Adjustable Thread Ring Gage Calibration Procedure

By

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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

- Complete contact between full form portion of setting plug and ring thread
- Complete contact between truncated portion of setting plug and ring thread
With the ring on the truncated portion of setting plug examine for side-to-side wobble.

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.