BRITISH STANDARD

Screw gauge limits and tolerances –

Part 4: Limits of size for gauges for screw threads of unified form diameters $\frac{1}{4}$ in and larger

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British Standards

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Contents

List of tables

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 62, an inside back cover and a back cover.

Foreword

This British Standard was published by BSI and came into effect on 31 October 2007. It was prepared by Subcommittee SFTSE/1, *Screws and fasteners technical specification committee*, under the authority of Technical Committee TDW/4, *Technical product realization*. A list of organizations represented on these committees can be obtained on request to their secretaries.

BS 919, *Screw gauge limits and tolerances* is in four parts:

Part 1: Specification for gauges for screw threads of unified form

Part 2: Specification for gauges for screw threads of Whitworth and B.A. forms

Part 3: Specification for gauges for screw threads of ISO metric form

Part 4: Limits of size for gauges for screw threads of unified form diameters $\frac{1}{4}$ in and larger

Supersession

This Part of BS 919 supersedes BS 919-6:1964, which is withdrawn.

Relationship with other publications

This British Standard is intended for use with BS 1580-1, which specifies the corresponding screw threads.

Information about this document

This British Standard has been fully revised to bring it up to date.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is "shall".

Commentary, explanation and general informative material is presented in notes in smaller italic type, and does not constitute a normative element.

Contractual and legal considerations

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

1 Scope

This British Standard specifies the limits of size for the following types of gauges, setting plugs and check plugs for the various classes of standard Unified Coarse (UNC), Unified Fine (UNF) and Unified Extra Fine (UNEF) threads specified in BS 1580-1.

a) GO and NOT GO screw gauges:

   1) screw plug gauges;

   2) solid screw ring gauges;

   3) adjustable screw ring gauges;

   4) adjustable screw calliper gauges.

b) Setting plugs for GO and NOT GO adjustable screw ring gauges and for GO and NOT GO adjustable screw calliper gauges:

   1) double length type;

   2) single length type.

c) GO and NOT GO check plugs for solid screw ring gauges.

d) GO and NOT GO plug gauges and GO and NOT GO calliper gauges for the crest diameters of product threads.

NOTE The values tabulated in this standard have been derived from the application of the tolerances specified in BS 919-1 to the limits of size given in BS 1580, and reference should be made to the former standard for general information, details of the form of thread for Unified screw gauges, and tolerances on pitch and thread angle.

2 Terms and definitions

For the purposes of this part of BS 919, the terms and definitions given in BS 6528:1984 and the following apply.

2.1 effective diameter

diameter of the pitch cylinder

*NOTE 1 This is the "simple" effective diameter, as distinct from the "virtual" effective diameter (see **2.2**).*

NOTE Also known as "pitch diameter".

2.2 virtual effective diameter

effective diameter of an imaginary thread of perfect pitch and flank angle, having the full depth of flanks, but clear at the crests and roots, which would just assemble with the actual thread over the prescribed length of engagement

NOTE The "virtual" effective diameter exceeds the effective diameter in the case of an external thread, but is less than the effective diameter in the case of an internal thread by an amount corresponding to the combined diametral effects due to any errors in the pitch and/or the flank angles of the thread.

Section 1: Unified coarse threads, UNC

Table 1 **Limits of size for GO screw plug gauges (all classes of thread)**

1	2	3	4	5
Designation	**Major diameter**		**Effective diameter**	
	Max.	**Min.**	**Max.**	**Min.**
	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.250 5	0.250 0	0.217 8	0.217 5
$\frac{5}{16}$ — 18 UNC	0.313 0	0.312 5	0.276 7	0.276 4
$\frac{3}{8}$ — 16 UNC	0.375 6	0.375 0	0.334 7	0.334 4
$\frac{7}{16}$ — 14 UNC	0.438 1	0.437 5	0.391 4	0.391 1
$\frac{1}{2}$ — 13 UNC	0.500 6	0.500 0	0.450 3	0.450 0
$\frac{9}{16}$ — 12 UNC	0.563 1	0.562 5	0.508 7	0.508 4
$\frac{5}{8}$ — 11 UNC	0.625 6	0.625 0	0.566 3	0.566 0
$\frac{3}{4}$ — 10 UNC	0.750 6	0.750 0	0.685 3	0.685 0
$\frac{7}{8}$ — 9 UNC	0.875 7	0.875 0	0.803 1	0.802 8
1 — 8 UNC	1.000 7	1.000 0	0.919 2	0.918 8
$1\frac{1}{8}$ — 7 UNC	1.125 7	1.125 0	1.032 6	1.032 2
$1\frac{1}{4}$ — 7 UNC	1.250 7	1.250 0	1.157 6	1.157 2
$1\frac{3}{8}$ — 6 UNC	1.375 8	1.375 0	1.267 1	1.266 7
$1\frac{1}{2}$ — 6 UNC	1.500 8	1.500 0	1.392 1	1.391 7
$1\frac{3}{4}$ — 5 UNC	1.750 8	1.750 0	1.620 6	1.620 1
2 — $4\frac{1}{2}$ UNC	2.000 8	2.000 0	1.856 2	1.855 7
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.250 8	2.250 0	2.106 2	2.105 7
$2\frac{1}{2}$ — 4 UNC	2.500 9	2.500 0	2.338 1	2.337 6
$2\frac{3}{4}$ — 4 UNC	2.750 9	2.750 0	2.588 1	2.587 6
3 — 4 UNC	3.000 9	3.000 0	2.838 1	2.837 6
$3\frac{1}{4}$ — 4 UNC	3.250 9	3.250 0	3.088 1	3.087 6
$3\frac{1}{2}$ — 4 UNC	3.500 9	3.500 0	3.338 1	3.337 6
$3\frac{3}{4}$ — 4 UNC	3.750 9	3.750 0	3.588 1	3.587 6
4 — 4 UNC	4.000 9	4.000 0	3.838 1	3.837 6

Table 2 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum)[1], Class 1B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.235 6	0.235 1	0.246 5	0.246 0	0.225 1	0.224 8
$\frac{5}{16}$ — 18 UNC	0.296 3	0.295 8	0.308 4	0.307 9	0.284 6	0.284 3
$\frac{3}{8}$ — 16 UNC	0.356 4	0.355 8	0.370 0	0.369 4	0.343 2	0.342 9
$\frac{7}{16}$ — 14 UNC	0.415 8	0.415 2	0.431 2	0.430 6	0.400 6	0.400 3
$\frac{1}{2}$ — 13 UNC	0.476 3	0.475 7	0.493 0	0.492 4	0.460 0	0.459 7
$\frac{9}{16}$ — 12 UNC	0.536 6	0.536 0	0.554 7	0.554 1	0.518 9	0.518 6
$\frac{5}{8}$ — 11 UNC	0.596 4	0.595 8	0.616 1	0.615 5	0.577 0	0.576 7
$\frac{3}{4}$ — 10 UNC	0.718 1	0.717 5	0.739 8	0.739 2	0.696 8	0.696 5
$\frac{7}{8}$ — 9 UNC	0.839 2	0.838 5	0.863 2	0.862 5	0.815 4	0.815 1
1 — 8 UNC	0.959 1	0.958 4	0.986 1	0.985 4	0.932 4	0.932 0
$1\frac{1}{8}$ — 7 UNC	1.077 2	1.076 5	1.108 2	1.107 5	1.046 7	1.046 3
$1\frac{1}{4}$ — 7 UNC	1.202 5	1.201 8	1.233 5	1.232 8	1.172 0	1.171 6
$1\frac{3}{8}$ — 6 UNC	1.318 3	1.317 5	1.354 4	1.353 6	1.282 6	1.282 2
$1\frac{1}{2}$ — 6 UNC	1.443 6	1.442 8	1.479 7	1.478 9	1.407 9	1.407 5
$1\frac{3}{4}$ — 5 UNC	1.680 8	1.680 0	1.724 1	1.723 3	1.638 0	1.637 5
2 — $4\frac{1}{2}$ UNC	1.922 4	1.921 6	1.970 5	1.969 7	1.874 8	1.874 3
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.172 8	2.172 0	2.220 9	2.220 1	2.125 2	2.124 7
$2\frac{1}{2}$ — 4 UNC	2.411 9	2.411 0	2.466 1	2.465 2	2.358 3	2.357 8
$2\frac{3}{4}$ — 4 UNC	2.662 3	2.661 4	2.716 5	2.715 6	2.608 7	2.608 2
3 — 4 UNC	2.912 6	2.911 7	2.966 8	2.965 9	2.859 0	2.858 5
$3\frac{1}{4}$ — 4 UNC	3.162 9	3.162 0	3.217 1	3.216 2	3.109 3	3.108 8
$3\frac{1}{2}$ — 4 UNC	3.413 2	3.412 3	3.467 4	3.466 5	3.359 6	3.359 1
$3\frac{3}{4}$ — 4 UNC	3.663 5	3.662 6	3.717 7	3.716 8	3.609 9	3.609 4
4 — 4 UNC	3.913 8	3.912 9	3.968 0	3.967 1	3.860 2	3.859 7

[1] These terms are explained in BS 919-1.

Table 3 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 2B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.233 1	0.232 6	0.244 0	0.243 5	0.222 6	0.222 3
$\frac{5}{16}$ — 18 UNC	0.293 7	0.293 2	0.305 8	0.305 3	0.282 0	0.281 7
$\frac{3}{8}$ — 16 UNC	0.353 6	0.353 0	0.367 2	0.366 6	0.340 4	0.340 1
$\frac{7}{16}$ — 14 UNC	0.412 7	0.412 1	0.428 1	0.427 5	0.397 5	0.397 2
$\frac{1}{2}$ — 13 UNC	0.473 2	0.472 6	0.489 8	0.489 2	0.456 8	0.456 5
$\frac{9}{16}$ — 12 UNC	0.533 2	0.532 6	0.551 3	0.550 7	0.515 5	0.515 2
$\frac{5}{8}$ — 11 UNC	0.592 9	0.592 3	0.612 6	0.612 0	0.573 5	0.573 2
$\frac{3}{4}$ — 10 UNC	0.714 3	0.713 7	0.736 0	0.735 4	0.693 0	0.692 7
$\frac{7}{8}$ — 9 UNC	0.835 1	0.834 4	0.859 1	0.858 4	0.811 3	0.811 0
1 — 8 UNC	0.954 7	0.954 0	0.981 7	0.981 0	0.928 0	0.927 6
$1\frac{1}{8}$ — 7 UNC	1.072 5	1.071 8	1.103 5	1.102 8	1.042 0	1.041 6
$1\frac{1}{4}$ — 7 UNC	1.197 7	1.197 0	1.228 7	1.228 0	1.167 2	1.166 8
$1\frac{3}{8}$ — 6 UNC	1.313 2	1.312 4	1.349 3	1.348 5	1.277 5	1.277 1
$1\frac{1}{2}$ — 6 UNC	1.438 3	1.437 5	1.474 4	1.473 6	1.402 6	1.402 2
$1\frac{3}{4}$ — 5 UNC	1.675 0	1.674 2	1.718 3	1.717 5	1.632 2	1.631 7
2 — $4\frac{1}{2}$ UNC	1.916 2	1.915 4	1.964 3	1.963 5	1.868 6	1.868 1
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.166 4	2.165 6	2.214 5	2.213 7	2.118 8	2.118 3
$2\frac{1}{2}$ — 4 UNC	2.405 2	2.404 3	2.459 4	2.458 5	2.351 6	2.351 1
$2\frac{3}{4}$ — 4 UNC	2.655 4	2.654 5	2.709 6	2.708 7	2.601 8	2.601 3
3 — 4 UNC	2.905 6	2.904 7	2.959 8	2.958 9	2.852 0	2.851 5
$3\frac{1}{4}$ — 4 UNC	3.155 8	3.154 9	3.210 0	3.209 1	3.102 2	3.101 7
$3\frac{1}{2}$ — 4 UNC	3.406 0	3.405 1	3.460 2	3.459 3	3.352 4	3.351 9
$3\frac{3}{4}$ — 4 UNC	3.656 2	3.655 3	3.710 4	3.709 5	3.602 6	3.602 1
4 — 4 UNC	3.906 4	3.905 5	3.960 6	3.959 7	3.852 8	3.852 3

Table 4 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 3B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.231 9	0.231 4	0.242 8	0.242 3	0.221 4	0.221 1
$\frac{5}{16}$ — 18 UNC	0.292 3	0.291 8	0.304 4	0.303 9	0.280 6	0.280 3
$\frac{3}{8}$ — 16 UNC	0.352 2	0.351 6	0.365 8	0.365 2	0.339 0	0.338 7
$\frac{7}{16}$ — 14 UNC	0.411 2	0.410 6	0.426 6	0.426 0	0.396 0	0.395 7
$\frac{1}{2}$ — 13 UNC	0.471 4	0.470 8	0.488 1	0.487 5	0.455 1	0.454 8
$\frac{9}{16}$ — 12 UNC	0.531 5	0.530 9	0.549 6	0.549 0	0.513 8	0.513 5
$\frac{5}{8}$ — 11 UNC	0.591 1	0.590 5	0.610 8	0.610 2	0.571 7	0.571 4
$\frac{3}{4}$ — 10 UNC	0.712 3	0.711 7	0.734 0	0.733 4	0.691 0	0.690 7
$\frac{7}{8}$ — 9 UNC	0.833 0	0.832 3	0.857 0	0.856 3	0.809 2	0.808 9
1 — 8 UNC	0.952 5	0.951 8	0.979 5	0.978 8	0.925 8	0.925 4
$1\frac{1}{8}$ — 7 UNC	1.070 2	1.069 5	1.101 2	1.100 5	1.039 7	1.039 3
$1\frac{1}{4}$ — 7 UNC	1.195 3	1.194 6	1.226 3	1.225 6	1.164 8	1.164 4
$1\frac{3}{8}$ — 6 UNC	1.310 6	1.309 8	1.346 7	1.345 9	1.274 9	1.274 5
$1\frac{1}{2}$ — 6 UNC	1.435 7	1.434 9	1.471 8	1.471 0	1.400 0	1.399 6
$1\frac{3}{4}$ — 5 UNC	1.672 1	1.671 3	1.715 4	1.714 6	1.629 3	1.628 8
2 — $4\frac{1}{2}$ UNC	1.913 1	1.912 3	1.961 2	1.960 4	1.865 5	1.865 0
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.163 3	2.162 5	2.211 4	2.210 6	2.115 7	2.115 2
$2\frac{1}{2}$ — 4 UNC	2.401 8	2.400 9	2.456 0	2.455 1	2.348 2	2.347 7
$2\frac{3}{4}$ — 4 UNC	2.652 0	2.651 1	2.706 2	2.705 3	2.598 4	2.597 9
3 — 4 UNC	2.902 1	2.901 2	2.956 3	2.955 4	2.848 5	2.848 0
$3\frac{1}{4}$ — 4 UNC	3.152 3	3.151 4	3.206 5	3.205 6	3.098 7	3.098 2
$3\frac{1}{2}$ — 4 UNC	3.402 5	3.401 6	3.456 7	3.455 8	3.348 9	3.348 4
$3\frac{3}{4}$ — 4 UNC	3.652 6	3.651 7	3.706 8	3.705 9	3.599 0	3.598 5
4 — 4 UNC	3.902 8	3.901 9	3.957 0	3.956 1	3.849 2	3.848 7

Table 5 **Limits of size for GO and NOT GO plug gauges for minor diameters**

1	2	3	4	5	6	7
Designation	**GO gauges**		**NOT GO gauges**			
	All classes of thread		**Classes 1B and 2B threads**		**Class 3B threads**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.196 2	0.195 9	0.207 7	0.207 4	0.207 0	0.206 7
$\frac{5}{16}$ — 18 UNC	0.252 7	0.252 4	0.265 4	0.265 1	0.263 3	0.263 0
$\frac{3}{8}$ — 16 UNC	0.307 6	0.307 3	0.321 7	0.321 4	0.318 5	0.318 2
$\frac{7}{16}$ — 14 UNC	0.360 5	0.360 2	0.376 3	0.376 0	0.372 0	0.371 7
$\frac{1}{2}$ — 13 UNC	0.417 0	0.416 7	0.433 9	0.433 6	0.428 7	0.428 4
$\frac{9}{16}$ — 12 UNC	0.472 6	0.472 3	0.490 7	0.490 4	0.484 6	0.484 3
$\frac{5}{8}$ — 11 UNC	0.526 9	0.526 6	0.546 3	0.546 0	0.539 4	0.539 1
$\frac{3}{4}$ — 10 UNC	0.642 0	0.641 7	0.663 0	0.662 7	0.654 8	0.654 5
$\frac{7}{8}$ — 9 UNC	0.755 0	0.754 7	0.777 8	0.777 5	0.768 8	0.768 5
1 — 8 UNC	0.865 0	0.864 7	0.890 0	0.889 7	0.880 0	0.879 7
$1\frac{1}{8}$ — 7 UNC	0.970 7	0.970 4	0.998 3	0.998 0	0.987 8	0.987 5
$1\frac{1}{4}$ — 7 UNC	1.095 7	1.095 4	1.123 3	1.123 0	1.112 8	1.112 5
$1\frac{3}{8}$ — 6 UNC	1.194 9	1.194 6	1.225 3	1.225 2	1.214 9	1.214 6
$1\frac{1}{2}$ — 6 UNC	1.319 9	1.319 6	1.350 5	1.350 2	1.339 9	1.339 6
$1\frac{3}{4}$ — 5 UNC	1.533 9	1.533 5	1.567 9	1.567 5	1.557 9	1.557 5
2 — $4\frac{1}{2}$ UNC	1.759 8	1.759 4	1.795 6	1.795 2	1.786 5	1.786 1
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.009 8	2.009 4	2.045 6	2.045 2	2.036 5	2.036 1
$2\frac{1}{2}$ — 4 UNC	2.229 8	2.229 4	2.267 3	2.266 9	2.259 8	2.259 4
$2\frac{3}{4}$ — 4 UNC	2.479 8	2.479 4	2.517 3	2.516 9	2.509 8	2.509 4
3 — 4 UNC	2.729 8	2.729 4	2.767 3	2.766 9	2.759 8	2.759 4
$3\frac{1}{4}$ — 4 UNC	2.979 9	2.979 4	3.017 4	3.016 9	3.009 9	3.009 4
$3\frac{1}{2}$ — 4 UNC	3.229 9	3.229 4	3.267 4	3.266 9	3.259 9	3.259 4
$3\frac{3}{4}$ — 4 UNC	3.479 9	3.479 4	3.517 4	3.516 9	3.509 9	3.509 4
4 — 4 UNC	3.729 9	3.729 4	3.767 4	3.766 9	3.759 9	3.759 4

Table 6 **Limits of size for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.194 2	0.194 8	0.215 8	0.216 4	0.195 3	0.195 9	0.216 9	0.217 5
$\frac{5}{16}$ — 18 UNC	0.250 6	0.251 2	0.274 6	0.275 2	0.251 8	0.252 4	0.275 8	0.276 4
$\frac{3}{8}$ — 16 UNC	0.305 4	0.306 0	0.332 5	0.333 1	0.306 7	0.307 3	0.333 8	0.334 4
$\frac{7}{16}$ — 14UNC	0.358 2	0.358 8	0.389 1	0.389 7	0.359 6	0.360 2	0.390 5	0.391 1
$\frac{1}{2}$ — 13 UNC	0.414 6	0.415 2	0.447 9	0.448 5	0.416 1	0.416 7	0.449 4	0.450 0
$\frac{9}{16}$ — 12 UNC	0.470 0	0.470 7	0.506 0	0.506 8	0.471 6	0.472 3	0.507 6	0.508 4
$\frac{5}{8}$ — 11 UNC	0.524 3	0.525 0	0.563 6	0.564 4	0.525 9	0.526 6	0.565 2	0.566 0
$\frac{3}{4}$ — 10 UNC	0.639 2	0.639 9	0.682 4	0.683 2	0.641 0	0.641 7	0.684 2	0.685 0
$\frac{7}{8}$ — 9 UNC	0.752 1	0.752 8	0.800 1	0.800 9	0.754 0	0.754 7	0.802 0	0.802 8
1 — 8 UNC	0.862 0	0.862 7	0.916 0	0.916 8	0.864 0	0.864 7	0.918 0	0.918 8
$1\frac{1}{8}$ — 7 UNC	0.967 5	0.968 2	1.029 2	1.030 0	0.969 7	0.970 4	1.031 4	1.032 2
$1\frac{1}{4}$ — 7 UNC	1.092 5	1.093 2	1.154 2	1.155 0	1.094 7	1.095 4	1.156 4	1.157 2
$1\frac{3}{8}$ — 6 UNC	1.191 5	1.192 2	1.263 5	1.264 3	1.193 9	1.194 6	1.265 9	1.266 7
$1\frac{1}{2}$ — 6 UNC	1.316 5	1.317 2	1.388 5	1.389 3	1.318 9	1.319 6	1.390 9	1.391 7
$1\frac{3}{4}$ — 5 UNC	1.530 0	1.530 8	1.616 4	1.617 4	1.532 7	1.533 5	1.619 1	1.620 1
2 — $4\frac{1}{2}$ UNC	1.755 7	1.756 5	1.851 8	1.852 8	1.758 6	1.759 4	1.854 7	1.855 7
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.005 7	2.006 5	2.101 8	2.102 8	2.008 6	2.009 4	2.104 7	2.105 7
$2\frac{1}{2}$ — 4 UNC	2.225 5	2.226 3	2.333 5	2.334 5	2.228 6	2.229 4	2.336 6	2.337 6
$2\frac{3}{4}$ — 4 UNC	2.475 4	2.476 2	2.583 4	2.584 4	2.478 6	2.479 4	2.586 6	2.587 6
3 — 4 UNC	2.725 4	2.726 2	2.833 4	2.834 4	2.728 6	2.729 4	2.836 6	2.837 6
$3\frac{1}{4}$ — 4 UNC	2.975 2	2.976 1	3.083 1	3.084 3	2.978 5	2.979 4	3.086 4	3.087 6
$3\frac{1}{2}$ — 4 UNC	3.225 2	3.226 1	3.333 1	3.334 3	3.228 5	3.229 4	3.336 4	3.337 6
$3\frac{3}{4}$ — 4 UNC	3.475 1	3.476 0	3.583 0	3.584 2	3.478 5	3.479 4	3.586 4	3.587 6
4 — 4 UNC	3.725 1	3.726 0	3.833 0	3.834 2	3.728 5	3.729 4	3.836 4	3.837 6

