

Adjustable Thread Ring Gage Calibration Procedure

By

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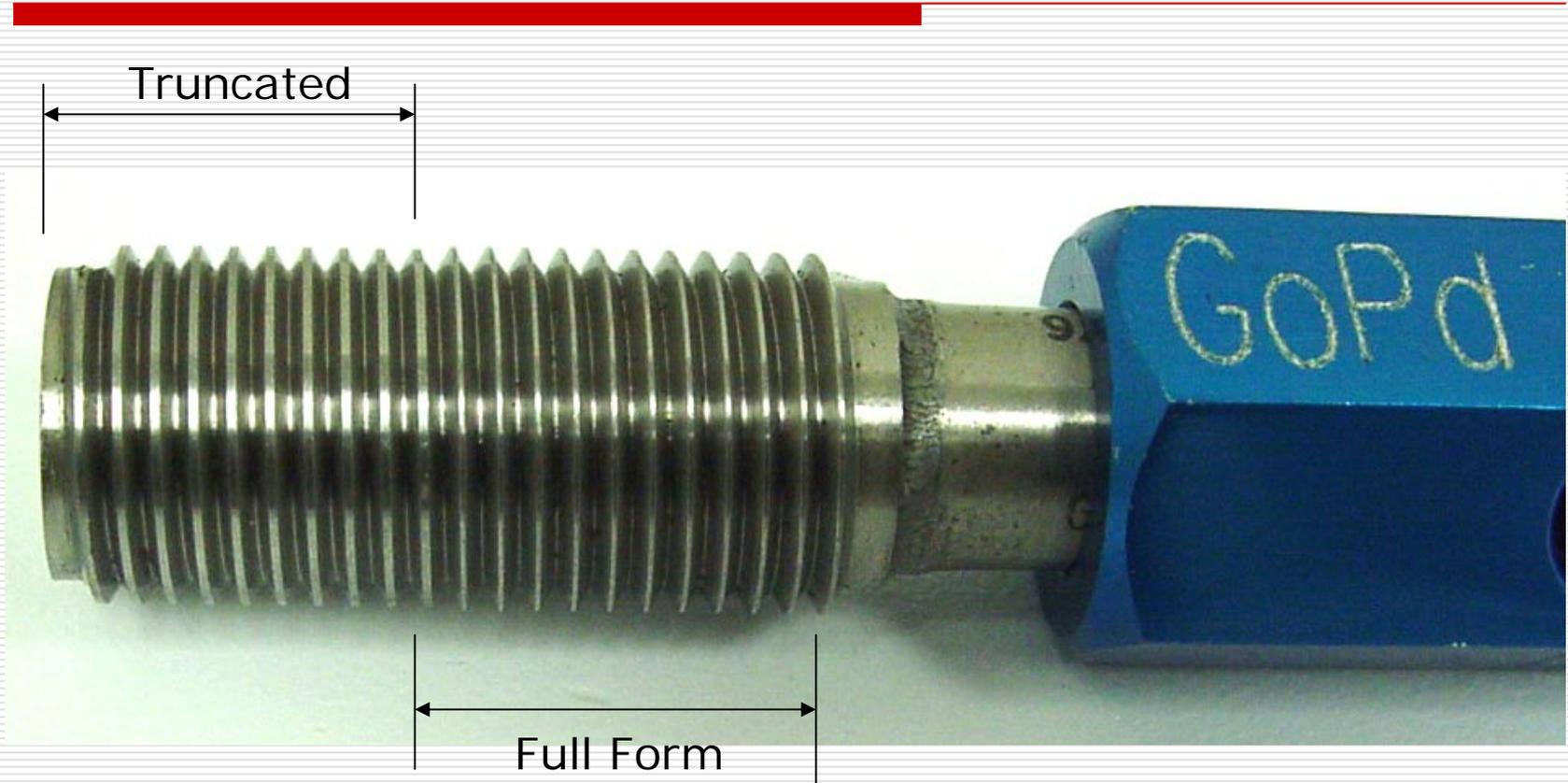
