



OPERATION INSTRUCTION

Metric Thread Plug Gauges



Brand Product code Serial number

front



GO plug gauge Nominal diameter xPitch xTolerance class NO GO plug gauge

back

4130-30

Code example: "-D8" stands for "4130-D8"

Size (mm)		Code (4130)		
Nominal diameter	Pitch	Class 6H	Class 6G	Class 4H
M0.8	0.2	-D8	-D8G	-D8H
M0.9	0.225	-D9	-D9G	-D9H
M1	0.25	-1	-1G	-1H
M1.1	0.25	-1D1	-1D1G	-1D1H
M1.2	0.25	-1D2	-1D2G	-1D2H
M1.4	0.3	-1D4	-1D4G	-1D4H
M1.6	0.35	-1D6	-1D6G	-1D6H
M1.7	0.35	-1D7	-1D7G	-1D7H
M1.8	0.35	-1D8	-1D8G	-1D8H
M2	0.4	-2	-2G	-2H
M2.2	0.45	-2D2	-2D2G	-2D2H
M2.3	0.4	-2D3	-2D3G	-2D3H
M2.5	0.45	-2D5	-2D5G	-2D5H
M2.6	0.45	-2D6	-2D6G	-2D6H
M3	0.5	-3	-3G	-3H

Size (mm)		Code (4130)		
Nominal diameter	Pitch	Class 6H	Class 6G	Class 4H
M3.5	0.6	-3D5	-3D5G	5H
M4	0.7	-4	-4G	-4H
M4.5	0.75	-4D5	-4D5G	-4D5H
M5	0.8	-5	-5G	-5H
M6	1	-6	-6G	-6H
M7	1	-7	-7G	-7H
M8	1.25	-8	-8G	-8H
M9	1.25	-9	-9G	-9H
M10	1.5	-10	-10G	-10H
M11	1.5	-11	-11G	-11H
M12	1.75	-12	-12G	-12H
M14	2	-14	-14G	-14H
M16	2	-16	-16G	-16H
M18	2.5	-18	-18G	-18H
M20	2.5	-20	-20G	-20H

Size (mm)		Code (4130)		
Nominal diameter	Pitch	Class 6H	Class 6G	Class 4H
M22	2.5	-22	-22G	-22H
M24	3	-24	-24G	-24H
M27	3	-27	-27G	-27H
M30	3.5	-30	-30G	-30H
M33	3.5	-33	-33G	-33H
M36	4	-36	-36G	-36H
M39	4	-39	-39G	-39H

Size (mm)		Code (4130)		
Nominal diameter	Pitch	Class 6H	Class 6G	Class 4H
M42	4.5	-42	-42G	-42H
M45	4.5	-45	-45G	-45H
M48	5	-48	-48G	-48H
M52	5	-52	-52G	-52H
M56	5.5	-56	-56G	-56H
M60	5.5	-60	-60G	-60H

Set

Code	Thread plug gages included
4130-S7	M3x0.5(4130-3), M4x0.7(4130-4), M5x0.8(4130-5), M6x1(4130-6), M8x1.25(4130-8), M10x1.5(4130-10), M12x1.75(4130-12)

- The product is used for comprehensive inspection of common internal threads.
- Usage
 - Select the corresponding specification of the thread plug gauge according to the measured internal thread workpiece.
 - Aim the GO thread plug gauge at the internal thread to be tested, and rotate the thread plug gauge or the internal 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.
 - Align the NO GO thread plug gauge with the two ends of the internal thread to be tested, rotate the thread plug gauge or the internal threaded workpiece to be tested with three fingers (thumb, forefinger, middle finger), and the NO GO thread plug 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 plug gauge (The NO GO thread plug gauge shall not pass completely through a workpiece with a length of thread of three threads or less.).
 - When both GO and NO GO thread plug tests are qualified, the internal threaded workpiece under test is regarded as qualified, and the opposite is regarded as unqualified.
- Precautions
 - Before using the thread plug gauge, the surface of the measured internal threaded workpiece should be cleaned to ensure that no impurities or oil will affect the measurement results.
 - When screwing in the thread plug 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 plug gauge.
 - After use, gently wipe the measuring surface of the thread plug gauge, oil it to prevent rusting, put it back into the special gauge box and put it in a cool and dry place.

MN-4130-E

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