Table 7 **Limits of size for NOT GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.200 0	0.200 6	0.210 3	0.210 8	0.201 9	0.202 5	0.212 2	0.212 7	0.203 9	0.204 5	0.214 2	0.214 7
$\frac{5}{16}$ — 18 UNC	0.257 1	0.257 7	0.268 6	0.269 1	0.259 2	0.259 8	0.270 7	0.271 2	0.261 4	0.262 0	0.272 9	0.273 4
$\frac{3}{8}$ — 16 UNC	0.313 1	0.313 7	0.326 1	0.326 6	0.315 2	0.315 8	0.328 2	0.328 7	0.317 6	0.318 2	0.330 6	0.331 1
$\frac{7}{16}$ — 14 UNC	0.367 1	0.367 7	0.382 1	0.382 6	0.369 5	0.370 1	0.384 5	0.385 0	0.372 1	0.372 7	0.387 1	0.387 6
$\frac{1}{2}$ — 13 UNC	0.424 5	0.425 1	0.440 6	0.441 1	0.426 9	0.427 5	0.443 0	0.443 5	0.429 7	0.430 3	0.445 8	0.446 3
$\frac{9}{16}$ — 12 UNC	0.481 0	0.481 7	0.498 4	0.499 0	0.483 6	0.434 3	0.501 0	0.501 6	0.486 5	0.487 2	0.503 9	0.504 5
$\frac{5}{8}$ — 11 UNC	0.536 4	0.537 1	0.555 5	0.556 1	0.539 2	0.539 9	0.558 3	0.558 9	0.542 2	0.542 9	0.561 3	0.561 9
$\frac{3}{4}$ — 10 UNC	0.652 8	0.653 5	0.673 8	0.674 4	0.655 7	0.656 4	0.676 7	0.677 3	0.659 0	0.659 7	0.680 0	0.680 6
$\frac{7}{8}$ — 9 UNC	0.767 3	0.768 0	0.709 8	0.791 4	0.770 5	0.771 2	0.794 0	0.794 6	0.774 0	0.774 7	0.797 5	0.798 1
1 — 8 UNC	0.879 6	0.880 3	0.906 1	0.906 7	0.882 9	0.883 6	0.909 4	0.910 0	0.886 6	0.887 3	0.913 1	0.913 7
$1\frac{1}{8}$ — 7 UNC	0.988 2	0.988 9	1.018 5	1.019 1	0.991 9	0.992 6	1.022 2	1.022 8	0.995 9	0.996 6	1.026 2	1.026 8
$1\frac{1}{4}$ — 7 UNC	1.113 0	1.113 7	1.143 3	1.143 9	1.116 7	1.117 4	1.147 0	1.147 6	1.120 8	1.121 5	1.151 1	1.151 7
$1\frac{3}{8}$ — 6 UNC	1.216 2	1.216 9	1.251 7	1.252 3	1.220 2	1.220 9	1.255 7	1.256 3	1.224 6	1.225 3	1.260 1	1.260 7
$1\frac{1}{2}$ — 6 UNC	1.341 1	1.341 8	1.376 6	1.377 2	1.345 1	1.345 8	1.380 6	1.381 2	1.349 5	1.350 2	1.385 0	1.385 6
$1\frac{3}{4}$ — 5 UNC	1.560 7	1.561 5	1.603 2	1.604 0	1.565 2	1.566 0	1.607 7	1.608 5	1.570 1	1.570 9	1.612 6	1.613 4
2 — $4\frac{1}{2}$ UNC	1.790 4	1.791 2	1.837 7	1.838 5	1.795 2	1.796 0	1.842 5	1.843 3	1.800 5	1.801 3	1.847 8	1.848 6
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.040 1	2.040 9	2.087 4	2.088 2	2.045 0	2.045 8	2.092 3	2.093 1	2.050 3	2.051 1	2.097 6	2.098 4
$2\frac{1}{2}$ — 4 UNC	2.264 9	2.265 7	2.318 2	2.319 0	2.270 0	2.270 8	2.323 3	2.324 1	2.275 7	2.276 5	2.329 0	2.329 8
$2\frac{3}{4}$ — 4 UNC	2.514 5	2.515 3	2.567 8	2.568 6	2.519 8	2.520 6	2.573 1	2.573 9	2.525 6	2.526 4	2.578 9	2.579 7
3 — 4 UNC	2.764 2	2.765 0	2.817 5	2.818 3	2.769 6	2.770 4	2.822 9	2.823 7	2.775 5	2.776 3	2.828 8	2.829 6
$3\frac{1}{4}$ — 4 UNC	3.013 9	3.014 8	3.067 1	3.068 0	3.019 3	3.020 2	3.072 5	3.073 4	3.025 3	3.026 2	3.078 5	3.079 4
$3\frac{1}{2}$ — 4 UNC	3.263 6	3.264 5	3.316 8	3.317 7	3.269 2	3.270 1	3.322 4	3.323 3	3.275 2	3.276 1	3.328 4	3.329 3
$3\frac{3}{4}$ — 4 UNC	3.513 3	3.514 2	3.566 5	3.567 4	3.518 9	3.519 8	3.572 1	3.573 0	3.525 1	3.526 0	3.578 3	3.579 2
4 — 4 UNC	3.763 1	3.764 0	3.816 3	3.817 2	3.768 8	3.769 7	3.822 0	3.822 9	3.775 0	3.775 9	3.828 2	3.829 1

Table 8 **Limits of size for GO screw check plugs for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Minor diameter[A)]		**Effective diameter**		**Minor diameter**[A)]		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.215 8	0.215 5	0.248 3	0.248 0	0.216 9	0.216 6	0.249 4	0.249 1
$\frac{5}{16}$ — 18 UNC	0.274 6	0.274 3	0.310 7	0.310 4	0.275 8	0.275 5	0.311 9	0.311 6
$\frac{3}{8}$ — 16 UNC	0.332 5	0.332 2	0.373 1	0.372 8	0.333 8	0.333 5	0.374 4	0.374 1
$\frac{7}{16}$ — 14 UNC	0.389 1	0.388 8	0.435 5	0.435 2	0.390 5	0.390 2	0.436 9	0.436 6
$\frac{1}{2}$ — 13 UNC	0.447 9	0.447 6	0.497 9	0.497 6	0.449 4	0.449 1	0.499 4	0.499 1
$\frac{9}{16}$ — 12 UNC	0.506 0	0.505 6	0.560 1	0.559 7	0.507 6	0.507 2	0.561 7	0.561 3
$\frac{5}{8}$ — 11 UNC	0.563 6	0.563 2	0.622 6	0.622 2	0.565 2	0.564 8	0.624 2	0.623 8
$\frac{3}{4}$ — 10 UNC	0.682 4	0.682 0	0.747 4	0.747 0	0.684 2	0.683 8	0.749 2	0.748 8
$\frac{7}{8}$ — 9 UNC	0.800 1	0.799 7	0.872 3	0.871 9	0.802 0	0.801 6	0.874 2	0.873 8
1 — 8 UNC	0.916 0	0.915 6	0.997 2	0.996 8	0.918 0	0.917 6	0.999 2	0.998 8
$1\frac{1}{8}$ — 7 UNC	1.029 2	1.028 8	1.122 0	1.121 6	1.031 4	1.031 0	1.124 2	1.123 8
$1\frac{1}{4}$ — 7 UNC	1.154 2	1.153 8	1.247 0	1.246 6	1.156 4	1.156 0	1.249 2	1.248 8
$1\frac{3}{8}$ — 6 UNC	1.263 5	1.263 1	1.371 8	1.371 4	1.265 9	1.265 5	1.374 2	1.373 8
$1\frac{1}{2}$ — 6 UNC	1.388 5	1.388 1	1.496 8	1.496 4	1.390 9	1.390 5	1.499 2	1.498 8
$1\frac{3}{4}$ — 5 UNC	1.616 4	1.615 9	1.746 3	1.745 8	1.619 1	1.618 6	1.749 0	1.748 5
2 — $4\frac{1}{2}$ UNC	1.851 8	1.851 3	1.996 1	1.995 6	1.854 7	1.854 2	1.999 0	1.998 5
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.101 8	2.101 3	2.246 1	2.245 6	2.104 7	2.104 2	2.249 0	2.248 5
$2\frac{1}{2}$ — 4 UNC	2.333 5	2.333 0	2.495 9	2.495 4	2.336 6	2.336 1	2.499 0	2.498 5
$2\frac{3}{4}$ — 4 UNC	2.583 4	2.582 9	2.745 8	2.745 3	2.586 6	2.586 1	2.749 0	2.748 5
3 — 4 UNC	2.833 4	2.832 9	2.995 8	2.995 3	2.836 6	2.836 1	2.999 0	2.998 5

A) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 9 **Limits of size for NOT GO effective diameter check plugs for new GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Effective diameter[A]		**Major diameter**		**Effective diameter**[A]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.216 6	0.216 4	0.227 2	0.226 9	0.217 7	0.217 5	0.228 3	0.228 0
$\frac{5}{16}$ — 18 UNC	0.275 4	0.275 2	0.287 2	0.286 9	0.276 6	0.276 4	0.288 4	0.288 1
$\frac{3}{8}$ — 16 UNC	0.333 3	0.333 1	0.346 6	0.346 3	0.334 6	0.334 4	0.347 9	0.347 6
$\frac{7}{16}$ — 14UNC	0.389 9	0.389 7	0.405 2	0.404 9	0.391 3	0.391 1	0.406 6	0.406 3
$\frac{1}{2}$ — 13 UNC	0.448 7	0.448 5	0.465 1	0.464 8	0.450 2	0.450 0	0.466 6	0.466 3
$\frac{9}{16}$ — 12 UNC	0.507 1	0.506 8	0.524 8	0.524 4	0.508 7	0.508 4	0.526 4	0.526 0
$\frac{5}{8}$ — 11 UNC	0.564 7	0.564 4	0.584 1	0.583 7	0.566 3	0.566 0	0.585 7	0.585 3
$\frac{3}{4}$ — 10 UNC	0.683 5	0.683 2	0.704 9	0.704 5	0.685 3	0.685 0	0.706 7	0.706 3
$\frac{7}{8}$ — 9 UNC	0.801 2	0.800 9	0.825 0	0.824 6	0.803 1	0.802 8	0.826 9	0.826 5
1 — 8 UNC	0.917 1	0.916 8	0.943 9	0.943 5	0.919 1	0.918 8	0.945 9	0.945 5
$1\frac{1}{8}$ — 7 UNC	1.030 3	1.030 0	1.060 9	1.060 5	1.032 5	1.032 2	1.063 1	1.062 7
$1\frac{1}{4}$ — 7 UNC	1.155 3	1.155 0	1.185 9	1.185 5	1.157 5	1.157 2	1.188 1	1.187 7
$1\frac{3}{8}$ — 6 UNC	1.264 6	1.264 3	1.300 4	1.300 0	1.267 0	1.266 7	1.302 8	1.302 4
$1\frac{1}{2}$ — 6 UNC	1.389 6	1.389 3	1.425 4	1.425 0	1.392 0	1.391 7	1.427 8	1.427 4
$1\frac{3}{4}$ — 5 UNC	1.617 8	1.617 4	1.660 7	1.660 2	1.620 5	1.620 1	1.663 4	1.662 9
2 — $4\frac{1}{2}$ UNC	1.853 2	1.852 8	1.900 9	1.900 4	1.856 1	1.855 7	1.903 8	1.903 3
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.103 2	2.102 8	2.150 9	2.150 4	2.106 1	2.105 7	2.153 8	2.153 3
$2\frac{1}{2}$ — 4 UNC	2.334 9	2.334 5	2.388 6	2.388 1	2.338 0	2.337 6	2.391 7	2.391 2
$2\frac{3}{4}$ — 4 UNC	2.584 8	2.584 4	2.638 5	2.638 0	2.588 0	2.587 6	2.641 7	2.641 2
3 — 4 UNC	2.834 8	2.834 4	2.888 5	2.888 0	2.838 0	2.837 6	2.891 7	2.891 2

[A] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 10 **Limits of size for NOT GO effective diameter check plugs for worn GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Effective diameter[A)]		**Major diameter**		**Effective diameter**[A)]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.216 8	0.216 6	0.227 2	0.226 9	0.217 9	0.217 7	0.228 3	0.228 0
$\frac{5}{16}$ — 18 UNC	0.275 6	0.275 4	0.287 2	0.286 9	0.276 8	0.276 6	0.288 4	0.288 1
$\frac{3}{8}$ — 16 UNC	0.333 5	0.333 3	0.346 6	0.346 3	0.334 8	0.334 6	0.347 9	0.347 6
$\frac{7}{16}$ — 14 UNC	0.390 1	0.389 9	0.405 2	0.404 9	0.391 5	0.391 3	0.406 6	0.406 3
$\frac{1}{2}$ — 13 UNC	0.448 9	0.448 7	0.465 1	0.464 8	0.450 4	0.450 2	0.466 6	0.466 3
$\frac{9}{16}$ — 12 UNC	0.507 4	0.507 1	0.524 8	0.524 4	0.509 0	0.508 7	0.526 4	0.526 0
$\frac{5}{8}$ — 11 UNC	0.565 0	0.564 7	0.584 1	0.583 7	0.566 6	0.566 3	0.585 7	0.585 3
$\frac{3}{4}$ — 10 UNC	0.683 8	0.683 5	0.704 9	0.704 5	0.685 6	0.685 3	0.706 7	0.706 3
$\frac{7}{8}$ — 9 UNC	0.801 5	0.801 2	0.825 0	0.804 6	0.803 4	0.803 1	0.826 9	0.826 5
1 — 8 UNC	0.917 4	0.917 1	0.943 9	0.943 5	0.919 4	0.919 1	0.945 9	0.945 5
$1\frac{1}{8}$ — 7 UNC	1.030 6	1.030 3	1.060 9	1.060 5	1.032 8	1.032 5	1.063 1	1.062 7
$1\frac{1}{4}$ — 7 UNC	1.155 6	1.155 3	1.185 9	1.185 5	1.157 8	1.157 5	1.188 1	1.187 7
$1\frac{3}{8}$ — 6 UNC	1.264 9	1.264 6	1.300 4	1.300 0	1.267 3	1.267 0	1.302 8	1.302 4
$1\frac{1}{2}$ — 6 UNC	1.389 9	1.389 6	1.425 4	1.425 0	1.392 3	1.392 0	1.427 8	1.427 4
$1\frac{3}{4}$ — 5 UNC	1.618 2	1.617 8	1.660 7	1.660 2	1.620 9	1.620 5	1.663 4	1.662 9
2 — $4\frac{1}{2}$ UNC	1.853 6	1.853 2	1.900 9	1.900 4	1.856 5	1.856 1	1.903 8	1.903 3
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.103 6	2.103 2	2.150 9	2.150 4	2.106 5	2.106 1	2.153 8	2.153 3
$2\frac{1}{2}$ — 4 UNC	2.335 3	2.334 9	2.388 6	2.388 1	2.338 4	2.338 0	2.391 7	2.391 2
$2\frac{3}{4}$ — 4 UNC	2.585 2	2.584 8	2.638 5	2.638 0	2.588 4	2.588 0	2.641 7	2.641 2
3 — 4 UNC	2.835 2	2.834 8	2.888 5	2.888 0	2.838 4	2.838 0	2.891 7	2.891 2

A) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 11 **Limits of size for GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Effective diameter[A)]		**Major diameter**		**Effective diameter[A)]**		**Major diameter**		**Effective diameter[A)]**		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.210 3	0.210 0	0.248 6	0.248 3	0.212 2	0.211 9	0.249 2	0.248 9	0.214 2	0.213 9	0.250 3	0.250 0
$\frac{5}{16}$ — 18 UNC	0.268 6	0.268 3	0.311 1	0.310 8	0.270 7	0.270 4	0.311 6	0.311 3	0.272 9	0.272 6	0.312 8	0.312 5
$\frac{3}{8}$ — 16 UNC	0.326 1	0.325 8	0.373 8	0.353 5	0.328 2	0.327 9	0.374 0	0.373 7	0.330 6	0.330 3	0.375 3	0.375 0
$\frac{7}{16}$ — 14 UNC	0.382 1	0.381 8	0.436 4	0.436 1	0.384 5	0.384 2	0.436 4	0.436 1	0.387 1	0.386 8	0.437 8	0.437 5
$\frac{1}{2}$ — 13 UNC	0.440 6	0.440 3	0.498 8	0.498 5	0.443 0	0.442 7	0.498 8	0.498 5	0.445 8	0.445 5	0.500 3	0.500 0
$\frac{9}{16}$ — 12 UNC	0.498 4	0.498 0	0.561 3	0.560 9	0.501 0	0.500 6	0.561 3	0.560 9	0.503 9	0.503 5	0.562 9	0.562 5
$\frac{5}{8}$ — 11 UNC	0.555 5	0.555 1	0.623 8	0.623 4	0.558 3	0.557 9	0.623 8	0.623 4	0.561 3	0.560 9	0.625 4	0.625 0
$\frac{3}{4}$ — 10 UNC	0.673 8	0.673 4	0.748 6	0.748 2	0.676 7	0.676 3	0.748 6	0.748 2	0.680 0	0.679 6	0.750 4	0.750 0
$\frac{7}{8}$ — 9 UNC	0.790 8	0.790 4	0.873 5	0.873 1	0.794 0	0.793 6	0.873 5	0.873 1	0.787 5	0.787 1	0.875 4	0.875 0
1 — 8 UNC	0.906 1	0.905 7	0.998 4	0.998 0	0.909 4	0.909 0	0.998 4	0.998 0	0.913 1	0.912 7	1.000 4	1.000 0
$1\frac{1}{8}$ — 7 UNC	1.018 5	1.018 1	1.123 2	1.122 8	1.022 2	1.021 8	1.123 2	1.122 8	1.026 2	1.025 8	1.125 4	1.125 0
$1\frac{1}{4}$ —7 UNC	1.143 3	1.142 9	1.248 2	1.247 8	1.147 0	1.146 6	1.248 2	1.247 8	1.151 1	1.150 7	1.250 4	1.250 0
$1\frac{3}{8}$ — 6 UNC	1.251 7	1.251 3	1.373 0	1.372 6	1.255 7	1.255 3	1.373 0	1.372 6	1.260 1	1.259 7	1.375 4	1.375 0
$1\frac{1}{2}$ — 6 UNC	1.376 6	1.376 2	1.498 0	1.497 6	1.380 6	1.380 2	1.498 0	1.497 6	1.385 0	1.384 6	1.500 4	1.500 0
$1\frac{3}{4}$ — 5 UNC	1.603 2	1.602 7	1.747 8	1.747 3	1.607 7	1.607 2	1.747 8	1.747 3	1.612 6	1.612 1	1.750 5	1.750 0
2 — $4\frac{1}{2}$ UNC	1.837 7	1.837 2	1.997 6	1.997 1	1.842 5	1.842 0	1.997 6	1.997 1	1.847 8	1.847 3	2.000 5	2.000 0
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.087 4	2.086 9	2.247 6	2.247 1	2.092 3	2.091 8	2.247 6	2.247 1	2.097 6	2.097 1	2.250 5	2.250 0
$2\frac{1}{2}$ — 4 UNC	2.318 2	2.317 7	2.497 4	2.496 9	2.323 3	2.322 8	2.497 4	2.496 9	2.329 0	2.328 5	2.500 5	2.500 0
$2\frac{3}{4}$ — 4 UNC	2.567 8	2.567 3	2.747 3	2.746 8	2.573 1	2.572 6	2.747 3	2.746 8	2.578 9	2.578 4	2.750 5	2.750 0
3 — 4 UNC	2.817 5	2.817 0	2.997 3	2.996 8	2.822 9	2.822 4	2.997 3	2.996 8	2.828 8	2.828 3	3.000 5	3.000 0

[A)] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 12 **Limits of size for NOT GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Effective diameter[A)]		**Major diameter**		**Effective diameter[A)]**		**Major diameter**		**Effective diameter[A)]**		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.211 0	0.210 8	0.221 6	0.221 3	0.212 9	0.212 7	0.223 5	0.223 2	0.214 9	0.214 7	0.225 5	0.225 2
$\frac{5}{16}$ — 18 UNC	0.269 3	0.269 1	0.281 1	0.280 8	0.271 4	0.271 2	0.283 2	0.282 9	0.273 6	0.273 4	0.285 4	0.285 1
$\frac{3}{8}$ — 16 UNC	0.326 8	0.326 6	0.340 1	0.339 8	0.328 9	0.328 7	0.342 2	0.341 9	0.331 3	0.331 1	0.344 6	0.344 3
$\frac{7}{16}$ — 14 UNC	0.382 8	0.382 6	0.398 1	0.397 8	0.385 2	0.385 0	0.400 5	0.400 2	0.387 8	0.387 6	0.403 1	0.402 8
$\frac{1}{2}$ — 13 UNC	0.441 3	0.441 1	0.457 7	0.457 4	0.443 7	0.443 5	0.460 1	0.459 8	0.446 5	0.446 3	0.462 9	0.462 8
$\frac{9}{16}$ — 12 UNC	0.499 3	0.499 0	0.517 0	0.516 6	0.501 9	0.501 6	0.519 6	0.519 2	0.504 8	0.504 5	0.522 5	0.522 1
$\frac{5}{8}$ — 11 UNC	0.556 4	0.556 1	0.575 8	0.575 4	0.559 2	0.558 9	0.578 6	0.578 2	0.562 2	0.561 9	0.581 6	0.581 2
$\frac{3}{4}$ — 10 UNC	0.674 7	0.674 4	0.696 1	0.695 7	0.677 6	0.677 3	0.699 0	0.698 6	0.680 9	0.680 6	0.702 3	0.701 9
$\frac{7}{8}$ — 9 UNC	0.791 7	0.791 4	0.815 5	0.815 1	0.794 9	0.794 6	0.818 7	0.818 3	0.798 4	0.798 1	0.822 2	0.821 8
1 — 8 UNC	0.907 0	0.906 7	0.933 8	0.933 4	0.910 3	0.910 0	0.937 1	0.936 7	0.914 0	0.913 7	0.940 8	0.940 4
$1\frac{1}{8}$ — 7 UNC	1.019 4	1.019 1	1.050 0	1.049 6	1.023 1	1.022 8	1.053 7	1.053 3	1.027 1	1.026 8	1.057 7	1.057 3
$1\frac{1}{4}$ — 7 UNC	1.144 2	1.143 9	1.174 8	1.174 4	1.147 9	1.147 6	1.178 5	1.178 1	1.152 0	1.151 7	1.182 6	1.182 2
$1\frac{3}{8}$ — 6 UNC	1.252 6	1.252 3	1.288 4	1.288 0	1.256 6	1.256 3	1.292 4	1.292 0	1.261 0	1.260 7	1.296 8	1.296 4
$1\frac{1}{2}$ — 6 UNC	1.377 5	1.377 2	1.413 3	1.412 9	1.381 5	1.381 2	1.417 3	1.416 9	1.385 9	1.385 6	1.421 7	1.421 3
$1\frac{3}{4}$ — 5 UNC	1.604 4	1.604 0	1.647 3	1.646 8	1.608 9	1.608 5	1.651 8	1.651 3	1.613 8	1.613 4	1.656 7	1.656 2
2 — $4\frac{1}{2}$ UNC	1.838 9	1.838 5	1.886 6	1.886 1	1.843 7	1.843 3	1.891 4	1.890 9	1.849 0	1.848 6	1.896 7	1.896 2
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.088 6	2.088 2	2.136 3	2.135 8	2.093 5	2.093 1	2.141 2	2.140 7	2.098 8	2.098 4	2.146 5	2.146 0
$2\frac{1}{2}$ — 4 UNC	2.319 4	2.319 0	2.373 1	2.372 6	2.324 5	2.324 1	2.378 2	2.377 7	2.330 2	2.329 8	2.383 9	2.383 4
$2\frac{3}{4}$ — 4 UNC	2.569 0	2.568 6	2.622 7	2.622 2	2.574 3	2.573 9	2.628 0	2.627 5	2.580 1	2.579 7	2.633 8	2.633 3
3 — 4 UNC	2.818 7	2.818 3	2.872 4	2.871 9	2.824 1	2.823 7	2.877 8	2.877 3	2.830 0	2.829 6	2.883 7	2.883 3