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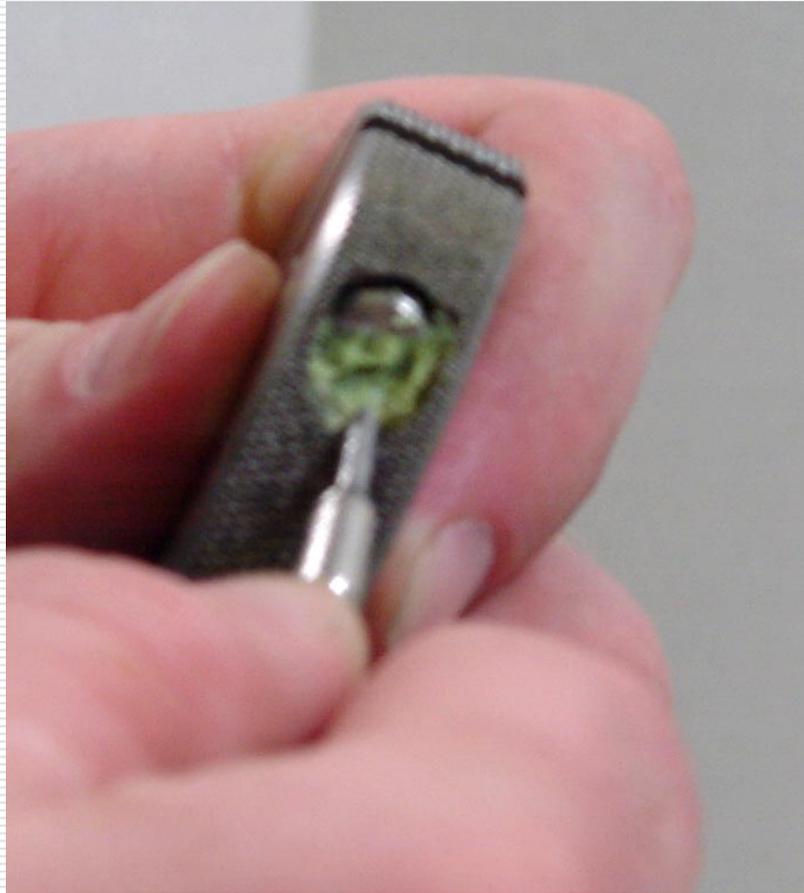
Adjustable Ring Gage Procedure



