inspection or calibration report.

5. Compare the readings with the measurement specified in API Specification 5B.

External Setup

1. For model TH-3001V: place the gage on a flat surface.

2. Tilt the gage from side to side to locate the shortest depth location. Then, turn the indicator Bezel to align the needle with zero.

3. Tighten the indicator Bezel clamp.

External Gage Operation

1. Place the contact point into the thread groove of the part.

2. Push down on the gage until the gage body rests on the crests of the thread.

3. Tilt the gage from side to side to locate the shortest depth location.

4. Record any deviations on an inspection or calibration report.

5. Compare the readings with the measurement specified in API Specification 5B.

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