

## Using Screw Ring Gauges

### 1. Understand the Purpose

Go and Nogo screw ring gauges are used to quickly determine if the external threads of bolts or threaded shafts are within specified tolerances. They provide a simple pass/fail assessment without providing detailed measurements.

### 2. Select the Correct Gauge

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

### 3. Clean the Workpiece

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

### 4. Apply the Gauges

Screw the Go gauge on to the threaded shaft or bolt being checked, ensure it screws on smoothly to full depth without force or resistance. Next try to screw on the Nogo gauge, it should not start on the thread.

### 5. Interpret the Assessment

If the Go gauge fits properly and the Nogo gauge does not fit, it signifies that the threads are within tolerance. However, if the Go gauge does not screw on or the Nogo gauge does screw on, 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.