Truncated Setting Plug



Remove wax from locking and adjusting screws



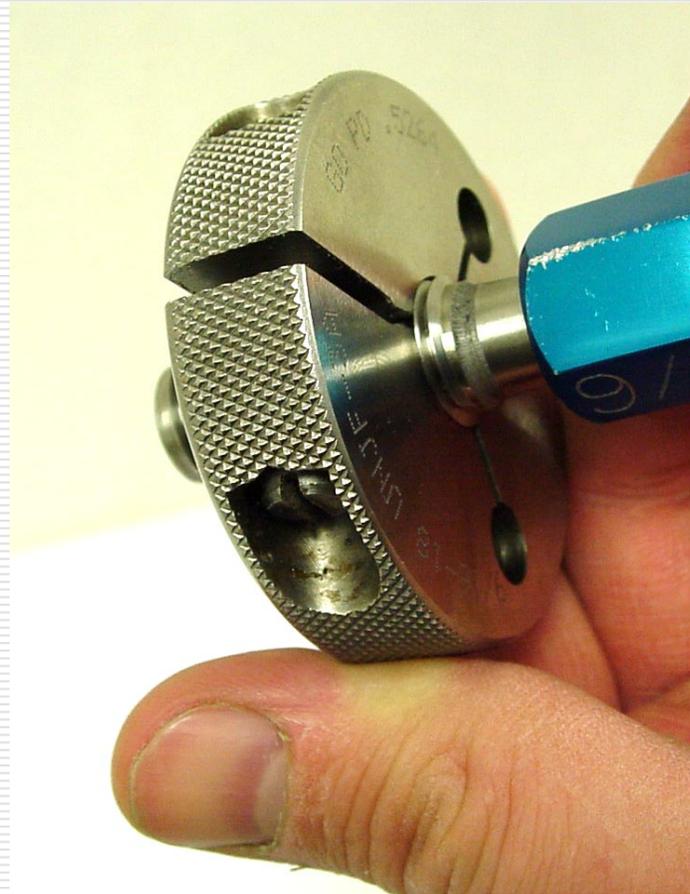
Locking Screw and Adjusting Screw



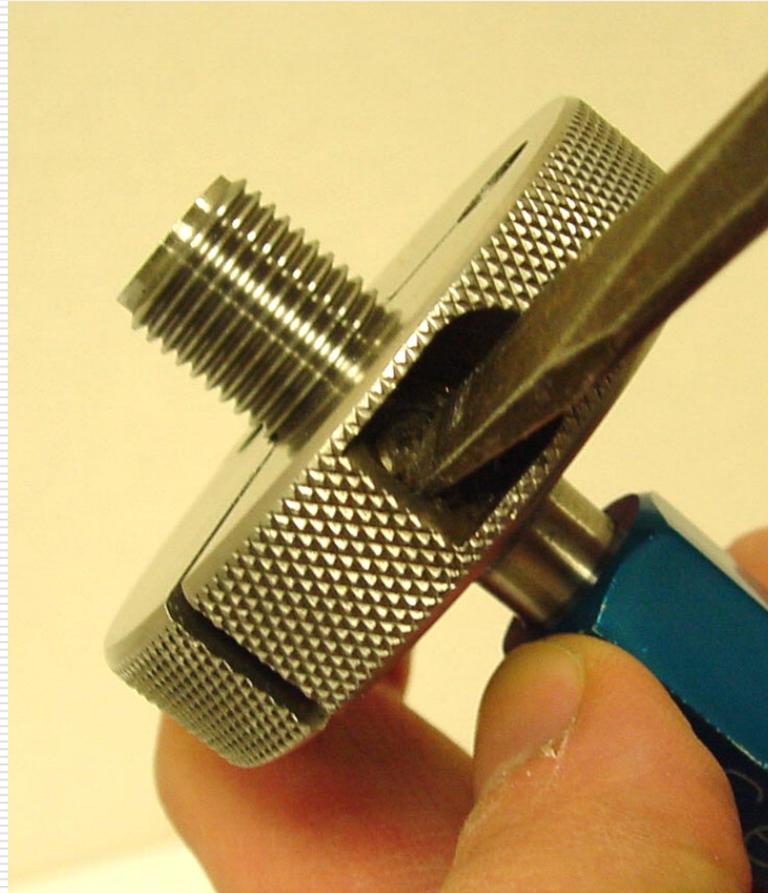
Loosen locking screw and adjusting screw



