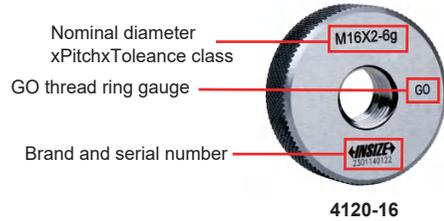


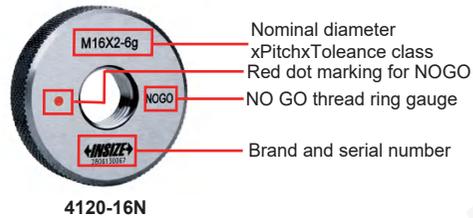


OPERATION INSTRUCTION

Metric Thread Ring Gauges



4120-16



4120-16N

Code example: “-2” stands for “4120-2”

Size (mm)		Code (4120)					
Nominal diameter	Pitch	Class 6g		Class 6e		Class 6h	
		GO	NOGO	GO	NOGO	GO	NOGO
M2	0.4	-2	-2N	-2E	-2EN	-2H	-2HN
M2.2	0.45	-2D2	-2D2N	-2D2E	-2D2EN	-2D2H	-2D2HN
M2.3	0.4	-2D3	-2D3N	-2D3E	-2D3EN	-2D3H	-2D3HN
M2.5	0.45	-2D5	-2D5N	-2D5E	-2D5EN	-2D5H	-2D5HN
M2.6	0.45	-2D6	-2D6N	-2D6E	-2D6EN	-2D6H	-2D6HN
M3	0.5	-3	-3N	-3E	-3EN	-3H	-3HN
M3.5	0.6	-3D5	-3D5N	-3D5E	-3D5EN	-3D5H	-3D5HN
M4	0.7	-4	-4N	-4E	-4EN	-4H	-4HN
M4.5	0.75	-4D5	-4D5N	-4D5E	-4D5EN	-4D5H	-4D5HN
M5	0.8	-5	-5N	-5E	-5EN	-5H	-5HN
M6	1	-6	-6N	-6E	-6EN	-6H	-6HN

Size (mm)		Code (4120)					
Nominal diameter	Pitch	Class 6g		Class 6e		Class 6h	
		GO	NOGO	GO	NOGO	GO	NOGO
M7	1	-7	-7N	-7E	-7EN	-7H	-7HN
M8	1.25	-8	-8N	-8E	-8EN	-8H	-8HN
M9	1.25	-9	-9N	-9E	-9EN	-9H	-9HN
M10	1.5	-10	-10N	-10E	-10EN	-10H	-10HN
M11	1.5	-11	-11N	-11E	-11EN	-11H	-11HN
M12	1.75	-12	-12N	-12E	-12EN	-12H	-12HN
M14	2	-14	-14N	-14E	-14EN	-14H	-14HN
M16	2	-16	-16N	-16E	-16EN	-16H	-16HN
M18	2.5	-18	-18N	-18E	-18EN	-18H	-18HN
M20	2.5	-20	-20N	-20E	-20EN	-20H	-20HN
M22	2.5	-22	-22N	-22E	-22EN	-22H	-22HN
M24	3	-24	-24N	-24E	-24EN	-24H	-24HN
M27	3	-27	-27N	-27E	-27EN	-27H	-27HN
M30	3.5	-30	-30N	-30E	-30EN	-30H	-30HN
M33	3.5	-33	-33N	-33E	-33EN	-33H	-33HN
M36	4	-36	-36N	-36E	-36EN	-36H	-36HN
M39	4	-39	-39N	-39E	-39EN	-39H	-39HN
M42	4.5	-42	-42N	-42E	-42EN	-42H	-42HN
M45	4.5	-45	-45N	-45E	-45EN	-45H	-45HN
M48	5	-48	-48N	-48E	-48EN	-48H	-48HN
M52	5	-52	-52N	-52E	-52EN	-52H	-52HN
M56	5.5	-56	-56N	-56E	-56EN	-56H	-56HN
M60	5.5	-60	-60N	-60E	-60EN	-60H	-60HN

Go ring gauge set

Code	Thread ring gauges included
4120-S7	M3x0.5(4120-3), M4x0.7(4120-4), M5x0.8(4120-5), M6x1(4120-6), M8x1.25(4120-8), M10x1.5(4120-10), M12x1.75(4120-12)

No Go ring gauge set

Code	Thread ring gauges included
4120-S7N	M3x0.5(4120-3N), M4x0.7(4120-4N), M5x0.8(4120-5N), M6x1(4120-6N), M8x1.25(4120-8N), M10x1.5(4120-10N), M12x1.75(4120-12N)

1. The product is used for comprehensive inspection of common external threads.

2.Usage

- a. Select the corresponding specification of the thread ring gauge according to the measured external thread workpiece.
- b. Aim the GO thread ring gauge at the external thread to be tested, and rotate the thread ring gauge or the external threaded workpiece to be tested with three fingers (thumb, forefinger, middle finger), so that it rotates and passes through the whole length of the thread in the free state, then it is regarded as a qualified test of the through gauge, and vice versa, it is unqualified.
- c. Align the NO GO thread ring gauge with the two ends of the external thread to be tested, rotate the thread ring gauge or the external threaded workpiece to be tested with three fingers (thumb, forefinger, middle finger), and the NO GO thread ring gauge is screwed into the threaded workpiece to be tested not exceeding two pitches, then it is regarded as a qualified test of the NO GO thread ring gauge (The NO GO thread ring gauge shall not pass completely through a workpiece with a length of thread of three threads or less.).
- d. When both GO and NO GO thread ring gauge tests are qualified, the external threaded workpiece under test is regarded as qualified, and the opposite is regarded as unqualified.

3. Precautions

- a. Before using the thread ring gauge, the surface of the measured external threaded workpiece should be cleaned to ensure that no impurities or oil will affect the measurement results.
- b. When screwing in the thread ring gauge, don't use excessive force. It should be kept as stable as possible, avoiding shaking or rotating too fast, so as not to damage the thread ring gauge.
- c. After use, gently wipe the measuring surface of the thread ring gauge, oil it to prevent rusting, put it back into the special gauge box and put it in a cool and dry place.