[A)] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 13 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**GO check plugs**				**NOT GO check plugs**			
	Classes 1A and 2A threads		**Class 3A threads**		**Classes 1A and 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.194 2	0.194 1	0.195 3	0.195 2	0.194 9	0.194 8	0.196 0	0.195 9
$\frac{5}{16}$ — 18 UNC	0.250 6	0.250 5	0.251 8	0.251 7	0.251 3	0.251 2	0.252 5	0.252 4
$\frac{3}{8}$ — 16 UNC	0.305 4	0.305 3	0.306 7	0.306 6	0.306 1	0.306 0	0.307 4	0.307 3
$\frac{7}{16}$ — 14 UNC	0.358 2	0.358 1	0.359 6	0.359 5	0.358 9	0.358 8	0.360 3	0.360 2
$\frac{1}{2}$ — 13 UNC	0.414 6	0.414 5	0.416 1	0.416 0	0.415 3	0.415 2	0.416 8	0.416 7
$\frac{9}{16}$ — 12 UNC	0.470 0	0.469 9	0.471 6	0.471 5	0.470 8	0.470 7	0.472 4	0.472 3
$\frac{5}{8}$ — 11 UNC	0.524 3	0.524 2	0.525 9	0.525 8	0.525 1	0.525 0	0.526 7	0.526 6
$\frac{3}{4}$ — 10 UNC	0.639 2	0.639 1	0.641 0	0.640 9	0.640 0	0.639 9	0.641 8	0.641 7
$\frac{7}{8}$ — 9 UNC	0.752 1	0.752 0	0.754 0	0.753 9	0.753 9	0.752 8	0.754 8	0.754 7
1 — 8 UNC	0.862 0	0.861 9	0.864 0	0.863 9	0.862 8	0.862 7	0.864 8	0.864 7
$1\frac{1}{8}$ — 7 UNC	0.967 5	0.967 4	0.969 7	0.969 6	0.968 3	0.968 2	0.970 5	0.970 4
$1\frac{1}{4}$ — 7 UNC	1.092 5	1.092 4	1.094 7	1.094 6	1.093 3	1.093 2	1.095 5	1.095 4
$1\frac{3}{8}$ — 6 UNC	1.191 5	1.191 4	1.193 9	1.193 8	1.192 3	1.192 2	1.194 7	1.194 6
$1\frac{1}{2}$ — 6 UNC	1.316 5	1.316 4	1.318 9	1.318 8	1.317 3	1.317 2	1.319 7	1.319 6
$1\frac{3}{4}$ — 5 UNC	1.530 0	1.529 8	1.532 7	1.532 5	1.531 0	1.530 8	1.533 7	1.533 5
2 — $4\frac{1}{2}$ UNC	1.755 7	1.755 5	1.758 6	1.758 4	1.756 7	1.756 5	1.759 6	1.759 4
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.005 7	2.005 5	2.008 6	2.008 4	2.006 7	2.006 5	2.009 6	2.009 4
$2\frac{1}{2}$ — 4 UNC	2.225 5	2.225 3	2.228 6	2.228 4	2.226 5	2.226 3	2.229 6	2.229 4
$2\frac{3}{4}$ — 4 UNC	2.475 4	2.475 2	2.478 6	2.478 4	2.476 4	2.476 2	2.479 6	2.479 4
3 — 4 UNC	2.725 4	2.725 2	2.728 6	2.728 4	2.726 4	2.726 2	2.729 6	2.729 4

Table 14 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**GO check plugs**						**NOT GO check plugs**					
	Class 1A threads		**Class 2A threads**		**Class 3A threads**		**Class 1A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.200 0	0.199 9	0.201 9	0.201 8	0.203 9	0.203 8	0.200 7	0.200 6	0.202 6	0.202 5	0.204 6	0.204 5
$\frac{5}{16}$ — 18 UNC	0.257 1	0.257 0	0.259 2	0.259 1	0.261 4	0.261 3	0.257 8	0.257 7	0.259 9	0.259 8	0.262 1	0.262 0
$\frac{3}{8}$ — 16 UNC	0.313 1	0.313 0	0.315 2	0.315 1	0.317 6	0.317 5	0.313 8	0.313 7	0.315 9	0.315 8	0.318 3	0.318 2
$\frac{7}{16}$ — 14 UNC	0.367 1	0.367 0	0.369 5	0.369 4	0.372 1	0.372 0	0.367 8	0.367 7	0.370 2	0.370 1	0.372 8	0.372 7
$\frac{1}{2}$ — 13 UNC	0.424 5	0.424 4	0.426 9	0.426 8	0.429 7	0.429 6	0.425 2	0.425 1	0.427 6	0.427 5	0.430 4	0.430 3
$\frac{9}{16}$ — 12 UNC	0.481 0	0.480 9	0.483 6	0.483 5	0.486 5	0.486 4	0.481 8	0.481 7	0.434 4	0.434 3	0.487 3	0.487 2
$\frac{5}{8}$ — 11 UNC	0.536 4	0.536 3	0.539 2	0.539 1	0.542 2	0.542 1	0.537 2	0.537 1	0.540 0	0.539 9	0.543 0	0.542 9
$\frac{3}{4}$ — 10 UNC	0.652 8	0.652 7	0.655 7	0.655 6	0.659 0	0.658 9	0.653 6	0.653 5	0.656 5	0.656 4	0.659 8	0.659 7
$\frac{7}{8}$ — 9 UNC	0.767 3	0.767 2	0.770 5	0.770 4	0.774 0	0.773 9	0.768 1	0.768 0	0.771 3	0.771 2	0.774 8	0.774 7
1 — 8 UNC	0.879 6	0.879 5	0.882 9	0.882 8	0.886 6	0.886 5	0.880 4	0.880 3	0.883 7	0.883 6	0.887 4	0.887 3
$1\frac{1}{8}$ — 7 UNC	0.988 2	0.988 1	0.991 9	0.991 8	0.995 9	0.995 8	0.989 0	0.988 9	0.992 7	0.992 6	0.996 7	0.996 6
$1\frac{1}{4}$ — 7 UNC	1.113 0	1.112 9	1.116 7	1.116 6	1.120 8	1.120 7	1.113 8	1.113 7	1.117 5	1.117 4	1.121 6	1.121 5
$1\frac{3}{8}$ — 6 UNC	1.216 2	1.216 1	1.220 2	1.220 1	1.224 6	1.224 5	1.217 0	1.216 9	1.221 0	1.220 9	1.225 4	1.225 3
$1\frac{1}{2}$ — 6 UNC	1.341 1	1.341 0	1.345 1	1.345 0	1.349 5	1.349 4	1.341 9	1.341 8	1.345 9	1.345 8	1.350 3	1.350 2
$1\frac{3}{4}$ — 5 UNC	1.560 7	1.560 5	1.565 2	1.565 0	1.570 1	1.569 9	1.561 7	1.561 5	1.566 2	1.566 0	1.571 1	1.570 9
2 — $4\frac{1}{2}$ UNC	1.790 4	1.790 2	1.795 2	1.795 0	1.800 5	1.800 3	1.791 4	1.791 2	1.796 2	1.796 0	1.801 5	1.801 3
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.040 1	2.039 9	2.045 0	2.044 8	2.050 3	2.050 1	2.041 1	2.040 9	2.046 0	2.045 8	2.051 3	2.051 1
$2\frac{1}{2}$ — 4 UNC	2.264 9	2.264 7	2.270 0	2.269 8	2.275 7	2.275 5	2.265 9	2.265 7	2.271 0	2.270 8	2.276 7	2.276 5
$2\frac{3}{4}$ — 4 UNC	2.514 5	2.514 3	2.519 8	2.519 6	2.525 6	2.525 4	2.515 5	2.515 3	2.520 8	2.520 6	2.526 6	2.526 4
3 — 4 UNC	2.764 2	2.764 0	2.769 6	2.769 4	2.775 5	2.775 3	2.765 2	2.765 0	2.770 6	2.770 4	2.776 5	2.776 3

Table 15 **Limits of size for adjustable GO screw ring and calliper gauges**

1	2	3	4	5	6
Designation	**Minor diameter**				**Effective diameter**
	Classes 1A and 2A threads		**Classes 3A threads**		**All classes of thread**
	Max.	**Min.**	**Max.**	**Min.**	
	in	in	in	in	Since adjustable GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 17 and Table 21 respectively, no limits are given for the effective diameters of the gauges.
$\frac{1}{4}$ — 20 UNC	0.194 3	0.194 8	0.195 4	0.195 9	
$\frac{5}{16}$ — 18 UNC	0.250 7	0.251 2	0.251 9	0.252 4	
$\frac{3}{8}$ — 16 UNC	0.305 4	0.306 0	0.306 7	0.307 3	
$\frac{7}{16}$ — 14 UNC	0.358 2	0.358 8	0.359 6	0.360 2	
$\frac{1}{2}$ — 13 UNC	0.414 6	0.415 2	0.416 1	0.416 7	
$\frac{9}{16}$ — 12 UNC	0.470 1	0.470 7	0.471 7	0.472 3	
$\frac{5}{8}$ — 11 UNC	0.524 4	0.525 0	0.526 0	0.526 6	
$\frac{3}{4}$ — 10 UNC	0.639 3	0.639 9	0.641 1	0.641 7	
$\frac{7}{8}$ — 9 UNC	0.752 1	0.752 8	0.754 0	0.754 7	
1 — 8 UNC	0.862 0	0.862 7	0.864 0	0.864 7	
$1\frac{1}{8}$ — 7 UNC	0.967 5	0.968 2	0.069 7	0.970 4	
$1\frac{1}{4}$ — 7 UNC	1.092 5	1.093 2	1.094 7	1.095 4	
$1\frac{3}{8}$ — 6 UNC	1.191 4	1.192 2	1.193 8	1.194 6	
$1\frac{1}{2}$ — 6 UNC	1.316 4	1.317 2	1.318 8	1.319 6	
$1\frac{3}{4}$ — 5 UNC	1.530 0	1.530 8	1.532 7	1.533 5	
2 — $4\frac{1}{2}$ UNC	1.755 7	1.756 5	1.758 6	1.759 4	
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.005 7	2.006 5	2.008 6	2.009 4	
$2\frac{1}{2}$ — 4 UNC	2.225 4	2.226 3	2.228 5	2.229 4	
$2\frac{3}{4}$ — 4 UNC	2.475 3	2.476 2	2.478 5	2.479 4	
3 — 4 UNC	2.725 3	2.726 2	2.728 5	2.729 4	
$3\frac{1}{4}$ — 4 UNC	2.975 2	2.976 1	2.978 5	2.979 4	
$3\frac{1}{2}$ — 4 UNC	3.225 2	3.226 1	3.228 5	3.229 4	
$3\frac{3}{4}$ — 4 UNC	3.475 1	3.476 0	3.478 5	3.479 4	
4 — 4 UNC	3.725 1	3.726 0	3.728 5	3.729 4	

Table 16 **Limits of size for adjustable NOT GO screw ring and calliper gauges**

1	2	3	4	5	6	7	8
Designation	**Minor diameter**						**Effective diameter**
	Classes 1A threads		**Classes 2A threads**		**Classes 3A threads**		**All classes of thread**
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	
	in	in	in	in	in	in	Since adjustable NOT GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 22 and Table 24 respectively, no limits are given for the effective diameters of the gauges.
$\frac{1}{4}$ — 20 UNC	0.200 0	0.200 5	0.201 9	0.202 4	0.203 9	0.204 4	
$\frac{5}{16}$ — 18 UNC	0.257 1	0.257 6	0.259 2	0.259 7	0.261 4	0.261 9	
$\frac{3}{8}$ — 16 UNC	0.313 1	0.313 7	0.315 2	0.315 8	0.317 6	0.318 2	
$\frac{7}{16}$ — 14 UNC	0.367 1	0.367 7	0.369 5	0.370 1	0.372 1	0.372 7	
$\frac{1}{2}$ — 13 UNC	0.424 5	0.424 1	0.426 9	0.427 5	0.429 7	0.430 3	
$\frac{9}{16}$ — 12 UNC	0.481 0	0.481 6	0.483 6	0.484 2	0.486 5	0.487 1	
$\frac{5}{8}$ — 11 UNC	0.536 4	0.537 0	0.539 2	0.539 8	0.542 2	0.542 8	
$\frac{3}{4}$ — 10 UNC	0.652 8	0.653 4	0.655 7	0.656 3	0.659 0	0.659 6	
$\frac{7}{8}$ — 9 UNC	0.767 3	0.768 0	0.770 5	0.771 2	0.774 0	0.774 7	
1 — 8 UNC	0.879 6	0.880 3	0.882 9	0.883 6	0.886 6	0.887 3	
$1\frac{1}{8}$ — 7 UNC	0.988 2	0.988 9	0.991 9	0.992 6	0.995 9	0.996 6	
$1\frac{1}{4}$ — 7 UNC	1.113 0	1.113 7	1.116 7	1.117 4	1.120 8	1.121 5	
$1\frac{3}{8}$ — 6 UNC	1.216 2	1.217 0	1.220 2	1.221 0	1.224 6	1.225 4	
$1\frac{1}{2}$ — 6 UNC	1.341 1	1.341 9	1.345 1	1.345 9	1.349 5	1.350 3	
$1\frac{3}{4}$ — 5 UNC	1.560 7	1.561 5	1.565 2	1.566 0	1.570 1	1.570 9	
2 — $4\frac{1}{2}$ UNC	1.790 4	1.791 2	1.795 2	1.796 0	1.800 5	1.801 3	
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.040 1	2.040 9	2.045 0	2.045 8	2.050 3	2.051 1	
$2\frac{1}{2}$ — 4 UNC	2.264 9	2.265 8	2.270 0	2.270 9	2.275 7	2.276 6	
$2\frac{3}{4}$ — 4 UNC	2.514 5	2.515 4	2.519 8	2.520 7	2.525 6	2.526 5	
3 — 4 UNC	2.764 2	2.765 1	2.769 6	2.770 5	2.775 5	2.776 4	
$3\frac{1}{4}$ — 4 UNC	3.013 9	3.014 8	3.019 3	3.020 2	3.025 3	3.026 2	
$3\frac{1}{2}$ — 4 UNC	3.263 6	3.264 5	3.269 2	3.270 1	3.275 2	3.276 1	
$3\frac{3}{4}$ — 4 UNC	3.513 3	3.514 2	3.518 9	3.519 8	3.525 1	3.526 0	
4 — 4 UNC	3.763 1	3.764 0	3.768 8	3.769 7	3.775 0	3.775 9	

Table 17 **Limits of size for double length setting plugs for adjustable GO screw ring gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Classes 1A and 2A threads**						**Class 3A threads**					
	Major diameter				**Effective diameter**		**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**		**Full flank portion**		**Truncated portion**		**Both portions**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.249 4	0.248 9	0.239 9	0.239 4	0.216 4	0.216 3	0.250 5	0.250 0	0.241 0	0.240 5	0.217 5	0.217 4
$\frac{5}{16}$ — 18 UNC	0.311 8	0.311 3	0.301 6	0.301 1	0.275 2	0.275 1	0.313 0	0.312 5	0.302 8	0.302 3	0.276 4	0.276 3
$\frac{3}{8}$ — 16 UNC	0.374 3	0.373 7	0.363 2	0.362 6	0.333 1	0.333 0	0.375 6	0.375 0	0.364 5	0.363 9	0.334 4	0.334 3
$\frac{7}{16}$ — 14 UNC	0.436 7	0.436 1	0.424 6	0.424 0	0.389 70	0.389 55	0.438 1	0.437 5	0.426 0	0.425 4	0.391 10	0.390 95
$\frac{1}{2}$ — 13 UNC	0.499 1	0.498 5	0.486 3	0.485 7	0.448 50	0.448 35	0.500 6	0.500 0	0.487 8	0.487 2	0.450 00	0.449 85
$\frac{9}{16}$ — 12 UNC	0.561 5	0.560 9	0.548 0	0.547 4	0.506 8	0.506 6	0.563 1	0.562 5	0.549 6	0.549 0	0.508 4	0.508 2
$\frac{5}{8}$ — 11 UNC	0.624 0	0.623 4	0.609 7	0.609 1	0.564 4	0.564 2	0.625 6	0 625 0	0.611 3	0.610 7	0.566 0	0.565 8
$\frac{3}{4}$ — 10 UNC	0.748 8	0.748 2	0.733 6	0.733 0	0.683 2	0.683 0	0.750 6	0.750 0	0.735 4	0.734 8	0.685 0	0.684 8
$\frac{7}{8}$ — 9 UNC	0.873 8	0.873 1	0.857 3	0.856 6	0.800 9	0.800 7	0.875 7	0.875 0	0.859 2	0.858 5	0.802 8	0.802 6
1 — 8 UNC	0.998 7	0.998 0	0.980 9	0.980 2	0.916 8	0.916 6	1.000 7	1.000 0	0.982 9	0.982 2	0.918 8	0.918 6
$1\frac{1}{8}$ — 7 UNC	1.123 5	1.122 8	1.104 0	1.103 3	1.030 0	1.029 8	1.125 7	1.125 0	1.106 2	1.105 5	1.032 2	1.032 0
$1\frac{1}{4}$ — 7 UNC	1.248 5	1.247 8	1.229 0	1.228 3	1.155 0	1.154 8	1.250 7	1.250 0	1.231 2	1.230 5	1.157 2	1.157 0
$1\frac{3}{8}$ — 6 UNC	1.373 4	1.372 6	1.351 6	1.350 8	1.264 3	1.264 1	1.375 8	1.375 0	1.354 0	1.353 2	1.266 7	1.266 5
$1\frac{1}{2}$ — 6 UNC	1.498 4	1.497 6	1.476 6	1.475 8	1.389 3	1.389 1	1.500 8	1.500 0	1.479 0	1.478 2	1.391 7	1.391 5
$1\frac{3}{4}$ — 5 UNC	1.748 1	1.747 3	1.723 4	1.722 6	1.617 40	1.617 15	1.750 8	1.750 0	1.726 1	1.725 3	1.620 10	1.619 85
2 — $4\frac{1}{2}$ UNC	1.997 9	1.997 1	1.971 3	1.970 5	1.852 80	1.852 55	2.000 8	2.000 0	1.974 2	1.973 4	1.855 70	1.855 45
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.247 9	2.247 1	2.221 3	2.220 5	2.102 80	2.102 55	2.250 8	2.250 0	2.224 2	2.223 4	2.105 70	2.105 45
$2\frac{1}{2}$ — 4 UNC	2.497 8	2.496 9	2.468 8	2.467 9	2.334 50	2.334 25	2.500 9	2.500 0	2.471 9	2.471 0	2.337 60	2.337 35
$2\frac{3}{4}$ — 4 UNC	2.747 7	2.746 8	2.718 7	2.717 8	2.584 40	2.584 15	2.750 9	2.750 0	2.721 9	2.721 0	2.587 60	2.587 35
3 — 4 UNC	2.997 7	2.996 8	2.968 7	2.967 8	2.834 40	2.834 15	3.000 9	3.000 0	2.971 9	2.971 0	2.837 60	2.837 35
$3\frac{1}{4}$ — 4 UNC	3.247 6	3.246 7	3.218 6	3.217 7	3.084 30	3.084 05	3.250 9	3.250 0	3.221 9	3.221 0	3.087 60	3.087 35
$3\frac{1}{2}$ — 4 UNC	3.497 6	3.496 7	3.468 6	3.467 7	3.334 30	3.334 05	3.500 9	3.500 0	3.471 9	3.471 0	3.337 60	3.337 35
$3\frac{3}{4}$ — 4 UNC	3.747 5	3.746 6	3.718 5	3.717 6	3.584 20	3.583 95	3.750 9	3.750 0	3.721 9	3.721 0	3.587 60	3.587 35
4 — 4 UNC	3.997 5	3.996 6	3.968 5	3.967 6	3.834 20	3.833 95	4.000 9	4.000 0	3.971 9	3.971 0	3.837 60	3.837 35

Table 18 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 1A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.248 8	0.248 3	0.232 5	0.232 0	0.210 8	0.210 7
$\frac{5}{16}$ — 18 UNC	0.311 3	0.310 8	0.293 2	0.292 7	0.269 1	0.269 0
$\frac{3}{8}$ — 16 UNC	0.374 1	0.373 5	0.353 7	0.353 1	0.326 6	0.326 5
$\frac{7}{16}$ — 14 UNC	0.436 7	0.436 1	0.413 5	0.412 9	0.382 60	0.382 45
$\frac{1}{2}$ — 13 UNC	0.499 1	0.498 5	0.474 4	0.473 8	0.441 10	0.440 95
$\frac{9}{16}$ — 12 UNC	0.561 5	0.560 9	0.535 1	0.534 5	0.499 00	0.498 80
$\frac{5}{8}$ — 11 UNC	0.624 0	0.623 4	0.595 5	0.594 9	0.556 10	0.555 90
$\frac{3}{4}$ — 10 UNC	0.748 8	0.748 2	0.717 7	0.717 1	0.674 4	0.674 2
$\frac{7}{8}$ — 9 UNC	0.873 8	0.873 1	0.839 5	0.838 8	0.791 4	0.791 2
1 — 8 UNC	0.998 7	0.998 0	0.960 8	0.960 1	0.906 7	0.906 5
$1\frac{1}{8}$ — 7 UNC	1.123 5	1.122 8	1.081 0	1.080 3	1.019 1	1.018 9
$1\frac{1}{4}$ — 7 UNC	1.248 5	1.247 8	1.205 8	1.205 1	1.143 9	1.143 7
$1\frac{3}{8}$ — 6 UNC	1.373 4	1.372 6	1.324 5	1.323 7	1.252 3	1.252 1
$1\frac{1}{2}$ — 6 UNC	1.498 4	1.497 6	1.449 4	1.448 6	1.377 2	1.377 0
$1\frac{3}{4}$ — 5 UNC	1.748 1	1.747 3	1.690 6	1.689 8	1.604 00	1.603 75
2 — $4\frac{1}{2}$ UNC	1.997 9	1.997 1	1.934 7	1.933 9	1.838 50	1.838 25
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.247 9	2.247 1	2.184 4	2.183 6	2.088 20	2.087 95
$2\frac{1}{2}$ — 4 UNC	2.497 8	2.496 9	2.427 3	2.426 4	2.319 00	2.318 75
$2\frac{3}{4}$ — 4 UNC	2.747 7	2.746 8	2.676 9	2.676 0	2.568 60	2.568 35
3 — 4 UNC	2.997 7	2.996 8	2.926 6	2.925 7	2.818 30	2.818 05
$3\frac{1}{4}$ — 4 UNC	3.247 6	3.246 7	3.176 3	3.175 4	3.068 00	3.067 75
$3\frac{1}{2}$ — 4 UNC	3.497 6	3.496 7	3.426 0	3.425 1	3.317 70	3.317 45
$3\frac{3}{4}$ — 4 UNC	3.747 5	3.746 6	3.675 7	3.674 8	3.567 40	3.567 15
4 — 4 UNC	3.997 5	3.996 6	3.925 5	3.924 6	3.817 20	3.816 95