Rotate ring to full form portion of setting plug



Work with adjusting screw until there is a slight resistance to rotation.
Tighten locking screw.



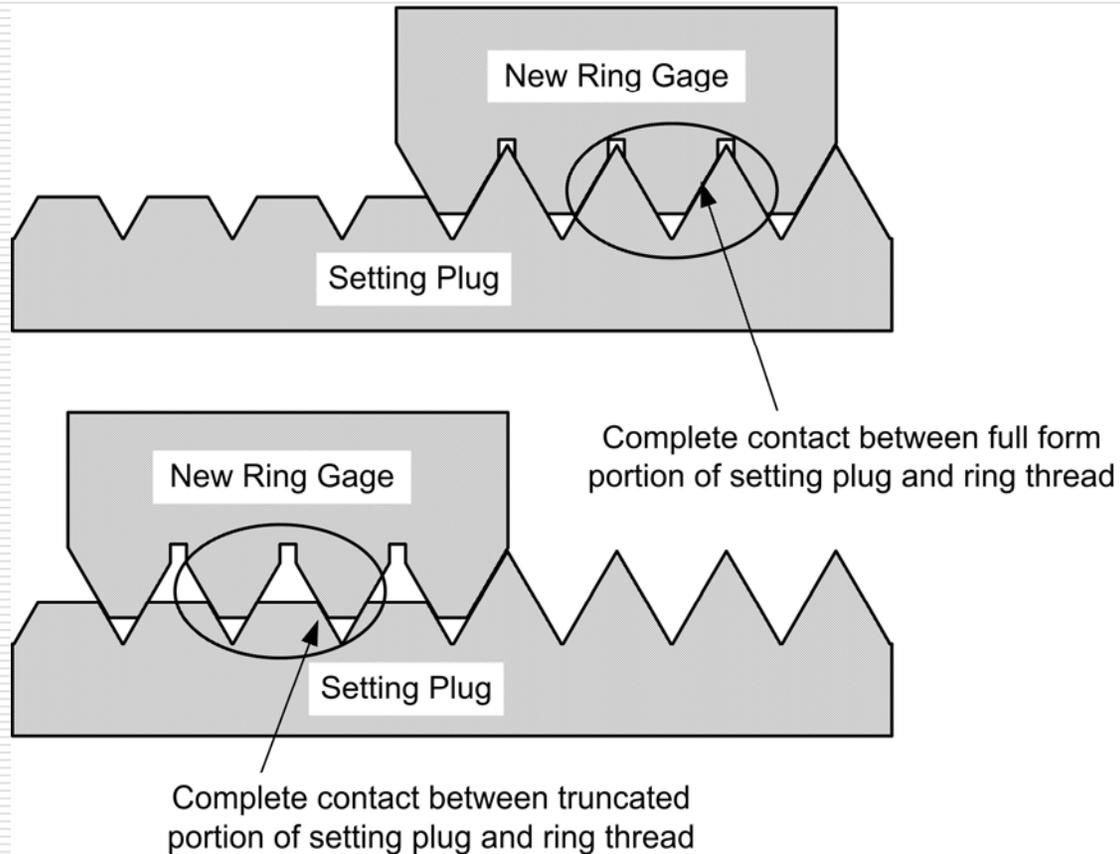
Rotate ring to truncated portion of setting plug.

