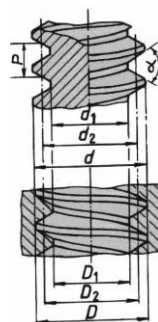


MEASURING DIAMETERS d_1 & D ON THREADS

The FMS thread inserts in the tables below are for measuring d_1 on external threads and D on internal threads.

Thread inserts for these two diameters not shown in the tables can be manufactured to either the thread standard specification or to customer specification.



EXTERNAL THREAD
 d = Major diameter
 d_2 = Pitch diameter
 d_1 = Minor diameter

INTERNAL THREAD
 D = Major diameter
 D_2 = Pitch diameter
 D_1 = minor diameter

P = Pitch
 α = Flank angle

For measuring d_1 on external threads with a flank angle of 55° or 60°		
FMS No.	For	Nose radius
71-001	1 & 2mm	R 0.12
71-002	1.25 & 2.5mm	R 0.15
71-003	1.5 & 3mm	R 0.18
71-004	1.75 & 3.5mm	R 0.2
71-005	2 & 4mm	R 0.25
71-006	2.5 & 5mm	R 0.3
71-007	3 & 6mm	R 0.35
71-008	4 and 8mm	R 0.5
71-009	4.5mm	R 0.55
71-010	5.5mm	R 0.65
71-101	28 & 14 TPI	R 0.1
71-102	24 & 12 TPI	R 0.12
71-103	22 & 11 TPI	R 0.13
71-104	20 & 10 TPI	R 0.15
71-105	19 TPI	R 0.16
71-106	18 & 9 TPI	R 0.16
71-107	16 & 8 TPI	R 0.19
71-108	14 & 7 TPI	R 0.2
71-109	12 & 6 TPI	R 0.25
71-110	10 & 5 TPI	R 0.3
71-111	8 & 4 TPI	R 0.38
71-112	6 & 3 TPI	R 0.5

For measuring D on internal threads with a flank angle of 55° or 60°		
FMS No.	For	Nose radius
72-001	1 & 2mm	R 0.06
72-002	1.25 & 2.5mm	R 0.07
72-003	1.5 & 3mm	R 0.09
72-004	1.75 & 3.5mm	R 0.1
72-005	2 & 4mm	R 0.12
72-006	2.5 & 5mm	R 0.15
72-007	3 & 6mm	R 0.17
72-008	4 and 8mm	R 0.25
72-009	4.5mm	R 0.27
72-010	5.5mm	R 0.32
72-101	28 & 14 TPI	R 0.05
72-102	24 & 12 TPI	R 0.06
72-103	22 & 11 TPI	R 0.06
72-104	20 & 10 TPI	R 0.07
72-105	19 TPI	R 0.08
72-106	18 & 9 TPI	R 0.08
72-107	16 & 8 TPI	R 0.09
72-108	14 & 7 TPI	R 0.1
72-109	12 & 6 TPI	R 0.12
72-110	10 & 5 TPI	R 0.15
72-111	8 & 4 TPI	R 0.19
72-112	6 & 3 TPI	R 0.25

Thread inserts for many other thread types and pitches (i.e metric Tr/Stub Tr & ACME/STUB ACME) for measuring d_1 & D can be made to order.



FMS calibration plate no. 75A can be used to calibrate external and internal FMS thread inserts for diameters d_1 and D .

N.B. As with all standard FMS thread measurement inserts they can be used for both RH & LH threads.

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