

## Allowable Nogo Engagement

Component threads both internal and external should be gauged by hand without using excessive force. Ideally the Go gauge should engage the component fully and the Not Go gauge should not engage the component. Below is a summary from two standards that do allow for limited Nogo engagement.

### I. AS 1014-1986

Solid and adjustable Not Go screw ring gauges, external component threads are permitted to enter up to two turns of the thread. *Ref A3.1.2*

Not Go screw plug gauges are permitted to enter the internal component thread up to two turns. *Ref A3.2.2*

Note that the determination of two turns is based on withdrawal disengagement.

Procedure to measure withdrawal disengagement

1. Screw the Not Go gauge on to the component thread until it stops, only use hand force.
2. Take note of the gauge position relative to the component thread, making a line is useful.
3. Unscrew the gauge carefully noting when disengagement takes place.
4. Compare the amount of turns of disengagement to the allowable specification.

### II. ANSI/ASME B1.2-1983

Not Go (HI) Thread Plug Gauges

The functional diameter is acceptable if the product internal thread does not enter more than three complete turns. *Ref 4.2.1*

Not Go (LO) Thread Ring Gauge

The functional diameter is acceptable if the ring gauge applied to the product external thread does not pass over the thread more than three complete turns. *Ref 5.2.1*

Always refer to the applicable standard to ensure details are correct for your application.