

**I.S.O. METRIC THREAD GAUGES**
**I. INDIAN STANDARD (IS)**

Basic dimensions: IS: 4218 Part III &amp; Part IV –1976

Gauging Practice: IS: 2344 –1975

**II. INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)**

Basic dimensions: ISO – 724-1978(E) / ISO – 965/1-1980(E)

Gauging Practice: ISO – 1502-1978/IS: 2344 –1975

**RIGHT HAND**

NOMINAL DIAMETER	PITCH	Thread Plugs D/E	Thread Rings Each	NOMINAL DIAMETER	PITCH	Thread Plugs D/E	Thread Rings Each
		GO & NO GO '6H'CLASS	GO or NOGO '6g'CLASS			GO & NO GO '6H'CLASS	GO or NOGO '6g'CLASS
		Rs	Rs			Rs	Rs
2	0.4	970	1700	18	2.5	1240	1425
2.2	0.45	970	1700		2	1030	1345
2.5	0.45	970	1700		1.5	900	945
3	0.5	650	760		1	900	945
3.5	0.6	650	760	20	2.5	1240	1830
4	0.7	650	760		2	1030	1640
	0.5	1030	1075		1.5	900	1175
4.5	0.75	1030	1075		1	900	1175
	0.5	1030	1075	22	2.5	1290	1830
5	0.8	650	760		2	1030	1640
	0.5	1030	1075		1.5	950	1175
5.5	0.5	1030	1075		1	950	1175
6	1	650	760	24	3	1290	1830
	0.75	1030	1075		2	1030	1640
7	1	650	760		1.5	950	1175
	0.75	1030	1075		1	950	1175
8	1.25	650	760	25	2	1170	1720
	1	650	760		1.5	1110	1510
	0.75	1030	1075		1	1110	1700
9	1.25	650	760	26	1.5	1265	1510
	1	650	760	27	3	1675	2400
	0.75	650	1075		2	1385	1935
10	1.5	650	760	28	1.5	1260	1700
	1.25	650	760		1	1260	1700
	1	650	760		2	1385	1935
	0.75	1030	1075		1.5	1260	1700
11	1.5	650	760	30	1	1260	1700
	1	650	760		3.5	2310	2475
	0.75	1030	1075		3	1920	2550
12	1.75	650	760	32	2	1510	2040
	1.5	650	760		1.5	1380	1885
	1.25	650	760		1	1740	2410
	1	650	760		2	1510	2040
14	2	870	1135	33	1.5	1380	1885
	1.5	775	800		3.5	2310	2475
	1.25	775	800		3	1920	2550
	1	775	800		2	1510	2040
15	1.5	1070	1165	35	1.5	1380	1885
	1	1070	1165		1.5	1470	1885
16	2	870	1135	36	4	2390	2700
	1.5	775	800		3	1920	2550
	1	775	800		2	1510	2040
17	1.5	1070	1100	38	1.5	1380	1885
	1	1070	1100		1.5	1380	1885

NOMINAL DIAMETER	PITCH	Thread Plugs D/E	Thread Rings Each	NOMINAL DIAMETER	PITCH	Thread Plugs D/E	Thread Rings Each	
		Go & NO GO '6H'CLASS	GoOR NOGO '6g'CLASS			Go & NO GO '6H'CLASS	GoOR NOGO '6g'CLASS	
39	4	2390	2700	62	4	3400	3610	
	3	1920	2550		3	2725	2985	
	2	1510	2040		2	2055	3190	
	1.5	1380	1885		1.5	1920	3060	
40	3	2030	2550	64	6	4285	4620	
	2	1600	2040		4	3400	3610	
	1.5	1380	1885		3	2725	2985	
42	4.5	3020	3320	65	2	2055	3190	
	4	3020	3150		1.5	1920	3060	
	3	2475	2985		4	3400	3610	
	2	1800	2560		3	2725	2985	
45	1.5	1740	2415	68	2	2055	3190	
	4.5	3020	3320		1.5	1920	3060	
	4	3020	3150		6	4430	4710	
	3	2475	2985		4	3730	3960	
48	2	1800	2560	70	3	3070	3260	
	1.5	1740	2415		2	2270	3190	
	5	3200	3560		1.5	2060	3060	
	4	3020	3150		6	4430	4710	
50	3	2475	2985	72	4	3730	3960	
	2	1800	2560		3	3070	3260	
	1.5	1740	2415		2	2270	3190	
	3	2475	2985		1.5	2060	3060	
52	2	1800	2560	75	6	4430	4710	
	1.5	1740	2415		4	3730	3960	
	5	3700	4185		3	3070	3260	
	4	3400	3610		2	2270	3190	
	3	2725	2985		1.5	2060	3060	
55	2	2055	3190	76	4	3730	3960	
	1.5	1920	3060		3	3070	3260	
	4	3400	3610		2	2270	3190	
	3	2725	2985		1.5	2060	3060	
56	2	2055	3190	78	6	4850	5280	
	1.5	1920	3060		4	4450	4760	
	4	3400	3610		3	3520	4620	
	3	2725	2985		2	2640	4030	
	2	2055	3190		1.5	2480	3780	
58	1.5	1920	3060	80	2	2640	4030	
	4	3400	3610		6	4850	5280	
	3	2725	2985		4	4450	4760	
	2	2055	3190		3	3520	4620	
60	1.5	1920	3060	82	2	2640	4030	
	4	3400	3610		85	6	4850	5280
	3	2725	2985			4	4450	4760
	2	2055	3190			3	3520	4620
	1.5	1920	3060			2	2640	4030
				1.5		2480	3780	

NOMINAL DIAMETER	PITCH	Thread Plugs D/E	Thread Rings Each				
		Go & NO GO '6H'CLAS S	GoOR NOGO '6g'CLASS				
90	6	6000	6210				
	4	5200	6000				
	3	4270	5830				
	2	3400	5120				
	1.5	3210	4810				
95	6	6000	6210				
	4	5200	6000				
	3	4270	5830				
	2	3400	5120				
	1.5	3210	4810				
100	6	7650	6210				
	4	5525	6000				
	3	4540	5830				
	2	3400	5120				
	1.5	3210	4810				
<b>1] THREAD PLUGS</b>							
i) Prices for single ended GO or NOGO Thread Plug Gauges will be at 60% of Double - ended Thread Plug Gauges.							
ii) Prices for Thread Plugs other than 6H Class add 20% extra on the price of 6H Thread Plug.							
iii) Price for Left Hand Thread Plugs is 40 % extra on the price of Right Hand Thread Plug.							
<b>2] THREAD RING:</b>							
i) For any class of fit other than 6g class add 40% extra on the prices of 6g thread rings up to 24 mm & 20 % extra on sizes above 24 mm.							
ii) Prices of LEFT HAND Ring Gauges add 40% extra .							
3] Prices for single ended NO GO Wear Check Plug Gauges is the same as a standard Double Ended Thread Plug gauge							
4] Prices for Double ended Check Plug Gauges add 50 % extra on Standard Thread Plug Gauges price							