

APPLICATION

Setters...set screwing tools more accurately- setting to low limits gives maximum runs without re-setting. Direct work approaching high limits before producing rejects. Make plating allowances.

Inspectors...use this very handy method of control at the machine in addition to normal routine inspection. Check border line rejects and worn plug gauges.

Storekeepers...replace worn taps by periodic checks with special O-VEE gauges for taps.

Quality Control Personnel...will find this a convenient method of obtaining effective diameter measurement for recording purposes.

ADVANTAGES

No Calculations Necessary...the high and low limits "over the wires" are clearly marked on the data plate.

No Reference Books or Tables Required...data plate shows correct tolerances for any specified fit.

No Grips or Supports Needed...the O-Vee gauges are manufactured from heat-treated, high tensile steel wire specially selected for accuracy and are well within B.S.I. Gauge Tolerances. They have been tested and approved by the National Physical Laboratory.

Versatility...O-Vee Gauges are available for any thread form; right, left hand, single or multi-start threads.

Low Cost...Gauges for both standard and non-standard threads involve a very modest outlay.

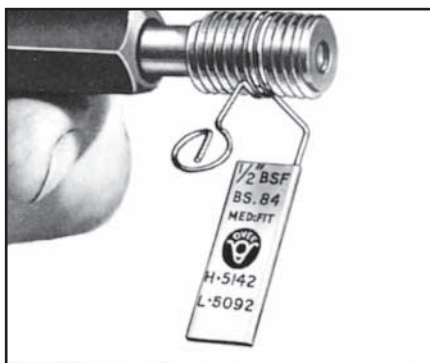
Acceptance of Border-Line Rejects...knowledge of the actual size facilitates a discretionary acceptance.

Standard O-Vee Gauges...intended for general production checking, quality control and for setting screwing tools.

Special O-Vee Gauges...can be made for threads of special pitches or diameters. Gauges can be supplied or in boxed sets.

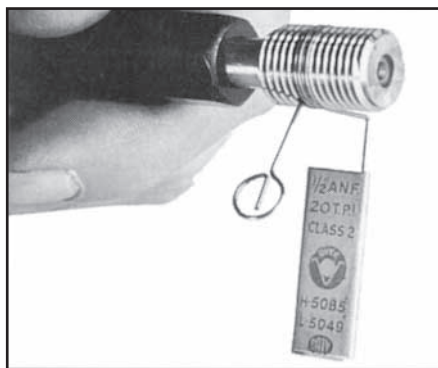
INSERT

Keep coil expanded by depressing lever and screw in component.



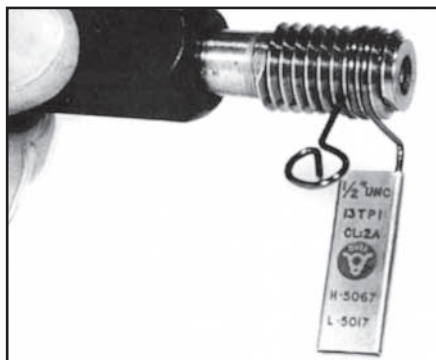
MEASURE

Take reading over coils.



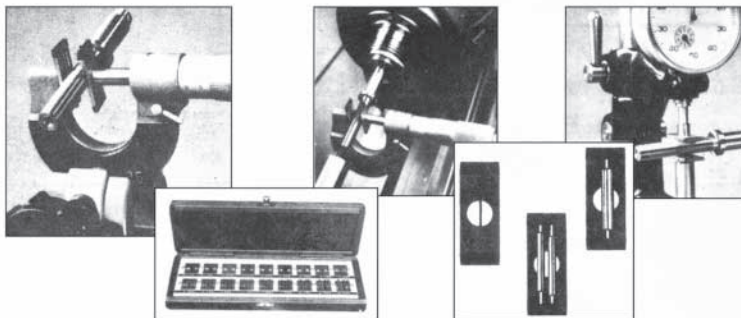
COMPARE

Checks reading with limits on data plate.



The O-Vee measuring system provides quick, simple and accurate internal and external measurement of threaded components. The effective diameter is measured over the wires, by a standard type micrometer, without recourse to calculations or reference to tables. The data plate shows a maximum and minimum limits over wires, and current tolerances for any specified fit.

