

Using Screw Plug Gauges

1. Understand the Purpose

Go/Nogo screw plug gauges are used to quickly determine if the internal threads of nuts or threaded holes are within specified tolerances. They provide a simple pass/fail assessment without providing detailed measurements.

2. Select the Correct Gauge

Choose the appropriate Go/Nogo screw plug gauge for the thread size you want to check. These gauges are usually engraved with the thread description and pitch diameters they designed to check.

3. Clean the Workpiece

Before using the gauge, ensure that the threads of the nut or hole are clean and free from debris or burrs. This ensures accurate assessments and prevents any interference during the gauging process.

4. Insert the Gauges

Screw the Go gauge into the threaded hole or nut being checked, ensure it enters smoothly to full depth without force or resistance. Next try to screw in the Nogo gauge, it should not enter.

5. Interpret the Assessment

If the Go gauge fits properly and the Nogo gauge does not enter, it signifies that the threads are within tolerance. However, if the Go gauge does not enter or the Nogo gauge does enter, it indicates the threads are out of tolerance.

(Refer to downloads - Allowable Nogo engagement)

6. Record the Assessment

If needed, document the results obtained using the gauges. This record can be useful for quality control purposes or for taking appropriate actions based on the assessment.

7. Clean and Store the Gauges

After use, clean the gauges thoroughly to remove any debris or contaminants then apply a light coat of oil. Store them in a clean, dry place, ensuring they are protected from damage to maintain their accuracy for future use.