Table 19 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 2A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.249 4	0.248 9	0.234 4	0.233 9	0.212 7	0.212 6
$\frac{5}{16}$ — 18 UNC	0.311 8	0.311 3	0.295 3	0.294 8	0.271 2	0.271 1
$\frac{3}{8}$ — 16 UNC	0.374 3	0.373 7	0.355 8	0.355 2	0.328 7	0.328 6
$\frac{7}{16}$ — 14 UNC	0.436 7	0.436 1	0.415 9	0.415 3	0.385 00	0.384 85
$\frac{1}{2}$ — 13 UNC	0.499 1	0.498 5	0.476 8	0.476 2	0.443 50	0.443 35
$\frac{9}{16}$ — 12 UNC	0.561 5	0.560 9	0.537 7	0.537 1	0.501 6	0.501 4
$\frac{5}{8}$ — 11 UNC	0.624 0	0.623 4	0.598 3	0.597 7	0.558 9	0.558 7
$\frac{3}{4}$ — 10 UNC	0.748 8	0.748 2	0.720 6	0.720 0	0.677 3	0.677 1
$\frac{7}{8}$ — 9 UNC	0.873 8	0.873 1	0.842 7	0.842 0	0.794 6	0.794 4
1 — 8 UNC	0.998 7	0.998 0	0.964 1	0.963 4	0.910 0	0.909 8
$1\frac{1}{8}$ — 7 UNC	1.123 5	1.122 8	1.084 7	1.084 0	1.022 8	1.022 6
$1\frac{1}{4}$ — 7 UNC	1.248 5	1.247 8	1.209 5	1.208 8	1.147 6	1.147 4
$1\frac{3}{8}$ — 6 UNC	1.373 4	1.372 6	1.328 5	1.327 7	1.256 3	1.256 1
$1\frac{1}{2}$ — 6 UNC	1.498 4	1.497 6	1.453 4	1.452 6	1.381 2	1.381 0
$1\frac{3}{4}$ — 5 UNC	1.748 1	1.747 3	1.695 1	1.694 3	1.608 50	1.608 25
2 — $4\frac{1}{2}$ UNC	1.997 9	1.997 1	1.939 5	1.938 7	1.843 30	1.843 05
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.247 9	2.247 1	2.189 3	2.188 5	2.093 10	2.092 85
$2\frac{1}{2}$ — 4 UNC	2.497 8	2.496 9	2.432 4	2.431 5	2.324 10	2.323 85
$2\frac{3}{4}$ — 4 UNC	2.747 7	2.746 8	2.682 2	2.681 3	2.573 90	2.573 65
3 — 4 UNC	2.997 7	2.996 8	2.932 0	2.931 1	2.823 70	2.823 45
$3\frac{1}{4}$ — 4 UNC	3.247 6	3.246 7	3.181 7	3.180 8	3.073 40	3.073 15
$3\frac{1}{2}$ — 4 UNC	3.497 6	3.496 7	3.431 6	3.430 7	3.323 30	3.323 05
$3\frac{3}{4}$ — 4 UNC	3.747 5	3.746 6	3.681 3	3.680 4	3.573 00	3.572 75
4 — 4 UNC	3.997 5	3.996 6	3.931 2	3.930 3	3.822 90	3.822 65

Table 20 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 3A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.250 5	0.250 0	0.236 4	0.235 9	0.214 7	0.214 6
$\frac{5}{16}$ — 18 UNC	0.313 0	0.312 5	0.297 5	0.297 0	0.273 4	0.273 3
$\frac{3}{8}$ — 16 UNC	0.375 6	0.375 0	0.358 2	0.357 6	0.331 1	0.331 0
$\frac{7}{16}$ — 14 UNC	0.438 1	0.437 5	0.418 5	0.417 9	0.387 60	0.387 45
$\frac{1}{2}$ — 13 UNC	0.500 6	0.500 0	0.479 6	0.479 0	0.446 30	0.446 15
$\frac{9}{16}$ — 12 UNC	0.563 1	0.562 5	0.540 6	0.540 0	0.504 5	0.504 3
$\frac{5}{8}$ — 11 UNC	0.625 6	0.625 0	0.601 3	0.600 7	0.561 9	0.561 7
$\frac{3}{4}$ — 10 UNC	0.750 6	0.750 0	0.723 9	0.723 3	0.680 6	0.680 4
$\frac{7}{8}$ — 9 UNC	0.875 7	0.875 0	0.846 2	0.845 5	0.798 1	0.797 9
1 — 8 UNC	1.000 7	1.000 0	0.967 8	0.967 1	0.913 7	0.913 5
$1\frac{1}{8}$ — 7 UNC	1.125 7	1.125 0	1.088 7	1.088 0	1.026 8	1.026 6
$1\frac{1}{4}$ — 7 UNC	1.250 7	1.250 0	1.213 6	1.212 9	1.151 7	1.151 5
$1\frac{3}{8}$ — 6 UNC	1.375 8	1.375 0	1.332 9	1.332 1	1.260 7	1.260 5
$1\frac{1}{2}$ — 6 UNC	1.500 8	1.500 0	1.457 8	1.457 0	1.385 6	1.385 4
$1\frac{3}{4}$ — 5 UNC	1.750 8	1.750 0	1.700 0	1.699 2	1.613 40	1.613 15
2 — $4\frac{1}{2}$ UNC	2.000 8	2.000 0	1.944 8	1.944 0	1.848 60	1.848 35
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.250 8	2.250 0	2.194 6	2.193 8	2.098 40	2.098 15
$2\frac{1}{2}$ — 4 UNC	2.500 9	2.500 0	2.438 1	2.437 2	2.329 80	2.329 55
$2\frac{3}{4}$ — 4 UNC	2.750 9	2.750 0	2.680 0	2.687 1	2.579 70	2.579 45
3 — 4 UNC	3.000 9	3.000 0	2.937 9	2.937 0	2.829 60	2.829 35
$3\frac{1}{4}$ — 4 UNC	3.250 9	3.250 0	3.187 7	3.186 8	3.079 40	3.079 15
$3\frac{1}{2}$ — 4 UNC	3.500 9	3.500 0	3.437 6	3.436 7	3.329 30	3.329 05
$3\frac{3}{4}$ — 4 UNC	3.750 9	3.750 0	3.687 5	3.686 6	3.579 20	3.578 95
4 — 4 UNC	4.000 9	4.000 0	3.937 4	3.936 5	3.829 10	3.828 85

Table 21 **Limits of size for single length setting plugs for adjustable GO screw calliper gauges**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.238 9	0.237 9	0.216 0	0.215 8	0.240 0	0.239 0	0.217 1	0.216 9
$\frac{5}{16}$ — 18 UNC	0.300 2	0.299 2	0.274 8	0.274 6	0.301 4	0.300 4	0.276 0	0.275 8
$\frac{3}{8}$ — 16 UNC	0.361 2	0.360 2	0.332 7	0.332 5	0.362 5	0.361 5	0.334 0	0.333 8
$\frac{7}{16}$ — 14 UNC	0.421 8	0.420 8	0.389 3	0.389 1	0.423 2	0.422 2	0.390 7	0.390 5
$\frac{1}{2}$ — 13 UNC	0.483 1	0.482 1	0.448 1	0.447 9	0.484 6	0.483 6	0.449 6	0.449 4
$\frac{9}{16}$ — 12 UNC	0.544 2	0.543 2	0.506 2	0.506 0	0.545 8	0.544 8	0.507 8	0.507 6
$\frac{5}{8}$ — 11 UNC	0.605 2	0.604 2	0.563 8	0.563 6	0.606 8	0.605 8	0.565 4	0.565 2
$\frac{3}{4}$ — 10 UNC	0.728 2	0.727 2	0.682 6	0.682 4	0.730 0	0.729 0	0.684 4	0.684 2
$\frac{7}{8}$ — 9 UNC	0.850 9	0.849 9	0.800 3	0.800 1	0.852 8	0.851 8	0.802 2	0.802 0
1 — 8 UNC	0.973 0	0.972 0	0.916 2	0.916 0	0.975 0	0.974 0	0.918 2	0.918 0
$1\frac{1}{8}$ — 7 UNC	1.094 2	1.093 2	1.029 4	1.029 2	1.096 4	1.095 4	1.031 6	1.031 4
$1\frac{1}{4}$ — 7 UNC	1.219 2	1.218 2	1.154 4	1.154 2	1.221 4	1.220 4	1.156 6	1.156 4
$1\frac{3}{8}$ — 6 UNC	1.339 3	1.338 3	1.263 7	1.263 5	1.341 7	1.340 7	1.266 1	1.265 9
$1\frac{1}{2}$ — 6 UNC	1.464 3	1.463 3	1.388 7	1.388 5	1.466 7	1.465 7	1.399 1	1.390 9
$1\frac{3}{4}$ — 5 UNC	1.707 3	1.706 3	1.616 7	1.616 4	1.710 0	1.709 0	1.619 4	1.619 1
2 — $4\frac{1}{2}$ UNC	1.952 7	1.951 7	1.852 1	1.851 8	1.955 6	1.954 6	1.853 0	1.854 7
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.202 7	2.201 7	2.102 1	2.101 8	2.205 6	2.204 6	2.105 0	2.104 7
$2\frac{1}{2}$ — 4 UNC	2.446 9	2.445 9	2.333 8	2.333 5	2.450 0	2.449 0	2.336 9	2.336 6
$2\frac{3}{4}$ — 4 UNC	2.696 8	2.695 8	2.583 7	2.583 4	2.700 0	2.699 0	2.586 9	2.586 6
3 — 4 UNC	2.946 8	2.945 8	2.833 7	2.833 4	2.950 0	2.949 0	2.836 9	2.836 6
$3\frac{1}{4}$ — 4 UNC	3.196 7	3.195 7	3.083 5	3.083 1	3.200 0	3.199 0	3.086 8	3.086 4
$3\frac{1}{2}$ — 4 UNC	3.446 7	3.445 7	3.333 5	3.333 1	3.450 0	3.449 0	3.336 8	3.336 4
$3\frac{3}{4}$ — 4 UNC	3.696 6	3.695 6	3.583 4	3.583 0	3.700 0	3.699 0	3.586 6	3.586 4
4 — 4 UNC	3.946 6	3.945 6	3.833 4	3.833 0	3.950 0	3.949 0	3.836 8	3.836 4

Table 22 **Limits of size for single length setting plugs for adjustable NOT GO screw calliper gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.238 9	0.237 9	0.210 5	0.210 3	0.238 9	0.237 9	0.212 4	0.212 2	0.240 0	0.239 0	0.214 4	0.214 2
$\frac{5}{16}$ — 18 UNC	0.300 2	0.299 2	0.268 8	0.268 6	0.300 2	0.299 2	0.270 9	0.270 7	0.301 4	0.300 4	0.273 1	0.272 9
$\frac{3}{8}$ — 16 UNC	0.361 2	0.360 2	0.326 3	0.326 1	0.361 2	0.360 2	0.328 4	0.328 2	0.362 5	0.361 5	0.330 8	0.330 6
$\frac{7}{16}$ — 14 UNC	0.421 8	0 420 8	0.382 3	0.382 1	0.421 8	0.420 8	0.384 7	0.384 5	0.423 2	0.422 2	0.387 3	0.387 1
$\frac{1}{2}$ — 13 UNC	0.483 1	0.482 1	0.440 8	0.440 6	0.483 1	0.482 1	0.443 2	0.443 0	0.484 6	0.483 6	0.446 0	0.445 8
$\frac{9}{16}$ — 12 UNC	0.544 2	0.543 2	0.498 6	0.498 4	0.544 2	0.543 2	0.501 2	0.501 0	0.545 8	0.544 8	0.504 1	0.503 9
$\frac{5}{8}$ — 11 UNC	0.605 2	0.604 2	0.555 7	0.555 5	0.605 2	0.604 2	0.558 5	0.558 3	0.606 8	0.605 8	0.561 5	0.561 3
$\frac{3}{4}$ — 10 UNC	0.728 2	0.727 2	0.674 0	0.673 8	0.728 2	0.727 2	0.676 9	0.676 7	0.730 0	0.729 0	0.680 2	0.680 0
$\frac{7}{8}$ — 9 UNC	0.850 9	0.849 9	0.791 0	0.790 8	0.850 9	0.849 9	0.794 2	0.794 0	0.852 8	0.851 8	0.797 7	0.797 5
1 — 8 UNC	0.973 0	0.972 0	0.906 3	0.906 1	0.973 0	0.972 0	0.909 6	0.909 4	0.975 0	0.974 0	0.913 3	0.913 1
$1\frac{1}{8}$— 7 UNC	1.094 2	1.093 2	1.018 7	1.018 5	1.094 2	1.093 2	1.022 4	1.022 2	1.096 4	1.095 4	1.026 4	1.026 2
$1\frac{1}{4}$ — 7 UNC	1.219 2	1.218 2	1.143 5	1.143 3	1.219 2	1.218 2	1.147 2	1.147 0	1.221 4	1.220 4	1.151 3	1.151 1
$1\frac{3}{8}$ — 6 UNC	1.339 3	1.338 3	1.251 9	1.251 7	1.339 3	1.338 3	1.255 9	1.255 7	1.341 7	1.340 7	1.260 3	1.260 1
$1\frac{1}{2}$ — 6 UNC	1.464 3	1.463 3	1.376 8	1.376 6	1.464 3	1.463 3	1.380 8	1.380 6	1.466 7	1.465 7	1.385 2	1.385 0
$1\frac{3}{4}$ — 5 UNC	1.707 3	1.706 3	1.603 5	1.603 2	1.707 3	1.706 3	1.608 0	1.607 7	1.710 0	1.709 0	1.612 9	1.612 6
2 — $4\frac{1}{2}$ UNC	1.952 7	1.951 7	1.838 0	1.837 7	1.952 7	1.951 7	1.842 8	1.842 5	1.955 6	1.954 6	1.848 1	1.847 8
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.202 7	2.201 7	2.087 7	2.087 4	2.202 7	2.201 7	2.092 6	2.092 3	2.205 6	2.204 6	2.097 9	2.097 6
$2\frac{1}{2}$ — 4 UNC	2.446 9	2.445 9	2.318 5	2.318 2	2.446 9	2.445 9	2.323 6	2.323 3	2.450 0	2.449 0	2.329 3	2.329 0
$2\frac{3}{4}$ — 4 UNC	2.696 8	2.695 8	2.568 1	2.567 8	2.696 8	2.695 8	2.573 4	2.573 1	2.700 0	2.699 0	2.579 2	2.578 9
3 — 4 UNC	2.946 8	2.945 8	2.817 8	2.817 5	2.946 8	2.945 8	2.823 2	2.822 9	2.950 0	2.949 0	2.829 1	2.828 8
$3\frac{1}{4}$ — 4 UNC	3.196 7	3.195 7	3.067 5	3.067 1	3.196 7	3.195 7	3.072 9	3.072 5	3.200 0	3.199 0	3.078 9	3.078 5
$3\frac{1}{2}$ — 4 UNC	3.446 7	3.445 7	3.317 2	3.316 8	3.446 7	3.445 7	3.322 8	3.322 4	3.450 0	3.449 0	3.328 8	3.328 4
$3\frac{3}{4}$ — 4 UNC	3.696 6	3.695 6	3.566 9	3.566 5	3.696 6	3.695 6	3.572 5	3.572 1	3.700 0	3.699 0	3.578 7	3.578 3
4 — 4 UNC	3.946 6	3.945 6	3.816 7	3.816 3	3.946 6	3.945 6	3.822 4	3.822 0	3.950 0	3.949 0	3.828 6	3.828 2

Table 23 **Limits of size for GO and NOT GO plain calliper (GAP) gauges for major diameters**

1	2	3	4	5	6	7	8	9	10	11
Designation	**GO gauges**				**NOT GO gauges**					
	Class 1A threads		**Class 3A threads**		**Class 1A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 20 UNC	0.248 6	0.248 9	0.249 7	0.250 0	0.236 4	0.236 7	0.240 5	0.240 8	0.241 6	0.241 9
$\frac{5}{16}$ — 18 UNC	0.311 0	0.311 3	0.312 2	0.312 5	0.297 9	0.298 2	0.302 3	0.302 6	0.303 5	0.303 8
$\frac{3}{8}$ — 16 UNC	0.373 4	0.373 7	0.374 7	0.375 0	0.359 2	0.359 5	0.364 0	0.364 3	0.365 3	0.365 6
$\frac{7}{16}$ — 14 UNC	0.435 8	0.436 1	0.437 2	0.437 5	0.420 3	0.420 6	0.425 5	0.425 8	0.426 9	0.427 2
$\frac{1}{2}$ — 13 UNC	0.498 2	0.498 5	0.499 7	0.500 0	0.481 9	0.482 2	0.487 3	0.487 6	0.488 8	0.489 1
$\frac{9}{16}$ — 12 UNC	0.560 6	0.560 9	0.562 2	0.562 5	0.543 4	0.543 7	0.549 2	0.549 5	0.550 8	0.551 1
$\frac{5}{8}$ — 11 UNC	0.623 1	0.623 4	0.624 7	0.625 0	0.604 9	0.605 2	0.611 0	0.611 3	0.612 6	0.612 9
$\frac{3}{4}$ — 10 UNC	0.747 9	0.748 2	0.749 7	0.750 0	0.728 5	0.728 8	0.735 0	0.735 3	0.736 8	0.737 1
$\frac{7}{8}$ — 9 UNC	0.872 8	0.873 1	0.874 7	0.875 0	0.852 0	0.852 3	0.858 9	0.859 2	0.860 8	0.861 1
1 — 8 UNC	0.997 7	0.998 0	0.999 7	1.000 0	0.975 2	0.975 5	0.982 7	0.983 0	0.984 7	0.985 0
$1\frac{1}{8}$ — 7 UNC	1.122 5	1.122 8	1.124 7	1.125 0	1.097 9	1.098 2	1.106 1	1.106 4	1.108 3	1.108 6
$1\frac{1}{4}$ — 7 UNC	1.247 5	1.247 8	1.249 7	1.250 0	1.222 9	1.223 2	1.231 1	1.231 4	1.233 3	1.233 6
$1\frac{3}{8}$ — 6 UNC	1.372 3	1.372 6	1.374 7	1.375 0	1.345 0	1.345 3	1.354 1	1.354 4	1.356 5	1.356 8
$1\frac{1}{2}$ — 6 UNC	1.497 3	1.497 6	1.499 7	1.500 0	1.470 0	1.470 3	1.479 1	1.479 4	1.481 5	1.481 8
$1\frac{3}{4}$ — 5 UNC	1.746 9	1.747 3	1.749 6	1.750 0	1.716 1	1.716 5	1.726 4	1.726 8	1.729 1	1.729 5
2 — $4\frac{1}{2}$ UNC	1.996 7	1.997 1	1.999 6	2.000 0	1.963 7	1.964 1	1.974 7	1.975 1	1.977 6	1.978 0
$2\frac{1}{4}$ — $4\frac{1}{2}$ UNC	2.246 7	2.247 1	2.249 6	2.250 0	2.213 7	2.214 1	2.224 7	2.225 1	2.227 6	2.228 0
$2\frac{1}{2}$ — 4 UNC	2.496 5	2.496 9	2.499 6	2.500 0	2.460 8	2.461 2	2.472 7	2.473 1	2.475 8	2.476 2
$2\frac{3}{4}$ — 4 UNC	2.746 4	2.746 8	2.749 6	2.750 0	2.710 7	2.711.1	2.722 6	2.723 0	2.725 8	2.726 2
3 — 4 UNC	2.996 4	2.996 8	2.999 6	3.000 0	2.960 7	2.961.1	2.972 6	2.973 0	2.975 8	2.976 2
$3\frac{1}{4}$ — 4 UNC	3.246 2	3.246 7	3.249 5	3.250 0	3.210 5	3.211 0	3.222 4	3.222 9	3.225 7	3.226 2
$3\frac{1}{2}$ — 4 UNC	3.496 2	3.496 7	3.499 5	3.500 0	3.460 5	3.461 0	3.472 4	3.472 9	3.475 7	3.476 2
$3\frac{3}{4}$ — 4 UNC	3.746 1	3.746 6	3.749 5	3.750 0	3.710 4	3.710 9	3.722 3	3.722 8	3.725 7	3.726 2
4 — 4 UNC	3.996 1	3.996 6	3.999 5	4.000 0	3.960 4	3.960 9	3.972 3	3.972 8	3.975 7	3.976 2

Section 2: Unified fine threads, UNF

Table 24 **Limits of size for GO screw plug gauges (all classes of thread)**

1	2	3	4	5
Designation	**Major diameter**		**Effective diameter**	
	Max.	**Min.**	**Max.**	**Min.**
	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.250 5	0.250 0	0.227 1	0.226 8
$\frac{5}{16}$ — 24 UNF	0.313 0	0.312 5	0.285 7	0.285 4
$\frac{3}{8}$ — 24 UNF	0.375 5	0.375 0	0.348 2	0.347 9
$\frac{7}{16}$ — 20 UNF	0.438 0	0.437 5	0.405 3	0.405 0
$\frac{1}{2}$ — 20 UNF	0.500 5	0.500 0	0.467 8	0.467 5
$\frac{9}{16}$ — 18 UNF	0.563 0	0.562 5	0.526 7	0.526 4
$\frac{5}{8}$ — 18 UNF	0.625 5	0.625 0	0.589 2	0.588 9
$\frac{3}{4}$ — 16 UNF	0.750 6	0.750 0	0.709 7	0.709 4
$\frac{7}{8}$ — 14 UNF	0.875 6	0.875 0	0.828 9	0.828 6
1 — 12 UNF	1.000 6	1.000 0	0.946 2	0.945 9
$1\frac{1}{8}$ — 12 UNF	1.125 6	1.125 0	1.071 2	1.070 9
$1\frac{1}{4}$ — 12 UNF	1.250 6	1.250 0	1.196 2	1.195 9
$1\frac{3}{8}$ — 12 UNF	1.375 6	1.375 0	1.321 2	1.320 9
$1\frac{1}{2}$ — 12 UNF	1.500 6	1.500 0	1.446 2	1.445 9

Table 25 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 1B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.241 0	0.240 5	0.248 8	0.248 3	0.233 6	0.233 3
$\frac{5}{16}$ — 24 UNF	0.301 5	0.301 0	0.310 5	0.310 0	0.292 8	0.292 5
$\frac{3}{8}$ — 24 UNF	0.364 3	0.363 8	0.373 3	0.372 8	0.355 6	0.355 3
$\frac{7}{16}$ — 20 UNF	0.423 9	0.423 4	0.434 8	0.434 3	0.413 4	0.413 1
$\frac{1}{2}$ — 20 UNF	0.486 7	0.486 2	0.497 6	0.497 1	0.476 2	0.475 9
$\frac{9}{16}$ — 18 UNF	0.547 3	0.546 8	0.559 4	0.558 9	0.535 6	0.535 3
$\frac{5}{8}$ — 18 UNF	0.610 0	0.609 5	0.622 1	0.621 6	0.598 3	0.598 0
$\frac{3}{4}$ — 16 UNF	0.732 7	0.732 1	0.746 3	0.745 7	0.719 5	0.719 2
$\frac{7}{8}$ — 14 UNF	0.854 7	0.854 1	0.870 1	0.869 5	0.839 5	0.839 2
1 — 12 UNF	0.975 3	0.974 7	0.993 4	0.992 8	0.957 6	0.957 3
$1\frac{1}{8}$ — 12 UNF	1.100 6	1.100 0	1.118 7	1.118 1	1·082 9	1.082 6
$1\frac{1}{4}$ — 12 UNF	1.225 9	1.225 3	1.244 0	1.243 4	1.208 2	1.207 9
$1\frac{3}{8}$ — 12 UNF	1.351 2	1.350 6	1.369 3	1.368 7	1.333 5	1.333 2
$1\frac{1}{2}$ — 12 UNF	1.476 4	1.475 8	1.494 5	1.493 9	1.458 7	1.458 4