The resistance to rotation on the truncated portion of the set plug should be similar to the resistance on the full form portion of the plug.

The ring must NOT free-spin on the truncated portion of the set plug.

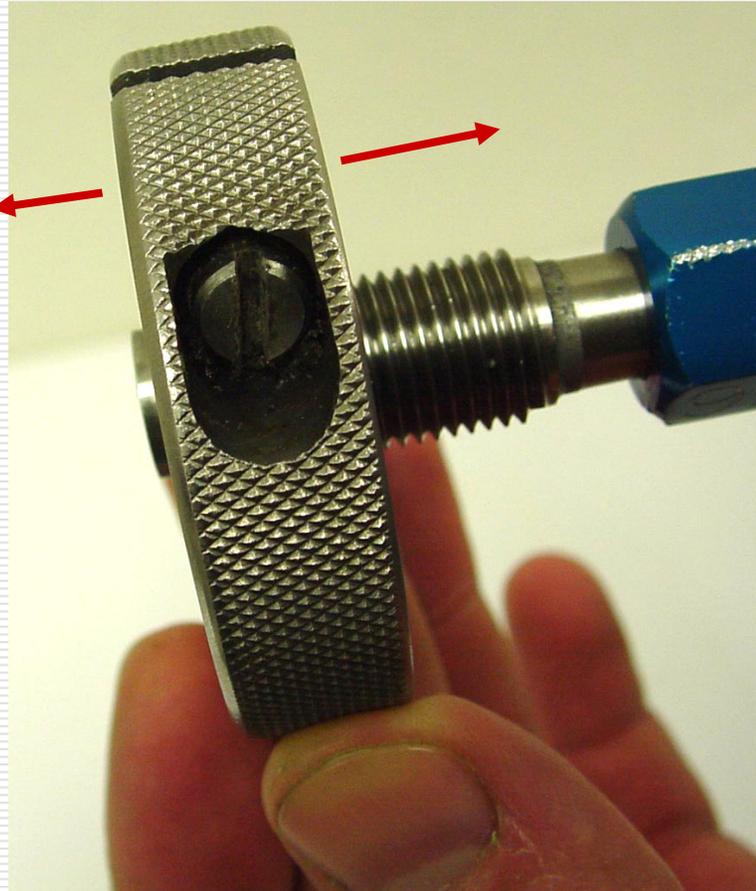


Correct fit between setting plug and ring gage



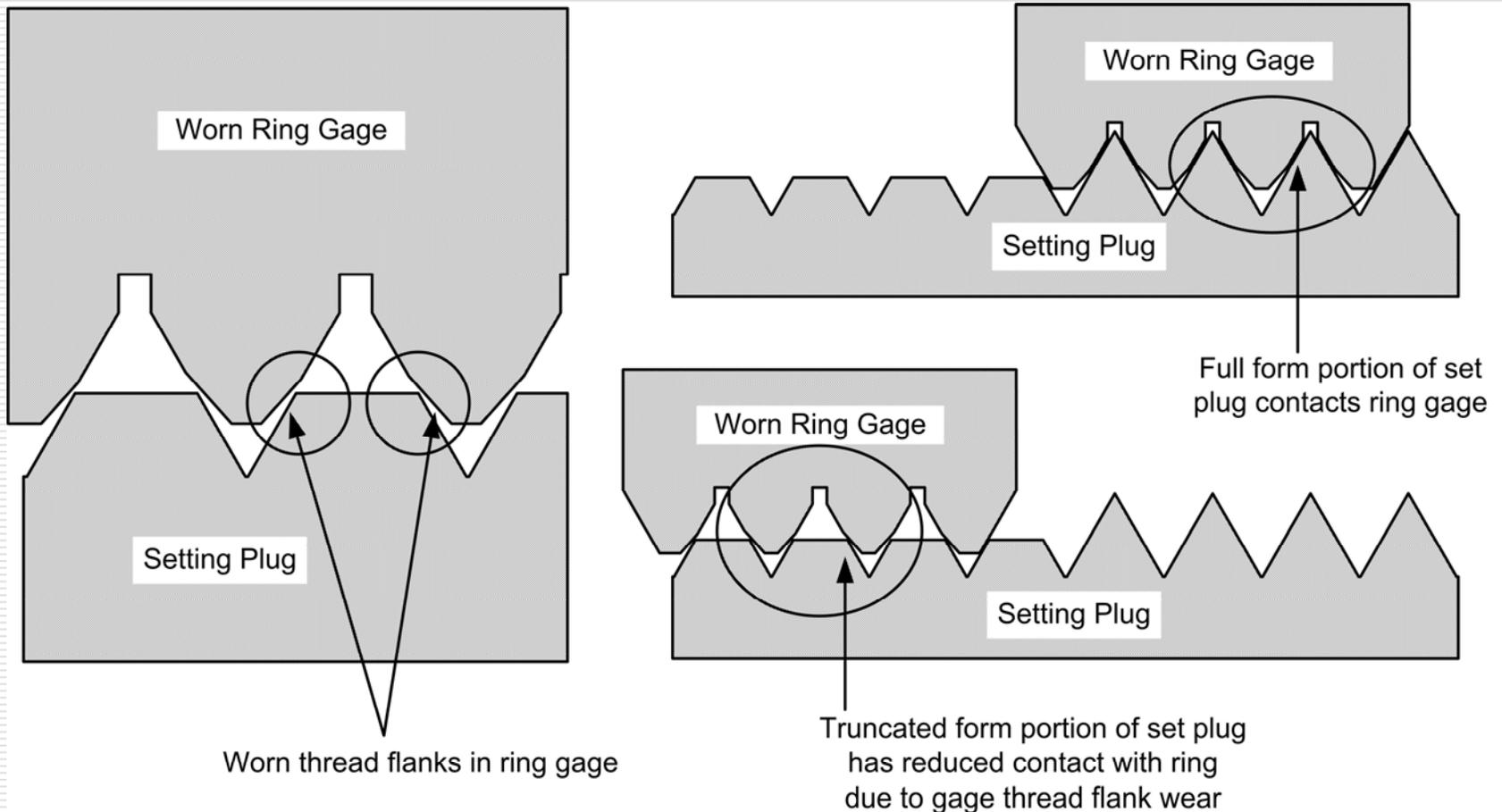
With the ring on the truncated portion of setting plug examine for side-to-side wobble.