ISO Metric BS 3643	Standard Gauge	Special Gauge	Internal Gauge	
M1.6-M3	√	√	N/A	N/A below 15mm
M3.1-M25	√	√	√	
M26-M50	√	√	√	
M51-M76	√	√	√	
M77 - M101	√	√	√	
M102-M127	√	√	√	
M128-M152	√	√	√	
M153-M177	√	√	√	
M178-M203	√	√	√	
M204-M228	√	√	√	
M229-M254	√	√	√	
M255-M280	√	√	√	
M282-M305	√	√	√	
BA (BRITISH ASSOCIATION) BS93				
0BA - 5BA	√	√	N/A	
6BA - 10BA	√	√	N/A	
UNIFIED: UNF/UN/UNFE/UNS BS 1580 & WHIT FORM: BSW/BSF BS 84				
1/32" - 1/8"	√	√	N/A	N/A below 5/8"
5/32" - 1"	√	√	√	
1 1/16" - 2"	√	√	√	
2 1/16" - 2"	√	√	√	
3 1/16" - 4"	√	√	√	
4 1/16" - 5"	√	√	√	
5 1/16" - 6"	√	√	√	
6 1/16" - 7"	√	√	√	
7 1/16" - 8"	√	√	√	
8 1/16" - 9"	√	√	√	
9 1/16" - 10"	√	√	√	
10 1/16" - 11"	√	√	√	
11 1/16" - 12"	√	√	√	
BSP (BRITISH STANDARD PIPE) BS2279				
1/8" - 5/8"	√	√	√	N/A
3/4" - 1 1/2"	√	√	√	
1 5/8" - 2 1/2"	√	√	√	
2 3/4" - 3 1/2"	√	√	√	
3 3/4" - 4 1/2"	√	√	√	
4 3/4" - 5 1/2"	√	√	√	
6"	√	√	√	



Available as pairs (3 wires) or Complete Set of 18 pairs, **Code73/3000**

D Cylinder Diameter Marked	Whitworth T.P.I.	'P' Value	60 Unified T.P.I.	'P' Value	60 I.S.O. Metric Pitch mm	'P' Value in mm	B.A. No.	'P' Value
3.200mm (0.12598")	4 1/2	0.06659"	4 1/2	0.06647"	5.5	1.5631"		
2.550mm (0.10039")	5	0.04525"	5	0.04722"	5.0	1.1303"		
2.050mm (0.08071")	6	0.04306"	6	0.04395"	4.5	1.3472"		
1.650mm (0.06496")	7	0.04313"	7	0.04301"	4.0	0.9141"		
1.350mm (0.05315")	8	0.02598"	8	0.02754"	3.5	0.9809"		
1.100mm (0.04331")	9	0.03100"	9	0.03126"	3.0	0.5481"		
0.895mm (0.03524")	10	0.02033"	10	0.02164"	2.5	0.5151"		
0.725mm (0.02854")	11	0.02536"	11	0.02258"	2.0	0.3820"		
0.620mm (0.02441")	12	0.01809"	12	0.01902"	1.75	0.4155"		
0.530mm (0.02087")	14	0.01811"	13	0.02331"	1.5	0.4039"		
0.455mm (0.01791")	16	0.01895"	14	0.01855"	1.25	0.3576		
0.390mm (0.01535")	18	0.01228"	16	0.01889"	1.0	0.2459"		
0.335mm (0.01319")	20	0.01728"	18	0.01287"	0.90	0.2494"	0	0.01379"
0.290mm (0.1142")	22	0.01520"	20	0.01476"	0.80	0.1628"	1	0.00932"
0.250mm (0.00984")	24	0.01157"	24	0.01167"	0.75	0.1946"	2	0.00968"
0.220mm (0.00866")	26	0.01261"	26	0.01244"	0.70	0.1514"		
0.195mm	28	0.00998"	28	0.01006"	0.65	0.1730"	3	0.00990"
0.170mm (0.00669")	32	0.00914"	32	0.00915"	0.60	0.1847"	4	0.00676"
	36	0.00879"	36	0.00615"	0.50	0.1430"	5	0.00684"
	40	0.00864"	40	0.00630"	0.45	0.0996"	6	0.00678"
	44	0.00864"	44	0.00433"	0.40	0.0965"	7	0.00454"
	48	0.00864"	48	0.00485"	0.35	0.0831"	8	0.00468"
	56	0.00670"	56	0.00404"			9	0.00460"
	64	0.00454"	64	0.00369"			10	0.00427"
	72	0.00491"	72	0.00337"			11	0.00395"
	80	0.00438"	80	0.00315"			12	0.00261"
		0.00421"			0.30	0.0899"		
					0.25	0.0465"		