Table 26 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 2B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.238 8	0.238 3	0.246 6	0.246 1	0.231 4	0.231 1
$\frac{5}{16}$ — 24 UNF	0.299 2	0.298 7	0.308 2	0.307 7	0.290 5	0.290 2
$\frac{3}{8}$ — 24 UNF	0.361 8	0.361 3	0.370 8	0.370 3	0.353 1	0.352 8
$\frac{7}{16}$ — 20 UNF	0.421 2	0.420 7	0.432 1	0.431 6	0.410 7	0.410 4
$\frac{1}{2}$ — 20 UNF	0·483 9	0.483 4	0.494 8	0.494 3	0.473 4	0.473 1
$\frac{9}{16}$ — 18 UNF	0.544 3	0.543 8	0.556 4	0.555 9	0.532 6	0.532 3
$\frac{5}{8}$ — 18 UNF	0.606 9	0.606 4	0.619 0	0.618 5	0.595 2	0.594 9
$\frac{3}{4}$ — 16 UNF	0.729 4	0.728 8	0.743 0	0.742 4	0.716 2	0.715 9
$\frac{7}{8}$ — 14 UNF	0.851 1	0.850 5	0.866 5	0.865 9	0.835 9	0.835 6
1 — 12 UNF	0.971 5	0.970 9	0.989 6	0.989 0	0.953 8	0.953 5
$1\frac{1}{8}$ — 12 UNF	1.096 7	1.096 1	1.114 8	1.114 2	1.079 0	1.078 7
$1\frac{1}{4}$ — 12 UNF	1.221 9	1.221 3	1.240 0	1.239 4	1.204 2	1.203 9
$1\frac{3}{8}$ — 12 UNF	1.347 1	1.346 5	1.365 2	1.364 6	1.329 4	1.329 1
$1\frac{1}{2}$ — 12 UNF	1·472 2	1.471 6	1.490 3	1.489 7	1.454 5	1.454 2

Table 27 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 3B threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.237 7	0.237 2	0.245 5	0.245 0	0.230 3	0.230 0
$\frac{5}{16}$ — 24 UNF	0.298 0	0.297 5	0.307 0	0.306 5	0.289 3	0.289 0
$\frac{3}{8}$ — 24 UNF	0.360 6	0.360 1	0.369 6	0.369 1	0.351 9	0.351 6
$\frac{7}{16}$ — 20 UNF	0.419 9	0.419 4	0.430 8	0.430 3	0.409 4	0.409 1
$\frac{1}{2}$ — 20 UNF	0.482 5	0.482 0	0.493 4	0.492 9	0.472 0	0.471 7
$\frac{9}{16}$ — 18 UNF	0.542 8	0.542 3	0.554 9	0.554 4	0.531 1	0.530 8
$\frac{5}{8}$ — 18 UNF	0.605 4	0.604 9	0.617 5	0.617 0	0.593 7	0.593 4
$\frac{3}{4}$ — 16 UNF	0.727 8	0.727 2	0.741 4	0.740 8	0.714 6	0.714 3
$\frac{7}{8}$ — 14 UNF	0.849 4	0.848 8	0.864 8	0.864 2	0.834 2	0.833 9
1 — 12 UNF	0.969 6	0.969 0	0.987 7	0.987 1	0.951 9	0.951 6
$1\frac{1}{8}$ — 12 UNF	1.094 8	1.094 2	1.112 9	1.112 3	1.077 1	1.076 8
$1\frac{1}{4}$ — 12 UNF	1.219 9	1.219 3	1.238 0	1.237 4	1.202 2	1.201 9
$1\frac{3}{8}$ — 12 UNF	1.345 0	1.344 4	1.363 1	1.362 5	1.327 3	1.327 0
$1\frac{1}{2}$ — 12 UNF	1.470 2	1.469 6	1.488 3	1.487 7	1.452 5	1.452 2

Table 28 **Limits of size for GO and NOT GO plain plug gauges for minor diameters**

1	2	3	4	5	6	7
Designation	**GO gauges**		**NOT GO gauges**			
	All classes of thread		**Classes 1B and 2B threads**		**Class 3B threads**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.211 6	0.211 3	0.220 0	0.219 7	0.219 3	0.219 0
$\frac{5}{16}$ — 24 UNF	0.267 7	0.267 4	0.277 4	0.277 1	0.275 7	0.275 4
$\frac{3}{8}$ — 24 UNF	0.330 2	0.329 9	0.339 9	0.339 6	0.337 5	0.337 2
$\frac{7}{16}$ — 20 UNF	0.383 7	0.383 4	0.395 2	0.394 9	0.391 9	0.391 6
$\frac{1}{2}$ — 20 UNF	0.446 2	0.445 9	0.457 7	0.457 4	0.454 0	0.453 7
$\frac{9}{16}$ — 18 UNF	0.502 7	0.502 4	0.515 4	0.515 1	0.510 9	0.510 6
$\frac{5}{8}$ — 18 UNF	0.565 2	0.564 9	0.577 9	0.577 6	0.573 3	0.573 0
$\frac{3}{4}$ — 16 UNF	0.682 6	0.682 3	0.696 7	0.696 4	0.700 1	0.690 8
$\frac{7}{8}$ — 14 UNF	0.798 0	0.797 7	0.813 8	0.813 5	0.807 1	0.806 8
1 — 12 UNF	0.910 1	0.909 8	0.928 2	0.927 9	0.920 1	0.919 8
$1\frac{1}{8}$ — 12 UNF	1.035 1	1.034 8	1.053 2	1.052 9	1.045 1	1.044 8
$1\frac{1}{4}$ — 12 UNF	1.160 1	1.159 8	1.178 2	1.177 9	1.170 1	1.169 8
$1\frac{3}{8}$ — 12 UNF	1.285 1	1.284 8	1.303 2	1.302 9	1.295 1	1.294 8
$1\frac{1}{2}$ — 12 UNF	1.410 1	1.409 8	1.428 2	1.427 9	1.420 1	1.419 8

Table 29 **Limits of size for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.209 7	0.210 3	0.225 2	0.225 8	0.210 7	0.211 3	0.226 2	0.226 8
$\frac{5}{16}$ — 24 UNF	0.265 7	0.266 3	0.283 7	0.284 3	0.266 8	0.267 4	0.284 8	0.285 4
$\frac{3}{8}$ — 24 UNF	0.328 2	0.328 8	0.346 2	0.346 8	0.329 3	0.329 9	0.347 3	0.347 9
$\frac{7}{16}$ — 20 UNF	0.381 5	0.382 1	0.403 1	0.403 7	0.382 8	0.383 4	0.404 4	0.405 0
$\frac{1}{2}$ — 20 UNF	0.444 0	0.444 6	0.465 6	0.466 2	0.445 3	0.445 9	0.466 9	0.467 5
$\frac{9}{16}$ — 18 UNF	0.500 3	0.501 0	0.524 2	0.525 0	0.501 7	0.502 4	0.525 6	0.526 4
$\frac{5}{8}$ — 18 UNF	0.562 8	0.563 5	0.586 7	0.587 5	0.564 2	0.564 9	0.588 1	0.588 9
$\frac{3}{4}$ — 16 UNF	0.680 1	0.680 8	0.707 1	0.707 9	0.681 6	0.682 3	0.708 6	0.709 4
$\frac{7}{8}$ — 14 UNF	0.795 4	0.796 1	0.826 2	0.827 0	0.797 0	0.797 7	0.827 8	0.828 6
1 — 12 UNF	0.907 3	0.908 0	0.943 3	0.944 1	0.909 1	0.909 8	0.945 1	0.945 9
$1\frac{1}{8}$ — 12 UNF	1.032 3	1.033 0	1.068 3	1.069 1	1.034 1	1.034 8	1.070 1	1.070 9
$1\frac{1}{4}$ — 12 UNF	1.157 3	1.158 0	1.193 3	1.194 1	1.159 1	1.159 8	1.195 1	1.195 9
$1\frac{3}{8}$ — 12 UNF	1.282 2	1.282 9	1.318 2	1.319 0	1.284 1	1.284 8	1.320 1	1.320 9
$1\frac{1}{2}$ — 12 UNF	1.407 2	1.407 9	1.443 2	1.444 0	1.409 1	1.409 8	1.445 1	1.445 9

Table 30 **Limits of size for NOT GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.213 1	0.213 7	0.220 3	0.220 8	0.214 8	0.215 4	0.222 0	0.222 5	0.216 6	0.217 2	0.223 8	0.224 3
$\frac{5}{16}$ — 24 UNF	0.269 8	0.270 4	0.278 3	0.278 8	0.271 6	0.272 2	0.280 1	0.280 6	0.273 7	0.274 3	0.282 2	0.282 7
$\frac{3}{8}$ — 24 UNF	0.332 1	0.332 7	0.340 6	0.341 1	0.334 0	0.334 6	0.342 5	0.343 0	0.336 0	0.336 6	0.344 5	0.345 0
$\frac{7}{16}$ — 20 UNF	0.386 7	0.387 3	0.397 0	0.397 5	0.388 7	0.389 3	0.399 0	0.399 5	0.391 1	0.391 7	0.401 4	0.401 9
$\frac{1}{2}$ — 20 UNF	0.449 0	0.449 6	0.459 3	0.459 8	0.451 1	0.451 7	0.461 4	0.461 9	0.453 5	0.454 1	0.463 8	0.464 3
$\frac{9}{16}$ — 18 UNF	0.506 2	0.506 9	0.517 6	0.518 2	0.508 5	0.509 2	0.519 9	0.520 5	0.511 0	0.511 7	0.522 4	0.523 0
$\frac{5}{8}$ — 18 UNF	0.568 5	0.569 2	0.579 9	0.580 5	0.570 8	0.571 5	0.582 2	0.582 8	0.573 4	0.574 1	0.584 8	0.585 4
$\frac{3}{4}$ — 16 UNF	0.686 9	0.687 6	0.699 8	0.700 4	0.689 4	0.690 1	0.702 3	0.702 9	0.692 1	0.692 8	0.705 0	0.705 6
$\frac{7}{8}$ — 14 UNF	0.803 4	0.804 1	0.818 3	0.818 9	0.806 1	0.806 8	0.821 0	0.821 6	0.809 0	0.809 7	0.823 9	0.824 5
1 — 12 UNF	0.917 3	0.918 0	0.934 7	0.935 3	0.920 2	0.920 9	0.937 6	0.938 2	0.923 5	0.924 2	0.940 9	0.941 5
$1\frac{1}{8}$ — 12 UNF	1.042 1	1.042 8	1.059 5	1.060 1	1.045 1	1.045 8	1.062 5	1.063 1	1.048 4	1.049 1	1.065 8	1.066 4
$1\frac{1}{4}$ — 12 UNF	1.166 9	1.167 6	1.184 3	1.184 9	1.169 9	1.170 6	1.187 3	1.187 9	1.173 3	1.174 0	1.190 7	1.191 3
$1\frac{3}{8}$ — 12 UNF	1.291 6	1.292 3	1.309 0	1.309 6	1.294 7	1.295 4	1.312 1	1.312 7	1.298 2	1.298 9	1.315 6	1.316 2
$1\frac{1}{2}$ — 12 UNF	1.416 4	1.417 1	1.433 8	1.434 4	1.419 6	1.420 3	1.437 0	1.437 6	1.423 1	1.423 8	1.440 5	1.441 1

Table 31 **Limits of size for GO screw check plugs for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Minor diameter[A)]		**Effective diameter**		**Minor diameter**[A)]		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.225 2	0.224 9	0.248 4	0.248 1	0.226 2	0.225 9	0.249 4	0.249 1
$\frac{5}{16}$ — 24 UNF	0.283 7	0.283 4	0.310 8	0.310 5	0.284 8	0.284 5	0.311 9	0.311 6
$\frac{3}{8}$ — 24 UNF	0.346 2	0.345 9	0.373 3	0.373 0	0.347 3	0.347 0	0.374 4	0.374 1
$\frac{7}{16}$ — 20 UNF	0.403 1	0.402 8	0.435 6	0.435 3	0.404 4	0.404 1	0.436 9	0.436 6
$\frac{1}{2}$ — 20 UNF	0.465 6	0.465 3	0.498 1	0.497 8	0.466 9	0.466 6	0.499 4	0.499 1
$\frac{9}{16}$ — 18 UNF	0.524 2	0.523 8	0.560 3	0.559 9	0.525 6	0.525 2	0.561 7	0.561 3
$\frac{5}{8}$ — 18 UNF	0.586 7	0.586 3	0.622 8	0.622 4	0.588 1	0.587 3	0.624 2	0.623 8
$\frac{3}{4}$ — 16 UNF	0.707 1	0.706 7	0.747 7	0.747 3	0.708 6	0.708 2	0.749 2	0.748 8
$\frac{7}{8}$ — 14 UNF	0.826 2	0.825 8	0.872 6	0.872 2	0.827 8	0.827 4	0.874 2	0.873 8
1 — 12 UNF	0.943 3	0.942 9	0.997 4	0.997 0	0.945 1	0.944 7	0.999 2	0.998 8
$1\frac{1}{8}$ — 12 UNF	1.068 3	1.067 9	1.122 4	1.122 0	1.070 1	1.069 7	1.124 2	1.123 8
$1\frac{1}{4}$ — 12 UNF	1.193 3	1.192 9	1.247 4	1.247 0	1.195 1	1.194 7	1.249 2	1.248 8
$1\frac{3}{8}$ — 12 UNF	1.318 2	1.317 8	1.372 3	1.371 9	1.320 1	1.319 7	1.374 2	1.373 8
$1\frac{1}{2}$ — 12 UNF	1.443 2	1.442 8	1.497 3	1.496 9	1.445 1	1.444 7	1.499 2	1.498 8

A) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 32 **Limits of size for NOT GO effective diameter check plugs for new GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Effective diameter[A)]		**Major diameter**		**Effective diameter**[A)]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.226 0	0.225 8	0.233 5	0.233 2	0.227 0	0.226 8	0.234 5	0.234 2
$\frac{5}{16}$ — 24 UNF	0.284 5	0.284 3	0.293 3	0.293 0	0.285 6	0.285 4	0.294 4	0.294 1
$\frac{3}{8}$ — 24 UNF	0.347 0	0.346 8	0.355 8	0.355 5	0.348 1	0.347 9	0.356 9	0.356 6
$\frac{7}{16}$ — 20 UNF	0.403 9	0.403 7	0.414 5	0.414 2	0.405 2	0.405 0	0.415 8	0.415 5
$\frac{1}{2}$ — 20 UNF	0.466 4	0.466 2	0.477 0	0.476 7	0.467 7	0.467 5	0.478 3	0.478 0
$\frac{9}{16}$ — 18 UNF	0.525 3	0.525 0	0.537 0	0.536 6	0.526 7	0.526 4	0.538 4	0.538 0
$\frac{5}{8}$ — 18 UNF	0.587 8	0.587 5	0.599 5	0.599 1	0.589 2	0.588 9	0.600 9	0.600 5
$\frac{3}{4}$ — 16 UNF	0.708 2	0.707 9	0.721 4	0.721 0	0.709 7	0.709 4	0.722 9	0.722 5
$\frac{7}{8}$ — 14 UNF	0.827 3	0.827 0	0.842 5	0.842 1	0.828 9	0.828 6	0.844 1	0.843 7
1 — 12 UNF	0.944 4	0.944 1	0.962 1	0.961 7	0.946 2	0.945 9	0.963 9	0.963 5
$1\frac{1}{8}$ — 12 UNF	1.069 4	1.069 1	1.087 1	1.086 7	1.071 2	1.070 9	1.088 9	1.088 5
$1\frac{1}{4}$ — 12 UNF	1.194 4	1.194 1	1.212 1	1.211 7	1.196 2	1.195 9	1.213 9	1.213 5
$1\frac{3}{8}$ — 12 UNF	1.319 3	1.319 0	1.337 0	1.336 6	1.321 2	1.320 9	1.338 9	1.338 5
$1\frac{1}{2}$ — 12 UNF	1.444 3	1.444 0	1.462 0	1.461 6	1.446 2	1.445 9	1.463 9	1.463 5

A) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 33 **Limits of size for NOT GO effective diameter check plugs for worn GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Effective diameter[A)]		**Major diameter**		**Effective diameter**[A)]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.226 2	0.226 0	0.233 5	0.233 2	0.227 2	0.227 0	0.234 5	0.234 2
$\frac{5}{16}$ — 24 UNF	0.284 7	0.284 5	0.293 3	0.293 0	0.285 8	0.285 6	0.294 4	0.294 1
$\frac{3}{8}$ — 24 UNF	0.347 2	0.347 0	0.355 8	0.355 5	0.348 3	0.348 1	0.356 9	0.356 6
$\frac{7}{16}$ — 20 UNF	0.404 1	0.403 9	0.414 5	0.414 2	0.405 4	0.405 2	0.415 8	0.415 5
$\frac{1}{2}$ — 20 UNF	0.466 6	0.466 4	0.477 0	0.476 7	0.467 9	0.467 7	0.478 3	0.478 0
$\frac{9}{16}$ — 18 UNF	0.525 6	0.525 3	0.537 0	0.536 6	0.527 0	0.526 7	0.538 4	0.538 0
$\frac{5}{8}$ — 18 UNF	0.588 1	0.587 8	0.599 5	0.599 1	0.589 5	0.589 2	0.600 9	0.600 5
$\frac{3}{4}$ — 16 UNF	0.708 5	0.708 2	0.721 4	0.721 0	0.710 0	0.709 7	0.722 9	0.722 5
$\frac{7}{8}$ — 14 UNF	0.827 6	0.827 3	0.842 5	0.842 1	0.829 2	0.828 9	0.844 1	0.843 7
1 — 12 UNF	0.944 7	0.944 4	0.962 1	0.961 7	0.946 5	0.946 2	0.963 9	0.963 5
$1\frac{1}{8}$ — 12 UNF	1.069 7	1.069 4	1.087 1	1.086 7	1.071 5	1.071 2	1.088 9	1.088 5
$1\frac{1}{4}$ — 12 UNF	1.194 7	1.194 4	1.212 1	1.211 7	1.196 5	1.196 2	1.213 9	1.213 5
$1\frac{3}{8}$ — 12 UNF	1.319 6	1.319 3	1.337 0	1.336 6	1.321 5	1.321 2	1.338 9	1.338 5
$1\frac{1}{2}$ — 12 UNF	1.444 6	1.444 3	1.462 0	1.461 6	1.446 5	1.446 2	1.463 9	1.463 5

A) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 34 **Limits of size for GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Effective diameter[A]		**Major diameter**		**Effective diameter**[A]		**Major diameter**		**Effective diameter**[A]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.220 3	0.220 0	0.247 9	0.247 6	0.222 0	0.221 7	0.249 3	0.249 0	0.224 5	0.224 3	0.232 0	0.231 7
$\frac{5}{16}$ — 24 UNF	0.278 3	0.278 0	0.310 3	0.310 0	0.280 1	0.279 8	0.311 7	0.311 4	0.282 9	0.282 7	0.291 7	0.291 7
$\frac{3}{8}$ — 24 UNF	0.340 6	0.340 3	0.372 6	0.372 3	0.342 5	0.342 2	0.374 2	0.373 9	0.345 2	0.345 0	0.354 0	0.353 7
$\frac{7}{16}$ — 20 UNF	0.397 0	0.396 7	0.435 3	0.435 0	0.399 0	0.398 7	0.436 5	0.436 2	0.402 1	0.401 9	0.412 7	0.412 4
$\frac{1}{2}$ — 20 UNF	0.459 3	0.459 0	0.497 6	0.497 3	0.461 4	0.461 1	0.499 0	0.498 7	0.464 5	0.464 3	0.475 1	0.474 8
$\frac{9}{16}$ — 18 UNF	0.517 6	0.517 2	0.560 3	0.559 9	0.519 9	0.519 5	0.561 5	0.561 1	0.523 3	0.523 0	0.535 0	0.534 6
$\frac{5}{8}$ — 18 UNF	0.579 9	0.579 5	0.622 6	0.622 2	0.582 2	0.581 8	0.624 0	0.623 6	0.585 7	0.585 4	0.597 4	0.597 0
$\frac{3}{4}$ — 16 UNF	0.699 8	0.699 4	0.747 7	0.747 3	0.702 3	0.701 9	0.748 9	0.748 5	0.705 9	0.705 6	0.719 1	0.718 7
$\frac{7}{8}$ — 14 UNF	0.818 3	0.817 9	0.872 9	0.872 5	0.821 0	0.820 6	0.873 8	0.873 4	0.824 8	0.824 5	0.840 0	0.839 6
1 — 12 UNF	0.934 7	0.934 3	0.998 2	0.997 8	0.937 6	0.937 2	0.998 6	0.998 2	0.941 8	0.941 5	0.959 5	0.959 1
$1\frac{1}{8}$ — 12 UNF	1.059 5	1.059 1	1.123 0	1.122 6	1.062 5	1.062 1	1.123 6	1.123 2	1.066 7	1.066 4	1.084 4	1.084 0
$1\frac{1}{4}$ — 12 UNF	1.184 3	1.183 9	1.247 8	1.247 4	1.187 3	1.186 9	1.248 6	1.248 2	1.191 6	1.191 3	1.209 3	1.208 9
$1\frac{3}{8}$ — 12 UNF	1.309 0	1.308 6	1.372 5	1.372 1	1.312 1	1.311 7	1.373 5	1.373 1	1.316 5	1.316 2	1.334 2	1.333 8
$1\frac{1}{2}$ — 12 UNF	1.433 8	1.433 4	1.497 3	1.496 9	1.437 0	1.436 6	1.498 5	1.498 1	1.441 4	1.441 1	1.459 1	1.458 7