Wobble
side to side

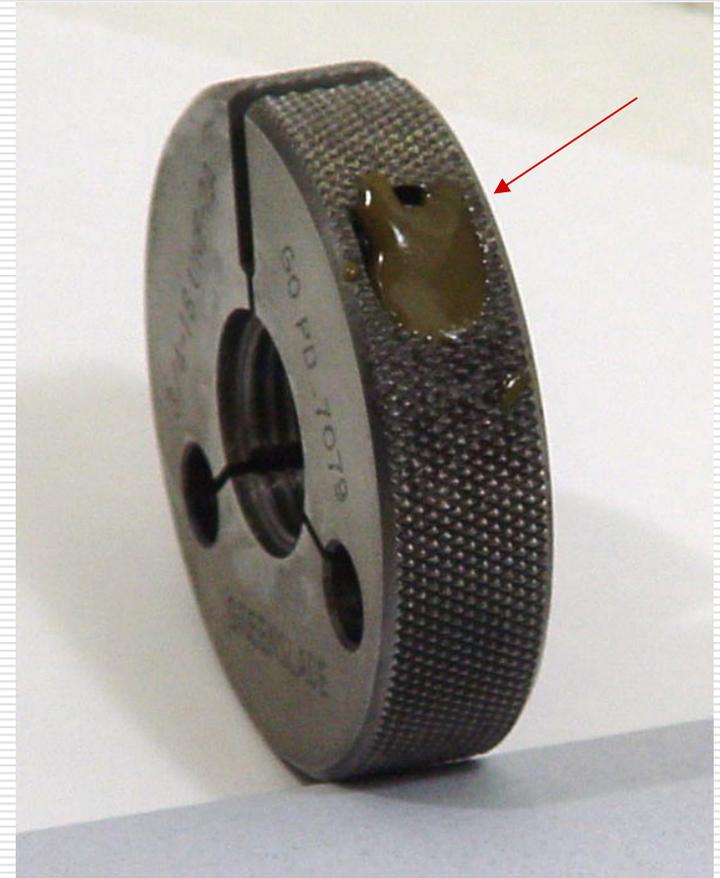
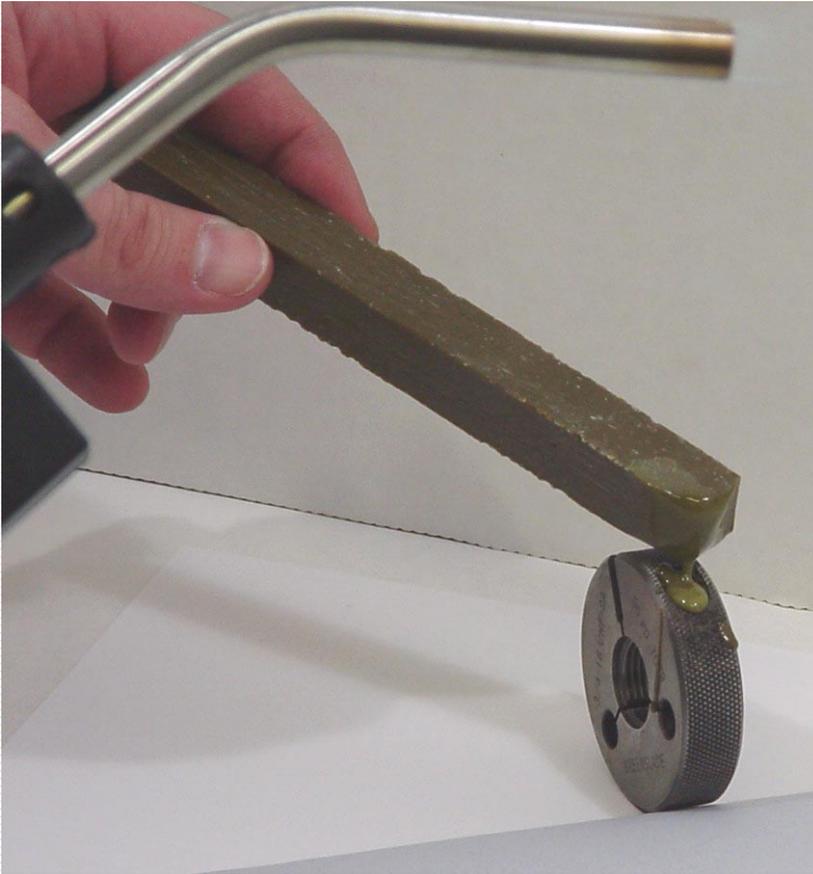


If the ring wobbles
side-to-side on the plug
the ring is worn and
must be replaced.

Incorrect fit between setting plug and ring gage due to worn thread flanks in ring gage.



Apply security wax to both locking and setting screw heads.



Ring ready for use.