[A] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 35 **Limits of size for NOT GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Effective diameter[A]		**Major diameter**		**Effective diameter**[A]		**Major diameter**		**Effective diameter**[A]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.221 0	0.220 8	0.228 5	0.228 2	0.222 7	0.222 5	0.230 2	0.229 9	0.223 5	0.223 8	0.250 0	0.250 3
$\frac{5}{16}$ — 24 UNF	0.279 0	0.278 8	0.287 8	0.287 5	0.280 8	0.280 6	0.289 6	0.289 3	0.281 9	0.282 2	0.312 5	0.312 8
$\frac{3}{8}$ — 24 UNF	0.341 3	0.341 1	0.350 1	0.349 8	0.343 2	0.343 0	0.352 0	0.351 7	0.344 2	0.344 5	0.375 0	0.375 3
$\frac{7}{16}$ — 20 UNF	0.397 7	0.397 5	0.408 3	0.408 0	0.399 7	0.399 5	0.410 3	0.410 0	0.401 1	0.401 4	0.437 5	0.437 8
$\frac{1}{2}$ — 20 UNF	0.456 0	0.459 8	0.470 6	0.470 3	0.462 1	0.461 9	0.472 7	0.472 4	0.463 5	0.463 8	0.500 0	0.500 3
$\frac{9}{16}$ — 18 UNF	0.518 5	0.518 2	0.530 2	0.529 8	0.520 8	0.520 5	0.532 5	0.532 1	0.522 0	0.522 4	0.562 5	0.562 9
$\frac{5}{8}$ — 18 UNF	0.580 8	0.580 5	0.592 5	0.592 1	0.583 1	0.582 8	0.594 8	0.594 4	0.584 4	0.584 8	0.625 0	0.625 4
$\frac{3}{4}$ — 16 UNF	0.700 7	0.700 4	0.713 9	0.713 5	0.703 2	0.702 9	0.716 4	0.716 0	0.704 6	0.705 0	0.750 0	0.750 4
$\frac{7}{8}$ — 14 UNF	0.819 2	0.818 9	0.834 4	0.834 0	0.821 9	0.821 6	0.837 1	0.836 7	0.823 5	0.823 9	0.875 0	0.875 4
1 — 12 UNF	0.935 6	0.935 3	0.953 3	0.952 9	0.938 5	0.938 2	0.956 2	0.955 8	0.940 5	0.940 9	1.000 0	1.000 4
$1\frac{1}{8}$ — 12 UNF	1.060 4	1.060 1	1.078 1	1.077 7	1.063 4	1.063 1	1.081 1	1.080 7	1.065 4	1.065 8	1.125 0	1.125 4
$1\frac{1}{4}$ — 12 UNF	1.185 2	1.184 9	1.202 9	1.202 5	1.188 2	1.187 9	1.205 9	1.205 5	1.190 3	1.190 7	1.250 0	1.250 4
$1\frac{3}{8}$ — 12 UNF	1.309 9	1.309 6	1.327 6	1.327 2	1.313 0	1.312 7	1.330 7	1.330 3	1.315 2	1.315 6	1.375 0	1.375 4
$1\frac{1}{2}$ — 12 UNF	1.434 7	1.434 4	1.452 4	1.452 0	1.437 9	1.437 6	1.455 6	1.455 2	1.440 1	1.440 5	1.500 0	1.500 4

[A] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 36 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation	**GO check plugs**				**NOT GO check plugs**			
	Classes 1A and 2A threads		**Class 3A threads**		**Classes 1A and 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.209 7	0.209 6	0.210 7	0.210 6	0.210 4	0.210 3	0.211 4	0.211 3
$\frac{5}{16}$ — 24 UNF	0.265 7	0.265 6	0.266 8	0.266 7	0.266 4	0.266 3	0.267 5	0.267 4
$\frac{3}{8}$ — 24 UNF	0.328 2	0.328 1	0.329 3	0.329 2	0.328 9	0.328 8	0.330 0	0.329 9
$\frac{7}{16}$ — 20 UNF	0.381 5	0.381 4	0.382 8	0.382 7	0.382 2	0.382 1	0.383 5	0.383 4
$\frac{1}{2}$ — 20 UNF	0.444 0	0.443 9	0.445 3	0.445 2	0.444 7	0.444 6	0.446 0	0.445 9
$\frac{9}{16}$ — 18 UNF	0.500 3	0.500 2	0.501 7	0.501 6	0.501 1	0.501 0	0.502 5	0.502 4
$\frac{5}{8}$ — 18 UNF	0.562 8	0.562 7	0.564 2	0.564 1	0.563 6	0.563 5	0.565 0	0.564 9
$\frac{3}{4}$ — 16 UNF	0.680 1	0.680 0	0.681 6	0.681 5	0.680 9	0.680 8	0.682 4	0.682 3
$\frac{7}{8}$ — 14 UNF	0.795 4	0.795 3	0.797 0	0.796 9	0.796 2	0.796 1	0.797 8	0.797 7
1 — 12 UNF	0.907 3	0.907 2	0.909 1	0.909 0	0.908 1	0.908 0	0.909 9	0.909 8
$1\frac{1}{8}$ — 12 UNF	1.032 3	1.032 2	1.034 1	1.034 0	1.033 1	1.033 0	1.034 9	1.034 8
$1\frac{1}{4}$ — 12 UNF	1.157 3	1.157 2	1.159 1	1.159 0	1.158 1	1.158 0	1.159 9	1.159 8
$1\frac{3}{8}$ — 12 UNF	1.282 2	1.282 1	1.284 1	1.284 0	1.283 0	1.282 9	1.284 9	1.284 8
$1\frac{1}{2}$ — 12 UNF	1.407 2	1.407 1	1.409 1	1.409 0	1.408 0	1.407 9	1.409 9	1.409 8

Table 37 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**GO check plugs**						**NOT GO check plugs**					
	Class 1A threads		**Class 2A threads**		**Class 3A threads**		**Class 3A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.213 1	0.213 0	0.214 8	0.214 7	0.216 6	0.216 5	0.213 8	0.213 7	0.215 5	0.215 4	0.217 3	0.217 2
$\frac{5}{16}$ — 24 UNF	0.269 8	0.269 7	0.271 6	0.271 5	0.273 7	0.273 6	0.270 5	0.270 4	0.272 3	0.272 2	0.274 4	0.274 3
$\frac{3}{8}$ — 24 UNF	0.332 1	0.332 0	0.334 0	0.333 9	0.336 0	0.335 9	0.332 8	0.332 7	0.334 7	0.334 6	0.336 7	0.336 6
$\frac{7}{16}$ — 20 UNF	0.386 7	0.386 6	0.388 7	0.388 6	0.391 1	0.391 0	0.387 4	0.387 3	0.389 4	0.389 3	0.391 8	0.391 7
$\frac{1}{2}$ — 20 UNF	0.449 0	0.448 9	0.451 1	0.451 0	0.453 5	0.453 4	0.449 7	0.449 6	0.451 8	0.451 7	0.454 2	0.454 1
$\frac{9}{16}$ — 18 UNF	0.506 2	0.506 1	0.508 5	0.508 4	0.511 0	0.510 9	0.507 0	0.506 9	0.509 3	0.509 2	0.511 8	0.511 7
$\frac{5}{8}$ — 18 UNF	0.568 5	0.568 4	0.570 8	0.570 7	0.573 4	0.573 3	0.569 3	0.569 2	0.571 6	0.571 5	0.574 2	0.574 1
$\frac{3}{4}$ — 16 UNF	0.686 9	0.686 8	0.689 4	0.689 3	0.692 1	0.692 0	0.687 7	0.687 6	0.690 2	0.690 1	0.692 9	0.692 8
$\frac{7}{8}$ — 14 UNF	0.803 4	0.803 3	0.806 1	0.806 0	0.809 0	0.808 9	0.804 2	0.804 1	0.806 9	0.806 8	0.809 8	0.809 7
1 — 12 UNF	0.917 3	0.917 2	0.920 2	0.920 1	0.923 5	0.923 4	0.918 1	0.918 0	0.921 0	0.920 9	0.924 3	0.924 2
$1\frac{1}{8}$ — 12 UNF	1.042 1	1.042 0	1.045 1	1.045 0	1.048 4	1.048 3	1.042 9	1.042 8	1.045 9	1.045 8	1.049 2	1.049 1
$1\frac{1}{4}$ — 12 UNF	1.166 9	1.166 8	1.169 9	1.169 8	1.173 3	1.173 2	1.167 7	1.167 6	1.170 7	1.170 6	1.174 1	1.174 0
$1\frac{3}{8}$ — 12 UNF	1.291 6	1.291 5	1.294 7	1.294 6	1.298 2	1.298 1	1.292 4	1.292 3	1.295 5	1.295 4	1.299 0	1.298 9
$1\frac{1}{2}$ — 12 UNF	1.416 4	1.416 3	1.419 6	1.419 5	1.423 1	1.423 0	1.417 2	1.417 1	1.420 4	1.420 3	1.423 9	1.423 8

Table 38 **Limits of size for adjustable GO screw ring and calliper gauges**

1	2	3	4	5	6
Designation	**Minor diameter**				**Effective diameter**
	Classes 1A and 2A threads		**Class 3A threads**		**All classes of thread**
	Max.	**Min.**	**Max.**	**Min.**	
	in	in	in	in	Since adjustable GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 17 and Table 21 respectively, no limits are given for the effective diameters of these gauges.
$\frac{1}{4}$ — 28 UNF	0.209 8	0.210 3	0.210 8	0.211 3	
$\frac{5}{16}$ — 24 UNF	0.265 8	0.266 3	0.266 9	0.267 4	
$\frac{3}{8}$ — 24 UNF	0.328 3	0.328 8	0.329 4	0.329 9	
$\frac{7}{16}$ — 20 UNF	0.381 6	0.382 1	0.382 9	0.383 4	
$\frac{1}{2}$ — 20 UNF	0.444 1	0.444 6	0.445 4	0.445 9	
$\frac{9}{16}$ — 18 UNF	0.500 5	0.501 0	0.501 9	0.502 4	
$\frac{5}{8}$ — 18 UNF	0.563 0	0.563 5	0.564 4	0.564 9	
$\frac{3}{4}$ — 16 UNF	0.680 2	0.680 8	0.681 7	0.682 3	
$\frac{7}{8}$ — 14 UNF	0.795 5	0.796 1	0.797 1	0.797 7	
1 — 12 UNF	0.907 4	0.908 0	0.909 2	0.909 8	
$1\frac{1}{8}$ — 12 UNF	1.032 4	1.033 0	1.034 2	1.034 8	
$1\frac{1}{4}$ — 12 UNF	1.157 4	1.158 0	1.159 2	1.159 8	
$1\frac{3}{8}$ — 12 UNF	1.282 3	1.282 9	1.284 2	1.284 8	
$1\frac{1}{2}$ — 12 UNF	1.407 3	1.407 9	1.409 2	1.409 8	

Table 39 **Limits of size for adjustable NOT GO screw ring and calliper gauges**

1	2	3	4	5	6	7	8
Designation	**Minor diameter**						**Effective diameter**
	Class 1A threads		**Class 2A threads**		**Class 3A threads**		**All classes of thread**
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	
	in	in	in	in	in	in	Since adjustable NOT GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 22 and Table 24 respectively, no limits are given for the effective diameters of these gauges.
$\frac{1}{4}$ — 28 UNF	0.213 1	0.213 6	0.214 8	0.215 3	0.216 6	0.217 1	
$\frac{5}{16}$ — 24 UNF	0.269 8	0.270 3	0.271 6	0.272 1	0.273 7	0.274 2	
$\frac{3}{8}$ — 24 UNF	0.332 1	0.332 6	0.334 0	0.334 5	0.336 0	0.336 5	
$\frac{7}{16}$ — 20 UNF	0.386 7	0.387 2	0.388 7	0.389 2	0.391 1	0.391 6	
$\frac{1}{2}$ — 20 UNF	0.449 0	0.449 5	0.451 1	0.451 6	0.453 5	0.454 0	
$\frac{9}{16}$ — 18 UNF	0.506 2	0.506 7	0.508 5	0.509 0	0.511 0	0.511 5	
$\frac{5}{8}$ — 18 UNF	0.568 5	0.569 0	0.570 8	0.571 3	0.573 4	0.573 9	
$\frac{3}{4}$ — 16 UNF	0.686 9	0.687 5	0.689 4	0.690 0	0.692 1	0.692 7	
$\frac{7}{8}$ — 14 UNF	0.803 4	0.804 0	0.806 1	0.806 7	0.809 0	0.809 6	
1 — 12 UNF	0.917 3	0.917 9	0.920 2	0.920 8	0.923 5	0.924 1	
$1\frac{1}{8}$ — 12 UNF	1.042 1	1.042 7	1.045 1	1.045 7	1.048 4	1.049 0	
$1\frac{1}{4}$ — 12 UNF	1.166 9	1.167 5	1.169 9	1.170 5	1.173 3	1.173 9	
$1\frac{3}{8}$ — 12 UNF	1.291 6	1.292 2	1.294 7	1.295 3	1.298 2	1.298 8	
$1\frac{1}{2}$ — 12 UNF	1.416 4	1.417 0	1.419 6	1.420 2	1.423 1	1.423 7	

Table 40 **Limits of size for double length setting plugs for adjustable GO screw ring gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Classes 1A and 2A threads**						**Class 3A threads**					
	Major diameter				**Effective diameter**		**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**		**Full flank portion**		**Truncated portion**		**Both portions**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.249 5	0.249 0	0.241 9	0.241 4	0.225 8	0.225 7	0.250 5	0.250 0	0.242 9	0.242 4	0.226 8	0.226 7
$\frac{5}{16}$ — 24 UNF	0.311 9	0.311 4	0.303 5	0.303 0	0.284 3	0.284 2	0.313 0	0.312 5	0.304 6	0.304 1	0.285 4	0.285 3
$\frac{3}{8}$ — 24 UNF	0.374 4	0.373 9	0.366 0	0.365 5	0.346 8	0.346 7	0.375 5	0.375 0	0.367 1	0.366 6	0.347 9	0.347 8
$\frac{7}{16}$ — 20 UNF	0.436 7	0.436 2	0.427 2	0.426 7	0.403 7	0.403 6	0.438 0	0.437 5	0.428 5	0.428 0	0.405 0	0.404 9
$\frac{1}{2}$ — 20 UNF	0.499 2	0.498 7	0.489 7	0.489 2	0.466 2	0.466 1	0.500 5	0.500 0	0.491 0	0.490 5	0.467 5	0.467 4
$\frac{9}{16}$ — 18 UNF	0.561 6	0.561 1	0.551 4	0.550 9	0.525 00	0.524 85	0.563 0	0.562 5	0.552 8	0.552 3	0.526 40	0.526 25
$\frac{5}{8}$ — 18 UNF	0.624 1	0.623 6	0.613 9	0.613 4	0.587 50	0.587 35	0.625 5	0.625 0	0.615 3	0.614 8	0.588 90	0.588 75
$\frac{3}{4}$ — 16 UNF	0.749 1	0.748 5	0.738 0	0.737 4	0.707 9	0.707 7	0.750 6	0.750 0	0.739 5	0.738 9	0.709 4	0.709 2
$\frac{7}{8}$ — 14 UNF	0.874 0	0.873 4	0.861 9	0.861 3	0.827 0	0.826 8	0.875 6	0.875 0	0.863 5	0.862 9	0.828 6	0.828 4
1 — 12 UNF	0.998 8	0.998 2	0.985 3	0.984 7	0.944 1	0.943 9	1.000 6	1.000 0	0.987 1	0.986 5	0.945 9	0.945 7
$1\frac{1}{8}$ —12 UNF	1.123 8	1.123 2	1.110 3	1.109 7	1.069 1	1.068 9	1.125 6	1.125 0	1.112 1	1.111 5	1.070 9	1.070 7
$1\frac{1}{4}$ — 12 UNF	1.248 8	1.248 2	1.235 3	1.234 7	1.194 1	1.193 9	1.250 6	1.250 0	1.237 1	1.236 5	1.195 9	1.195 7
$1\frac{3}{8}$ — 12 UNF	1.373 7	1.373 1	1.360 2	1.359 6	1.319 0	1.318 8	1.375 6	1.375 0	1.362 1	1.361 5	1.320 9	1.320 7
$1\frac{1}{2}$ —12 UNF	1.498 7	1.498 1	1.485 2	1.484 6	1.444 0	1.443 8	1.500 6	1.500 0	1.487 1	1.486 5	1.445 9	1.445 7

Table 41 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 1A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.248 1	0.247 6	0.236 3	0.235 8	0.220 8	0.220 7
$\frac{5}{16}$ — 24 UNF	0.310 5	0.310 0	0.296 8	0.296 3	0.278 8	0.278 7
$\frac{3}{8}$ — 24 UNF	0.372 9	0.372 4	0.359 1	0.358 6	0.341 1	0.341 0
$\frac{7}{16}$ — 20 UNF	0.435 5	0.435 0	0.419 2	0.418 7	0.397 5	0.397 4
$\frac{1}{2}$ — 20 UNF	0.497 8	0.497 3	0.481 5	0.481 0	0.459 8	0.459 7
$\frac{9}{16}$ — 18 UNF	0.560 4	0.559 9	0.542 3	0.541 8	0.518 20	0.518 05
$\frac{5}{8}$ — 18 UNF	0.622 7	0.622 2	0.604 6	0.604 1	0.580 50	0.580 35
$\frac{3}{4}$ — 16 UNF	0.747 9	0.747 3	0.727 5	0.726 9	0.700 4	0.700 2
$\frac{7}{8}$ — 14 UNF	0.873 1	0.872 5	0.849 8	0.849 2	0.818 9	0.818 7
1 — 12 UNF	0.998 4	0.997 8	0.971 4	0.970 8	0.935 3	0.935 1
$1\frac{1}{8}$ — 12 UNF	1.123 2	1.122 6	1.096 2	1.095 6	1.060 1	1.059 9
$1\frac{1}{4}$ — 12 UNF	1.248 0	1.247 4	1.221 0	1.220 4	1.184 9	1.184 7
$1\frac{3}{8}$ — 12 UNF	1.372 7	1.372 1	1.345 7	1.345 1	1.309 6	1.309 4
$1\frac{1}{2}$ — 12 UNF	1.497 5	1.496 9	1.470 5	1.469 9	1.434 4	1.434 2

Table 42 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 2A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.249 5	0.249 0	0.238 0	0.237 5	0.222 5	0.222 4
$\frac{5}{16}$ — 24 UNF	0.311 9	0.311 4	0.298 6	0.298 1	0.280 6	0.280 5
$\frac{3}{8}$ — 24 UNF	0.374 4	0.373 9	0.361 0	0.360 5	0.343 0	0.342 9
$\frac{7}{16}$ — 20 UNF	0.436 7	0.436 2	0.421 2	0.420 7	0.399 5	0.399 4
$\frac{1}{2}$ — 20 UNF	0.499 2	0.498 7	0.483 6	0.483 1	0.461 9	0.461 8
$\frac{9}{16}$ — 18 UNF	0.561 6	0.561 1	0.544 6	0.544 1	0.520 50	0.520 35
$\frac{5}{8}$ — 18 UNF	0.624 1	0.623 6	0.606 9	0.606 4	0.582 80	0.582 65
$\frac{3}{4}$ — 16 UNF	0.749 1	0.748 5	0.730 0	0.729 4	0.702 9	0.702 7
$\frac{7}{8}$ — 14 UNF	0.874 0	0.873 4	0.852 5	0.851 9	0.821 6	0.821 4
1 — 12 UNF	0.998 8	0.998 2	0.974 3	0.973 7	0.938 2	0.938 0
$1\frac{1}{8}$ — 12 UNF	1.123 8	1.123 2	1.099 2	1.098 6	1.063 1	1.062 9
$1\frac{1}{4}$ — 12 UNF	1.248 8	1.248 2	1.224 0	1.223 4	1.187 9	1.187 7
$1\frac{3}{8}$ — 12 UNF	1.373 7	1.373 1	1.348 8	1.348 2	1.312 7	1.312 5
$1\frac{1}{2}$ — 12 UNF	1.498 7	1.498 1	1.473 7	1.473 1	1.437 6	1.437 4

Table 43 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges, Class 3A threads**

1	2	3	4	5	6	7
Designation	**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.250 5	0.250 0	0.239 8	0.239 3	0.224 3	0.224 2
$\frac{5}{16}$ — 24 UNF	0.313 0	0.312 5	0.300 7	0.300 2	0.282 7	0.282 6
$\frac{3}{8}$ — 24 UNF	0.375 5	0.375 0	0.363 0	0.362 5	0.345 0	0.344 9
$\frac{7}{16}$ — 20 UNF	0.438 0	0.437 5	0.423 6	0.423 1	0.401 9	0.401 8
$\frac{1}{2}$ — 20 UNF	0.500 5	0.500 0	0.486 0	0.485 5	0.464 3	0.464 2
$\frac{9}{16}$ — 18 UNF	0.563 0	0.562 5	0.547 1	0.546 6	0.523 00	0.522 85
$\frac{5}{8}$ — 18 UNF	0.625 5	0.625 0	0.609 5	0.609 0	0.585 40	0.585 25
$\frac{3}{4}$ — 16 UNF	0.750 6	0.750 0	0.732 7	0.732 1	0.705 6	0.705 4
$\frac{7}{8}$ — 14 UNF	0.875 6	0.875 0	0.855 4	0.854 8	0.824 5	0.824 3
1 — 12 UNF	1.000 6	1.000 0	0.977 6	0.977 0	0.941 5	0.941 3
$1\frac{1}{8}$ — 12 UNF	1.125 6	1.125 0	1.102 5	1.101 9	1.066 4	1.066 2
$1\frac{1}{4}$ — 12 UNF	1.250 6	1.250 0	1.227 4	1.226 8	1.191 3	1.191 1
$1\frac{3}{8}$ — 12 UNF	1.375 6	1.375 0	1.352 3	1.351 7	1.316 2	1.316 0
$1\frac{1}{2}$ — 12 UNF	1.500 6	1.500 0	1.477 2	1.476 6	1.441 1	1.440 9

Table 44 **Limits of size for single length setting plugs for adjustable GO screw calliper gauges**

1	2	3	4	5	6	7	8	9
Designation	**Classes 1A and 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$— 28 UNF	0.241 9	0.240 9	0.225 4	0.225 2	0.242 9	0.241 9	0.226 4	0.226 2
$\frac{5}{16}$ — 24 UNF	0.303 1	0.302 1	0.283 9	0.283 7	0.304 2	0.303 2	0.285 0	0.284 8
$\frac{3}{8}$ — 24 UNF	0.365 6	0.364 6	0.346 4	0.346 2	0.366 7	0.365 7	0.347 5	0.347 3
$\frac{7}{16}$ — 20 UNF	0.426 2	0.425 2	0.403 3	0.403 1	0.427 5	0.426 5	0.404 6	0.404 4
$\frac{1}{2}$ — 20 UNF	0.488 7	0.487 7	0.465 8	0.465 6	0.490 0	0.489 0	0.467 1	0.466 9
$\frac{9}{16}$ — 18 UNF	0.550 0	0.549 0	0.524 4	0.524 2	0.551 4	0.550 4	0.525 8	0.525 6
$\frac{5}{8}$ — 18 UNF	0.612 5	0.611 5	0.586 9	0.586 7	0.613 9	0.612 9	0.588 3	0.588 1
$\frac{3}{4}$ — 16 UNF	0.736 0	0.735 0	0.707 3	0.707 1	0.737 5	0.736 5	0.708 8	0.708 6
$\frac{7}{8}$ — 14 UNF	0.859 1	0.858 1	0.826 4	0.826 2	0.860 7	0.859 7	0.828 0	0.827 8
1 — 12 UNF	0.981 5	0.980 5	0.943 5	0.943 3	0.983 3	0.982 3	0.945 3	0.945 1
$1\frac{1}{8}$ — 12 UNF	1.106 5	1.105 5	1.068 5	1.068 3	1.108 3	1.107 3	1.070 3	1.070 1
$1\frac{1}{4}$ — 12 UNF	1.231 5	1.230 5	1.193 5	1.193 3	1.233 3	1.232 3	1.195 3	1.195 1
$1\frac{3}{8}$ — 12 UNF	1.356 4	1.355 4	1.318 4	1.318 2	1.358 3	1.357 3	1.320 3	1.320 1
$1\frac{1}{2}$ — 12 UNF	1.481 4	1.480 4	1.443 4	1.443 2	1.483 3	1.482 3	1.445 3	1.445 1

Table 45 **Limits of size for single length setting plugs for adjustable NOT GO screw calliper gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation	**Class 1A threads**				**Class 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.241 9	0.240 9	0.220 5	0.220 3	0.241 9	0.240 9	0.222 2	0.222 0	0.242 9	0.241 9	0.224 0	0.223 8
$\frac{5}{16}$ — 24 UNF	0.303 1	0.302 1	0.278 5	0.278 3	0.303 1	0.302 1	0.280 3	0.280 1	0.304 2	0.303 2	0.282 4	0.282 2
$\frac{3}{8}$ — 24 UNF	0.365 6	0.364 6	0.340 8	0.340 6	0.365 6	0.364 6	0.342 7	0.342 5	0.366 7	0.365 7	0.344 7	0.344 5
$\frac{7}{16}$ — 20 UNF	0.426 2	0.425 2	0.397 2	0.397 0	0.426 2	0.425 2	0.399 2	0.399 0	0.427 5	0.426 5	0.401 6	0.401 4
$\frac{1}{2}$ — 20 UNF	0.488 7	0.487 7	0.459 5	0.459 3	0.488 7	0.487 7	0.461 6	0.461 4	0.490 0	0.489 0	0.464 0	0.463 8
$\frac{9}{16}$ — 18 UNF	0.550 0	0.549 0	0.517 8	0.517 6	0.550 0	0.549 0	0.520 1	0.519 9	0.551 4	0.550 4	0.522 6	0.522 4
$\frac{5}{8}$ — 18 UNF	0.612 5	0.611 5	0.580 1	0.579 9	0.612 5	0.611 5	0.582 4	0.582 2	0.613 9	0.612 9	0.585 0	0.584 8
$\frac{3}{4}$ — 16 UNF	0.736 0	0.735 0	0.700 0	0.699 8	0.736 0	0.735 0	0.702 5	0.702 3	0.737 5	0.736 5	0.705 2	0.705 0
$\frac{7}{8}$ — 14 UNF	0.859 1	0.858 1	0.818 5	0.818 3	0.859 1	0.858 1	0.821 2	0.821 0	0.860 7	0.859 7	0.824 1	0.823 9
1 — 12 UNF	0.981 5	0.980 5	0.934 9	0.934 7	0.981 5	0.980 5	0.937 8	0.937 6	0.983 3	0.982 3	0.941 1	0.940 9
$1\frac{1}{8}$ — 12 UNF	1.106 5	1.105 5	1.059 7	1.059 5	1.106 5	1.105 5	1.062 7	1.062 5	1.108 3	1.107 3	1.066 0	1.065 8
$1\frac{1}{4}$ — 12 UNF	1.231 5	1.230 5	1.184 5	1.184 3	1.231 5	1.230 5	1.187 5	1.187 3	1.233 3	1.232 3	1.190 9	1.190 7
$1\frac{3}{8}$ — 12 UNF	1.356 4	1.355 4	1.309 2	1.309 0	1.356 4	1.355 4	1.312 3	1.312 1	1.358 3	1.357 3	1.315 8	1.315 6
$1\frac{1}{2}$ — 12 UNF	1.481 4	1.480 4	1.434 0	1.433 8	1.481 4	1.480 4	1.437 2	1.437 0	1.483 3	1.482 3	1.440 7	1.440 5

Table 46 **Limits of size for GO and NOT GO plain calliper (GAP) gauges for major diameters**

1	2	3	4	5	6	7	8	9	10	11
Designation	**GO gauges**				**NOT GO gauges**					
	Class 1A threads		**Class 3A threads**		**Class 1A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 28 UNF	0.248 7	0.249 0	0.249 7	0.250 0	0.238 9	0.239 2	0.242 2	0.242 5	0.243 2	0.243 5
$\frac{5}{16}$ — 24 UNF	0.311 1	0.311 4	0.312 2	0.312 5	0.300 3	0.300 6	0.303 9	0.304 2	0.305 0	0.305 3
$\frac{3}{8}$ — 24 UNF	0.373 6	0.373 9	0.374 7	0.375 0	0.362 8	0.363 1	0.366 4	0.366 7	0.367 5	0.367 8
$\frac{7}{16}$ — 20 UNF	0.435 9	0.436 2	0.437 2	0.437 5	0.423 7	0.424 0	0.427 8	0.428 1	0.429 1	0.429 4
$\frac{1}{2}$ — 20 UNF	0.498 4	0.498 7	0.499 7	0.500 0	0.486 2	0.486 5	0.490 3	0.490 6	0.491 6	0.491 9
$\frac{9}{16}$ — 18 UNF	0.560 8	0.561 1	0.562 2	0.562 5	0.547 7	0.548 0	0.552 1	0.552 4	0.553 5	0.553 8
$\frac{5}{8}$ — 18 UNF	0.623 3	0.623 6	0.624 7	0.625 0	0.610 2	0.610 5	0.614 6	0.614 9	0.616 0	0.616 3
$\frac{3}{4}$ — 16 UNF	0.748 2	0.748 5	0.749 7	0.750 0	0.734 0	0.734 3	0.738 8	0.739 1	0.740 3	0.740 6
$\frac{7}{8}$ — 14 UNF	0.873 1	0.873 4	0.874 7	0.875 0	0.857 6	0.857 9	0.862 8	0.863 1	0.864 4	0.864 7
1 — 12 UNF	0.997 9	0.998 2	0.999 7	1.000 0	0.980 7	0.981 0	0.986 5	0.986 8	0.988 3	0.988 6
$1\frac{1}{8}$ — 12 UNF	1.122 9	1.123 2	1.124 7	1.125 0	1.105 7	1.106 0	1.111 5	1.111 8	1.113 3	1.113 6
$1\frac{1}{4}$ — 12 UNF	1.247 9	1.248 2	1.249 7	1.250 0	1.230 7	1.231 0	1.236 5	1.236 8	1.238 3	1.238 6
$1\frac{3}{8}$ — 12 UNF	1.372 8	1.373 1	1.374 7	1.375 0	1.355 6	1.355 9	1.361 4	1.361 7	1.363 3	1.363 6
$1\frac{1}{2}$ — 12 UNF	1.497 8	1.498 1	1.499 7	1.500 0	1.480 6	1.480 9	1.486 4	1.486 7	1.488 3	1.488 6

Section 3: Unified extra fine threads, UNEF

Table 47 **Limits of size for GO screw plug gauges (Classes 2B and 3B threads)**

1	2	3	4	5
Designation[A)]	**Major diameter**		**Effective diameter**	
	Max.	**Min.**	**Max.**	**Min.**
	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.250 5	0.250 0	0.230 0	0.229 7
$\frac{5}{16}$ — 32 UNEF	0.313 0	0.312 5	0.292 5	0.292 2
$\frac{3}{8}$ — 32 UNEF	0.375 5	0.375 0	0.355 0	0.354 7
$\frac{7}{16}$ — 28 UNEF	0.438 0	0.437 5	0.414 6	0.414 3
$\frac{1}{2}$ — 28 UNEF	0.500 5	0.500 0	0.477 1	0.476 8
$\frac{9}{16}$ — 24 UNEF	0.563 0	0.562 5	0.535 7	0.535 4
$\frac{5}{8}$ — 24 UNEF	0.625 5	0.625 0	0.598 2	0.597 9
($\frac{11}{16}$ — 24 UNEF)	0.688 0	0.687 5	0.660 7	0.660 4
$\frac{3}{4}$ — 20 UNEF	0.750 5	0.750 0	0.717 8	0.717 5
($\frac{13}{16}$ — 20 UNEF)	0.813 0	0.812 5	0.780 3	0.780 0
$\frac{7}{8}$ — 20 UNEF	0.875 5	0.875 0	0.842 8	0.842 5
($\frac{15}{16}$ — 20 UNEF)	0.938 0	0.937 5	0.905 3	0.905 0
1 — 20 UNEF	1.000 5	1.000 0	0.967 8	0.967 5
(1$\frac{1}{16}$ — 18 UNEF)	1.063 0	1.062 5	1.026 7	1.026 4
1$\frac{1}{8}$ — 18 UNEF	1.125 5	1.125 0	1.089 2	1.088 9
(1$\frac{3}{16}$ — 18 UNEF)	1.188 0	1.187 5	1.151 7	1.151 4
1$\frac{1}{4}$ — 18 UNEF	1.250 5	1.250 0	1.214 2	1.213 9
(1$\frac{5}{16}$ — 18 UNEF)	1.313 0	1.312 5	1.276 7	1.276 4
1$\frac{3}{8}$ — 18 UNEF	1.375 5	1.375 0	1.339 2	1.338 9
(1$\frac{7}{16}$ — 18 UNEF)	1.438 0	1.437 5	1.401 7	1.401 4
1$\frac{1}{2}$ — 18 UNEF	1.500 5	1.500 0	1.464 2	1.463 9
(1$\frac{9}{16}$ — 18 UNEF)	1.563 0	1.562 5	1.526 8	1.526 4
1$\frac{5}{8}$ — 18 UNEF	1.625 5	1.625 0	1.589 3	1.588 9
(1$\frac{11}{16}$ — 18 UNEF)	1.688 0	1.687 5	1.651 8	1.651 4

A) Sizes in brackets are shown as second choice in BS 1580.

Table 48 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 2B threads**

1	2	3	4	5	6	7
Designation[A)]	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.240 7	0.240 2	0.247 4	0.246 9	0.234 2	0.233 9
$\frac{5}{16}$ — 32 UNEF	0.303 2	0.302 7	0.309 9	0.309 4	0.296 7	0.296 4
$\frac{3}{8}$ — 32 UNEF	0.365 9	0.365 4	0.372 6	0.372 1	0.359 4	0.359 1
$\frac{7}{16}$ — 28 UNEF	0.426 6	0.426 1	0.434 4	0.433 9	0.419 2	0.418 9
$\frac{1}{2}$ — 28 UNEF	0.489 3	0.488 8	0.497 1	0.496 6	0.481 9	0.481 6
$\frac{9}{16}$ — 24 UNEF	0.549 5	0.549 0	0.558 5	0.558 0	0.540 8	0.540 5
$\frac{5}{8}$ — 24 UNEF	0.612 1	0.611 6	0.621 1	0.620 6	0.603 4	0.603 1
($\frac{11}{16}$ — 24 UNEF)	0.674 6	0.674 1	0.683 6	0.683 1	0.665 9	0.665 6
$\frac{3}{4}$ — 20 UNEF	0.734 0	0.733 5	0.744 9	0.744 4	0.723 5	0.723 2
($\frac{13}{16}$ — 20 UNEF)	0.796 5	0.796 0	0.807 4	0.806 9	0.786 0	0.785 7
$\frac{7}{8}$ — 20 UNEF	0.859 0	0.858 5	0.869 9	0.869 4	0.848 5	0.848 2
($\frac{15}{16}$ — 20 UNEF)	0.921 7	0.921 2	0.932 6	0.932 1	0.911 2	0.910 9
1 — 20 UNEF	0.984 2	0.983 7	0.995 1	0.994 6	0.973 7	0.973 4
($1\frac{1}{16}$ — 18 UNEF)	1.044 6	1.044 1	1.056 7	1.056 2	1.032 9	1.032 6
$1\frac{1}{8}$ — 18 UNEF	1.107 1	1.106 6	1.119 2	1.118 7	1.095 4	1.095 1
($1\frac{3}{16}$ — 18 UNEF)	1.169 7	1.169 2	1.181 8	1.181 3	1.158 0	1.157 7
$1\frac{1}{4}$ — 18 UNEF	1.232 2	1.231 7	1.244 3	1.243 8	1.220 5	1.220 2
($1\frac{5}{16}$ — 18 UNEF)	1.294 7	1.294 2	1.306 8	1.306 3	1.283 0	1.282 7
$1\frac{3}{8}$ — 18 UNEF	1.357 2	1.356 7	1.369 3	1.368 8	1.345 5	1.345 2
($1\frac{7}{16}$ — 18 UNEF)	1.419 9	1.419 4	1.432 0	1.431 5	1.408 2	1.407 9
$1\frac{1}{2}$ — 18 UNEF	1.482 4	1.481 9	1.494 5	1.494 0	1.470 7	1.470 4
($1\frac{9}{16}$ — 18 UNEF)	1.544 9	1.544 4	1.557 0	1.556 5	1.533 3	1.532 9
$1\frac{5}{8}$ — 18 UNEF	1.607 4	1.606 9	1.619 5	1.619 0	1.595 8	1.595 4
($1\frac{11}{16}$ — 18 UNEF)	1.670 0	1.669 5	1.682 1	1.681 6	1.658 4	1.658 0

[A)] Sizes in brackets are shown as second choice in BS 1580.

Table 49 **Limits of size for NOT GO screw plug gauges (low addendum and high addendum), Class 3B threads**

1	2	3	4	5	6	7
Designation[A)]	**Major diameter**				**Effective diameter**	
	Low addendum		**High addendum**		**Both types**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.239 6	0.239 1	0.246 3	0.245 8	0.233 1	0.232 8
$\frac{5}{16}$ — 32 UNEF	0.302 1	0.301 6	0.308 8	0.308 3	0.295 6	0.295 3
$\frac{3}{8}$ — 32 UNEF	0.364 8	0.364 3	0.371 5	0.371 0	0.358 3	0.358 0
$\frac{7}{16}$ — 28 UNEF	0.425 5	0.425 0	0.433 3	0.432 8	0.418 1	0.417 8
$\frac{1}{2}$ — 28 UNEF	0.488 1	0.487 6	0.495 9	0.495 4	0.480 7	0.480 8
$\frac{9}{16}$ — 24 UNEF	0.548 2	0.547 7	0.557 2	0.556 7	0.539 5	0.539 2
$\frac{5}{8}$ — 24 UNEF	0.610 8	0.610 3	0.619 8	0.619 3	0.602 1	0.601 8
($\frac{11}{16}$ — 24 UNEF)	0.673 3	0.672 8	0.682 3	0.681 8	0.664 6	0.664 3
$\frac{3}{4}$ — 20 UNEF	0.732 6	0.732 1	0.743 5	0.743 0	0.722 1	0.721 8
($\frac{13}{16}$ — 20 UNEF)	0.795 1	0.794 6	0.806 0	0.805 5	0.784 6	0.784 3
$\frac{7}{8}$ — 20 UNEF	0.857 6	0.857 1	0.868 5	0.868 0	0.847 1	0.846 8
($\frac{15}{16}$ — 20 UNEF)	0.920 2	0.919 7	0.931 1	0.930 6	0.909 7	0.909 4
1 — 20 UNEF	0.982 7	0.982 2	0.993 6	0.993 1	0.972 2	0.971 9
($1\frac{1}{16}$ — 18 UNEF)	1.043 0	1.042 5	1.055 1	1.054 6	1.031 3	1.031 0
$1\frac{1}{8}$ — 18 UNEF	1.105 5	1.105 0	1.117 6	1.117 1	1.093 8	1.093 5
($1\frac{3}{16}$ — 18 UNEF)	1.168 1	1.167 6	1.180 2	1.179 7	1.156 4	1.156 1
$1\frac{1}{4}$ — 18 UNEF	1.230 6	1.230 1	1.242 7	1.242 2	1.218 9	1.218 6
($1\frac{5}{16}$ — 18 UNEF)	1.293 1	1.292 6	1.305 2	1.304 7	1.281 4	1.281 1
$1\frac{3}{8}$ — 18 UNEF	1.355 6	1.355 1	1.367 7	1.367 2	1.343 9	1.343 6
($1\frac{7}{16}$ — 18 UNEF)	1.418 2	1.417 7	1.430 3	1.429 8	1.406 5	1.406 2
$1\frac{1}{2}$ — 18 UNEF	1.480 7	1.480 2	1.492 8	1.492 3	1.469 0	1.468 7
($1\frac{9}{16}$ — 18 UNEF)	1.543 2	1.542 7	1.555 3	1.554 8	1.531 6	1.531 2
$1\frac{5}{8}$ — 18 UNEF	1.605 7	1.605 2	1.617 8	1.617 3	1.594 1	1.593 7
($1\frac{11}{16}$ — 18 UNEF)	1.668 3	1.667 8	1.680 4	1.679 9	1.656 7	1.656 3

A) Sizes in brackets are shown as second choice in BS 1580.

Table 50 **Limits of size for GO and NOT GO plain plug gauges for minor diameters**

1	2	3	4	5	6	7
Designation[A)]	**GO gauges**		**NOT GO gauges**			
	Classes 2B and 3B thread		**Classes 1B and 2B threads**		**Class 3B threads**	
	Max.	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**
	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.216 5	0.216 2	0.223 9	0.223 6	0.223 2	0.222 9
$\frac{5}{16}$ — 32 UNEF	0.279 0	0.278 7	0.286 4	0.286 1	0.285 0	0.284 7
$\frac{3}{8}$ — 32 UNEF	0.341 5	0.341 2	0.348 9	0.348 6	0.347 2	0.346 9
$\frac{7}{16}$ — 28 UNEF	0.399 1	0.398 8	0.407 5	0.407 2	0.405 4	0.405 1
$\frac{1}{2}$ — 28 UNEF	0.461 6	0.461 3	0.470 0	0.469 7	0.467 9	0.467 6
$\frac{9}{16}$ — 24 UNEF	0.517 7	0.517 4	0.527 4	0.527 1	0.524 7	0.524 4
$\frac{5}{8}$ — 24 UNEF	0.580 2	0.579 9	0.589 9	0.589 6	0.587 2	0.586 9
($\frac{11}{16}$ — 24 UNEF)	0.642 7	0.642 4	0.652 4	0.652 1	0.649 7	0.649 4
$\frac{3}{4}$ — 20 UNEF	0.696 2	0.695 9	0.707 7	0.707 4	0.704 0	0.703 7
($\frac{13}{16}$ — 20 UNEF)	0.758 7	0.758 4	0.770 2	0.769 9	0.766 5	0.766 2
$\frac{7}{8}$ — 20 UNEF	0.821 2	0.820 9	0.832 7	0.832 4	0.829 0	0.828 7
($\frac{15}{16}$ — 20 UNEF)	0.883 7	0.883 4	0.895 2	0.894 9	0.891 5	0.891 2
1 — 20 UNEF	0.946 2	0.945 9	0.957 7	0.957 4	0.954 0	0.953 7
($1\frac{1}{16}$ — 18 UNEF)	1.002 7	1.002 4	1.015 4	1.015 1	1.010 8	1.010 5
$1\frac{1}{8}$ — 18 UNEF	1.065 2	1.064 9	1.077 9	1.077 6	1.073 3	1.073 0
($1\frac{3}{16}$ — 18 UNEF)	1.127 7	1.127 4	1.140 4	1.140 1	1.135 8	1.135 5
$1\frac{1}{4}$ — 18 UNEF	1.190 2	1.189 9	1.202 9	1.202 6	1.198 3	1.198 0
($1\frac{5}{16}$ — 18 UNEF)	1.252 7	1.252 4	1.265 4	1.265 1	1.260 8	1.260 5
$1\frac{3}{8}$ — 18 UNEF	1.315 2	1.314 9	1.327 9	1.327 6	1.323 3	1.323 0
($1\frac{7}{16}$ — 18 UNEF)	1.377 7	1.377 4	1.390 4	1.390 1	1.385 8	1.385 5
$1\frac{1}{2}$ — 18 UNEF	1.440 2	1.439 9	1.452 9	1.452 6	1.448 3	1.448 0
($1\frac{9}{16}$ — 18 UNEF)	1.502 8	1.502 4	1.515 5	1.515 1	1.510 9	1.510 5
$1\frac{5}{8}$ — 18 UNEF	1.565 3	1.564 9	1.578 0	1.577 6	1.573 4	1.573 0
($1\frac{11}{16}$ — 18 UNEF)	1.627 8	1.627 4	1.640 5	1.640 1	1.635 9	1.635 5

A) Sizes in brackets are shown as second choice in BS 1580.

Table 51 **Limits of size for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A)]	**Class 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.214 6	0.215 2	0.228 1	0.228 7	0.215 6	0.216 2	0.229 1	0.229 7
$\frac{5}{16}$ — 32 UNEF	0.277 1	0.277 7	0.290 6	0.291 2	0.278 1	0.278 7	0.291 6	0.292 2
$\frac{3}{8}$ — 32 UNEF	0.339 6	0.340 2	0.353 1	0.353 7	0.340 6	0.341 2	0.354 1	0.354 7
$\frac{7}{16}$ — 28 UNEF	0.397 1	0.397 7	0.412 6	0.413 2	0.398 2	0.398 8	0.413 7	0.414 3
$\frac{1}{2}$ — 28 UNEF	0.459 6	0.460 2	0.475 1	0.475 7	0.460 7	0.461 3	0.476 2	0.476 8
$\frac{9}{16}$ — 24 UNEF	0.515 5	0.516 2	0.533 5	0.534 2	0.516 7	0.517 4	0.534 7	0.535 4
$\frac{5}{8}$ — 24 UNEF	0.578 0	0.578 7	0.596 0	0.596 7	0.579 2	0.579 9	0.597 2	0.597 9
($\frac{11}{16}$ — 24 UNEF)	0.640 5	0.641 2	0.658 5	0.659 2	0.641 7	0.642 4	0.659 7	0.660 4
$\frac{3}{4}$ — 20 UNEF	0.693 9	0.694 6	0.715 4	0.716 2	0.695 2	0.695 9	0.716 7	0.717 5
($\frac{13}{16}$ — 20 UNEF)	0.756 4	0.757 1	0.777 9	0.778 7	0.757 7	0.758 4	0.779 2	0.780 0
$\frac{7}{8}$ — 20 UNEF	0.818 9	0.819 6	0.840 4	0.841 2	0.820 2	0.820 9	0.841 7	0.842 5
($\frac{15}{16}$ — 20 UNEF)	0.881 3	0.882 0	0.902 8	0.903 6	0.882 7	0.883 4	0.904 2	0.905 0
1 — 20 UNEF	0.943 8	0.944 5	0.965 3	0.966 1	0.945 2	0.945 9	0.966 7	0.967 5
($1\frac{1}{16}$ — 18 UNEF)	1.000 3	1.001 0	1.024 2	1.025 0	1.001 7	1.002 4	1.025 6	1.026 4
$1\frac{1}{8}$ — 18 UNEF	1.062 8	1.063 5	1.086 7	1.087 5	1.064 2	1.064 9	1.088 1	1.088 9
($1\frac{3}{16}$ — 18 UNEF)	1.125 2	1.125 9	1.149 1	1.149 9	1.126 7	1.127 4	1.150 6	1.151 4
$1\frac{1}{4}$ — 18 UNEF	1.187 7	1.188 4	1.211 6	1.212 4	1.189 2	1.189 9	1.213 1	1.213 9
($1\frac{5}{16}$ — 18 UNEF)	1.250 2	1.250 9	1.274 1	1.274 9	1.251 7	1.252 4	1.275 6	1.276 4
$1\frac{3}{8}$ — 18 UNEF	1.312 7	1.313 4	1.336 6	1.337 4	1.314 2	1.314 9	1.338 1	1.338 9
($1\frac{7}{16}$ — 18 UNEF)	1.375 2	1.375 9	1.399 1	1.399 9	1.376 7	1.377 4	1.400 6	1.401 4
$1\frac{1}{2}$ — 18 UNEF	1.437 7	1.438 4	1.461 6	1.462 4	1.439 2	1.439 9	1.463 1	1.463 9
($1\frac{9}{16}$ — 18 UNEF)	1.500 1	1.500 9	1.524 1	1.524 9	1.501 6	1.502 4	1.525 6	1.526 4
$1\frac{5}{8}$ — 18 UNEF	1.562 6	1.563 4	1.586 6	1.587 4	1.564 1	1.564 9	1.588 1	1.588 9
($1\frac{11}{16}$ — 18 UNEF)	1.625 1	1.625 9	1.649 1	1.649 9	1.626 6	1.627 4	1.650 6	1.651 4

A) Sizes in brackets are shown as second choice in BS 1580.

Table 52 **Limits of size for NOT GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A)]	**Classes 1A and 2A threads**				**Class 3A threads**			
	Minor diameter		**Effective diameter**		**Minor diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.218 7	0.219 3	0.225 0	0.225 5	0.220 5	0.221 1	0.226 8	0.227 3
$\frac{5}{16}$ — 32 UNEF	0.281 2	0.281 8	0.287 5	0.288 0	0.283 0	0.283 6	0.289 3	0.289 8
$\frac{3}{8}$ — 32 UNEF	0.343 5	0.344 1	0.349 8	0.350 3	0.345 4	0.346 0	0.351 7	0.352 2
$\frac{7}{16}$ — 28 UNEF	0.401 9	0.402 5	0.409 1	0.409 6	0.403 9	0.404 5	0.411 1	0.411 6
$\frac{1}{2}$ — 28 UNEF	0.464 3	0.464 9	0.471 5	0.472 0	0.466 3	0.466 9	0.473 5	0.474 0
$\frac{9}{16}$ — 24 UNEF	0.521 3	0.522 0	0.529 8	0.530 3	0.523 5	0.524 2	0.532 0	0.532 5
$\frac{5}{8}$ — 24 UNEF	0.583 7	0.584 4	0.592 2	0.592 7	0.585 9	0.586 6	0.594 4	0.594 9
($\frac{11}{16}$ — 24 UNEF)	0.646 2	0.646 9	0.654 7	0.655 2	0.648 4	0.649 1	0.656 9	0.657 4
$\frac{3}{4}$ — 20 UNEF	0.701 0	0.701 7	0.711 2	0.711 8	0.703 4	0.704 1	0.713 6	0.714 2
($\frac{13}{16}$ — 20 UNEF)	0.763 5	0.764 2	0.773 7	0.774 3	0.765 9	0.766 6	0.776 1	0.776 7
$\frac{7}{8}$ — 20 UNEF	0.826 0	0.826 7	0.836 2	0.836 8	0.828 4	0.829 1	0.838 6	0.839 2
($\frac{15}{16}$ — 20 UNEF)	0.888 3	0.889 0	0.898 5	0.899 1	0.890 8	0.891 5	0.901 0	0.901 6
1 — 20 UNEF	0.950 8	0.951 5	0.961 0	0.961 6	0.953 3	0.954 0	0.963 5	0.964 1
($1\frac{1}{16}$ — 18 UNEF)	1.008 3	1.009 0	1.019 7	1.020 3	1.010 8	1.011 5	1.022 2	1.022 8
$1\frac{1}{8}$ — 18 UNEF	1.070 8	1.071 5	1.082 2	1.082 8	1.073 3	1.074 0	1.084 7	1.085 3
($1\frac{3}{16}$ — 18 UNEF)	1.133 0	1.133 7	1.144 4	1.145 0	1.135 8	1.136 5	1.147 2	1.147 8
$1\frac{1}{4}$ — 18 UNEF	1.195 5	1.196 2	1.206 9	1.207 5	1.198 3	1.199 0	1.209 7	1.210 3
($1\frac{5}{16}$ — 18 UNEF)	1.258 0	1.258 7	1.269 4	1.270 0	1.260 8	1.261 5	1.272 2	1.272 8
$1\frac{3}{8}$ — 18 UNEF	1.320 5	1.321 2	1.331 9	1.332 5	1.323 3	1.324 0	1.334 7	1.335 3
($1\frac{7}{16}$ — 18 UNEF)	1.382 9	1.383 6	1.394 3	1.394 9	1.385 7	1.386 4	1.397 1	1.397 7
$1\frac{1}{2}$ — 18 UNEF	1.445 4	1.446 1	1.456 8	1.457 4	1.448 2	1.448 9	1.459 6	1.460 2
($1\frac{9}{16}$ — 18 UNEF)	1.507 9	1.508 7	1.519 3	1.519 9	1.510 7	1.511 5	1.522 1	1.522 7
$1\frac{5}{8}$ — 18 UNEF	1.570 4	1.571 2	1.581 8	1.582 4	1.573 2	1.574 0	1.584 6	1.585 2
($1\frac{11}{16}$ — 18 UNEF)	1.632 8	1.633 6	1.644 2	1.644 8	1.635 6	1.636 4	1.647 0	1.647 6

A) Sizes in brackets are shown as second choice in BS 1580-1.

Table 53 **Limits of size for GO screw check plugs for GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A]	**Class 2A threads**				**Class 3A threads**			
	Effective diameter[B]		**Major diameter**		**Effective diameter**[B]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.228 1	0.227 8	0.248 4	0.248 1	0.229 1	0.228 8	0.249 4	0.249 1
$\frac{5}{16}$ — 32 UNEF	0.290 6	0.290 3	0.310 9	0.310 6	0.291 6	0.291 3	0.311 9	0.311 6
$\frac{3}{8}$ — 32 UNEF	0.353 1	0.352 8	0.373 4	0.373 1	0.354 1	0.353 8	0.374 4	0.374 1
$\frac{7}{16}$ — 28 UNEF	0.412 6	0.412 3	0.435 8	0435 5	0.413 7	0.413 4	0.436 9	0.436 6
$\frac{1}{2}$ — 28 UNEF	0.475 1	0.474 8	0.498 3	0.498 0	0.476 2	0.475 9	0.499 4	0.499 1
$\frac{9}{16}$ — 24 UNEF	0.533 5	0.533 1	0.560 6	0.560 2	0.534 7	0.534 3	0.561 8	0.561 4
$\frac{5}{8}$ — 24 UNEF	0.596 0	0.595 6	0.623 1	0.622 7	0.597 2	0.596 8	0.624 3	0.623 9
($\frac{11}{16}$ — 24 UNEF)	0.658 5	0.658 1	0.685 6	0.685 2	0.659 7	0.659 3	0.686 8	0.686 4
$\frac{3}{4}$ — 20 UNEF	0.715 4	0.715 0	0.747 9	0.747 5	0.716 7	0.716 3	0.749 2	0.748 8
($\frac{13}{16}$ — 20 UNEF)	0.777 9	0.777 5	0 810 4	0.810 0	0.779 2	0.778 8	0.811 7	0.811 3
$\frac{7}{8}$ — 20 UNEF	0.840 4	0.840 0	0.872 9	0.872 5	0.841 7	0.841 3	0.874 2	0.873 8
($\frac{15}{16}$ — 20 UNEF)	0.902 8	0.902 4	0.935 3	0.934 9	0.904 2	0.903 8	0.936 7	0.936 3
1 — 20 UNEF	0.965 3	0.964 9	0.997 8	0.997 4	0.966 7	0.966 3	0.999 2	0.998 8
($1\frac{1}{16}$ — 18 UNEF)	1.024 2	1.023 8	1.060 3	1.059 9	1.025 6	1.025 2	1.061 7	1.061 3
$1\frac{1}{8}$ — 18 UNEF	1.086 7	1.086 3	1.122 8	1.122 4	1.088 1	1.087 7	1.124 2	1.123 8
($1\frac{3}{16}$ — 18 UNEF)	1.149 1	1.148 7	1.185 2	1.184 8	1.150 6	1.150 2	1.186 7	1.186 3
$1\frac{1}{4}$ — 18 UNEF	1.211 6	1.211 2	1.247 7	1.247 3	1.213 1	1.212 7	1.249 2	1.248 8
($1\frac{5}{16}$ — 18 UNEF)	1.274 1	1.273 7	1.310 2	1.309 8	1.275 6	1.275 2	1.311 7	1.311 3
$1\frac{3}{8}$ — 18 UNEF	1.336 6	1.336 2	1.372 7	1.372 3	1.338 1	1.337 7	1.374 2	1.373 8
($1\frac{7}{16}$ — 18 UNEF)	1.399 1	1.398 7	1.435 2	1.434 8	1.400 6	1.400 2	1.436 7	1.436 3
$1\frac{1}{2}$ — 18 UNEF	1.461 6	1.461 2	1.497 7	1.497 3	1.463 1	1.462 7	1.499 2	1.498 8
($1\frac{9}{16}$ — 18 UNEF)	1.524 1	1.523 6	1.560 2	1.559 7	1.525 6	1.525 1	1.561 7	1.561 2
$1\frac{5}{8}$ — 18 UNEF	1.586 6	1.586 1	1.622 7	1.622 2	1.588 1	1.587 6	1.624 2	1.623 7
($1\frac{11}{16}$ — 18 UNEF)	1.649 1	1.648 6	1.685 2	1.684 7	1.650 6	1.650 1	1.686 7	1.686 2

A) Sizes in brackets are shown as second choice in BS 1580.

B) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 54 **Limits of size for NOT GO effective diameter check plugs for new GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A]	**Class 2A threads**				**Class 3A threads**			
	Effective diameter[B]		**Major diameter**		**Effective diameter**[B]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.228 9	0.228 7	0.235 5	0.235 2	0.229 9	0.229 7	0.236 5	0.236 2
$\frac{5}{16}$ — 32 UNEF	0.291 4	0.291 2	0.298 0	0.297 7	0.292 4	0.292 2	0.299 0	0.298 7
$\frac{3}{8}$ — 32 UNEF	0.353 9	0.353 7	0.360 5	0.360 2	0.354 9	0.354 7	0.361 5	0.361 2
$\frac{7}{16}$ — 28 UNEF	0.413 4	0.413 2	0.420 9	0.420 6	0.414 5	0.414 3	0.422 0	0.421 7
$\frac{1}{2}$ — 28 UNEF	0.475 9	0.475 7	0.483 4	0.483 1	0.477 0	0.476 8	0.484 5	0.484 2
$\frac{9}{16}$ — 24 UNEF	0.534 5	0.534 2	0.543 2	0.542 8	0.535 7	0.535 4	0.544 4	0.544 0
$\frac{5}{8}$ — 24 UNEF	0.597 0	0.596 7	0.605 7	0.605 3	0.598 2	0.597 9	0.606 9	0.606 5
($\frac{11}{16}$ — 24 UNEF)	0.659 5	0.659 2	0.668 2	0.667 8	0.660 7	0.660 4	0.669 4	0.669 0
$\frac{3}{4}$ — 20 UNEF	0.716 5	0.716 2	0.727 0	0.726 6	0.717 8	0.717 5	0.728 3	0.727 9
($\frac{13}{16}$ — 20 UNEF)	0.779 0	0.778 7	0.789 5	0.789 1	0.780 3	0.780 0	0.790 8	0.790 4
$\frac{7}{8}$ — 20 UNEF	0.841 5	0.841 2	0.852 0	0.851 6	0.842 8	0.842 5	0.853 3	0.852 9
($\frac{15}{16}$ — 20 UNEF)	0.903 9	0.903 6	0.914 4	0.914 0	0.905 3	0.905 0	0.915 8	0.915 4
1 — 20 UNEF	0.966 4	0.966 1	0.976 9	0.976 5	0.967 8	0.967 5	0.978 3	0.977 9
($1\frac{1}{16}$ — 18 UNEF)	1.025 3	1.025 0	1.037 0	1.036 6	1.026 7	1.026 4	1.038 4	1.038 0
$1\frac{1}{8}$ — 18 UNEF	1.087 8	1.087 5	1.099 5	1.099 1	1.089 2	1.088 9	1.100 9	1.100 5
($1\frac{3}{16}$ — 18 UNEF)	1.150 2	1.149 9	1.161 9	1.161 5	1.151 7	1.151 4	1.163 4	1.163 0
$1\frac{1}{4}$ — 18 UNEF	1.212 7	1.212 4	1.224 4	1.224 0	1.214 2	1.213 9	1.225 9	1.225 5
($1\frac{5}{16}$ — 18 UNEF)	1.275 2	1.274 9	1.286 9	1.286 5	1.276 7	1.276 4	1.288 4	1.288 0
$1\frac{3}{8}$ — 18 UNEF	1.337 7	1.337 4	1.349 4	1.349 0	1.339 2	1.338 9	1.350 9	1.350 5
($1\frac{7}{16}$ — 18 UNEF)	1.400 2	1.399 9	1.411 9	1.411 5	1.401 7	1.401 4	1.413 4	1.413 0
$1\frac{1}{2}$ — 18 UNEF	1.462 7	1.462 4	1.474 4	1.474 0	1.464 2	1.463 9	1.475 9	1.475 5
($1\frac{9}{16}$ — 18 UNEF)	1.525 3	1.524 9	1.536 9	1.536 4	1.526 8	1.526 4	1.538 4	1.537 9
$1\frac{5}{8}$ — 18 UNEF	1.587 8	1.587 4	1.599 4	1.598 9	1.589 3	1.588 9	1.600 9	1.600 4
($1\frac{11}{16}$ — 18 UNEF)	1.650 3	1.649 9	1.661 9	1.661 4	1.651 8	1.651 4	1.663 4	1.662 9

[A] Sizes in brackets are shown as second choice in BS 1580-1.

[B] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 55 **Limits of size for NOT GO effective diameter check plugs for worn GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A]	**Class 2A threads**				**Class 3A threads**			
	Effective diameter[B]		**Major diameter**		**Effective diameter**[B]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.229 1	0.228 9	0.235 5	0.235 2	0.230 1	0.229 9	0.236 5	0.236 2
$\frac{5}{16}$ — 32 UNEF	0.291 6	0.291 4	0.298 0	0.297 7	0.292 6	0.292 4	0.299 0	0.298 7
$\frac{3}{8}$ — 32 UNEF	0.354 1	0.353 9	0.360 5	0.360 2	0.355 1	0.354 9	0.361 5	0.361 2
$\frac{7}{16}$ — 28 UNEF	0.413 6	0.413 4	0.420 9	0.420 6	0.414 7	0.414 5	0.422 0	0.421 7
$\frac{1}{2}$ — 28 UNEF	0.476 1	0.475 9	0.483 4	0.483 1	0.477 2	0.477 0	0.484 5	0.484 2
$\frac{9}{16}$ — 24 UNEF	0.534 8	0.534 5	0.543 2	0.542 8	0.536 0	0.535 7	0.544 4	0.544 0
$\frac{5}{8}$ — 24 UNEF	0.597 3	0.597 0	0.605 7	0.605 3	0.598 5	0.598 2	0.606 9	0.606 5
($\frac{11}{16}$ — 24 UNEF)	0.659 8	0.659 5	0.668 2	0.667 8	0.661 0	0.660 7	0.669 4	0.669 0
$\frac{3}{4}$ — 20 UNEF	0.716 8	0.716 5	0.727 0	0.726 6	0.718 1	0.717 8	0.728 3	0.727 9
($\frac{13}{16}$ — 20 UNEF)	0.779 3	0.779 0	0.789 5	0.789 1	0.780 6	0.780 3	0.790 8	0.790 4
$\frac{7}{8}$ — 20 UNEF	0.814 8	0.814 5	0.852 0	0.851 6	0.843 1	0.842 8	0.853 3	0.852 9
($\frac{15}{16}$ — 20 UNEF)	0.904 2	0.903 9	0.914 4	0.914 0	0.905 6	0.905 3	0.915 8	0.915 4
1 — 20 UNEF	0.966 7	0.966 4	0.976 9	0.976 5	0.968 1	0.967 8	0.978 3	0.977 9
($1\frac{1}{16}$ — 18 UNEF)	1.025 6	1.025 3	1.037 0	1.036 6	1.027 0	1.026 7	1.038 4	1.038 0
$1\frac{1}{8}$ — 18 UNEF	1.088 1	1.087 8	1.099 5	1.099 1	1.089 5	1.089 2	1.100 9	1.100 5
($1\frac{3}{16}$ — 18 UNEF)	1.150 5	1.150 2	1.161 9	1.161 5	1.152 0	1.151 7	1.163 4	1.163 0
$1\frac{1}{4}$ — 18 UNEF	1.213 0	1.212 7	1.224 4	1.224 0	1.214 5	1.214 2	1.225 9	1.225 5
($1\frac{5}{16}$ — 18 UNEF)	1.275 5	1.275 2	1.286 9	1.286 5	1.277 0	1.276 7	1.288 4	1.288 0
$1\frac{3}{8}$ — 18 UNEF	1.338 0	1.337 7	1.349 4	1.349 0	1.339 5	1.339 2	1.350 9	1.350 5
($1\frac{7}{16}$ — 18 UNEF)	1.400 5	1.400 2	1.411 9	1.411 5	1.402 0	1.401 7	1.413 4	1.413 0
$1\frac{1}{2}$ — 18 UNEF	1.463 0	1.462 7	1.474 4	1.474 0	1.464 5	1.464 2	1.475 9	1.475 5
($1\frac{9}{16}$ — 18 UNEF)	1.525 7	1.525 3	1.536 9	1.536 4	1.527 2	1.526 8	1.538 4	1.537 9
$1\frac{5}{8}$ — 18 UNEF	1.588 2	1.587 8	1.599 4	1.598 9	1.589 7	1.589 3	1.600 9	1.600 4
($1\frac{11}{16}$ — 18 UNEF)	1.650 7	1.650 3	1.661 9	1.661 4	1.652 2	1.651 8	1.663 4	1.662 9

A) Sizes in brackets are shown as second choice in BS 1580.

B) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 56 **Limits of size for GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A]	**Class 2A threads**				**Class 3A threads**			
	Effective diameter[B]		**Major diameter**		**Effective diameter**[B]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.225 0	0.224 7	0.248 9	0.248 6	0.226 8	0.226 5	0.250 0	0.249 7
$\frac{5}{16}$ — 32 UNEF	0.287 5	0.287 2	0.311 4	0.311 1	0.289 3	0.289 0	0.312 5	0.312 2
$\frac{3}{8}$ — 32 UNEF	0.349 8	0.349 5	0.373 7	0.373 4	0.351 7	0.351 4	0.375 0	0.374 7
$\frac{7}{16}$ — 28 UNEF	0.409 1	0.408 8	0.436 4	0.436 1	0.411 1	0.410 8	0.437 5	0.437 2
$\frac{1}{2}$ — 28 UNEF	0.471 5	0.471 2	0.498 8	0.498 5	0.473 5	0.473 2	0.500 0	0.499 7
$\frac{9}{16}$ — 24 UNEF	0.529 8	0.529 4	0.561 3	0.560 9	0.532 0	0.531 6	0.562 5	0.562 1
$\frac{5}{8}$ — 24 UNEF	0.592 2	0.591 8	0.623 8	0.623 4	0.594 4	0.594 0	0.625 0	0.624 6
($\frac{11}{16}$ — 24 UNEF)	0.654 7	0.654 3	0.686 3	0.685 9	0.656 9	0.656 5	0.687 5	0.687 1
$\frac{3}{4}$ — 20 UNEF	0.711 2	0.710 8	0.748 7	0.748 3	0.713 6	0.713 2	0.750 0	0.749 6
($\frac{13}{16}$ — 20 UNEF)	0.773 7	0.773 3	0.811 2	0.810 8	0.776 1	0.775 7	0.812 5	0.812 1
$\frac{7}{8}$ — 20 UNEF	0.836 2	0.835 8	0.873 7	0.873 3	0.838 6	0.838 2	0.875 0	0.874 6
($\frac{15}{16}$ — 20 UNEF)	0.898 5	0.898 1	0.936 1	0.935 7	0.901 0	0.900 6	0.937 5	0.937 1
1 — 20 UNEF	0.961 0	0.960 6	0.998 6	0.998 2	0.963 5	0.963 1	1.000 0	0.999 6
(1 $\frac{1}{16}$ — 18 UNEF)	1.019 7	1.019 3	1.061 1	1.060 7	1.022 2	1.021 8	1.062 5	1.062 1
1$\frac{1}{8}$ —18 UNEF	1.082 2	1.081 8	1.123 6	1.123 2	1.084 7	1.084 3	1.125 0	1.124 6
(1 $\frac{3}{16}$ — 18 UNEF)	1.144 4	1.144 0	1.186 0	1.185 6	1.147 2	1.146 8	1.187 5	1.187 1
1$\frac{1}{4}$ — 18 UNEF	1.206 9	1.206 5	1.248 5	1.248 1	1.209 7	1.209 3	1.250 0	1.249 6
(1 $\frac{5}{16}$ — 18 UNEF)	1.269 4	1.269 0	1.311 0	1.310 6	1.272 2	1.271 8	1.312 5	1.312 1
1$\frac{3}{8}$ — 18 UNEF	1.331 9	1.331 5	1.373 5	1.373 1	1.334 7	1.334 3	1.375 0	1.374 6
(1 $\frac{7}{16}$ — 18 UNEF)	1.394 3	1.393 9	1.436 0	1.435 6	1.397 1	1.396 7	1.437 5	1.437 1
1$\frac{1}{2}$ — 18 UNEF	1.456 8	1.456 4	1.498 5	1.498 1	1.459 6	1.459 2	1.500 0	1.499 6
(1 $\frac{9}{16}$ — 18 UNEF)	1.519 3	1.518 8	1.561 0	1.560 5	1.522 1	1.521 6	1.562 5	1.562 0
1$\frac{5}{8}$ — 18 UNEF	1.581 8	1.581 3	1.623 5	1.623 0	1.584 6	1.584 1	1.625 0	1.624 5
(1 $\frac{11}{16}$ — 18 UNEF)	1.644 2	1.643 7	1.686 0	1.685 5	1.647 0	1.646 5	1.687 5	1.687 0

[A] Sizes in brackets are shown as second choice in BS 1580.

[B] Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 57 **Limits of size for NOT GO screw check plugs for NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A]	**Class 2A threads**				**Class 3A threads**			
	Effective diameter[B]		**Major diameter**		**Effective diameter**[B]		**Major diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.225 7	0.225 5	0.232 3	0.232 0	0.227 5	0.227 3	0.234 1	0.233 8
$\frac{5}{16}$ — 32 UNEF	0.288 2	0.288 0	0.294 8	0.294 5	0.290 0	0.289 8	0.296 6	0.296 3
$\frac{3}{8}$ — 32 UNEF	0.350 5	0.350 3	0.357 1	0.356 8	0.352 4	0.352 2	0.359 0	0.358 7
$\frac{7}{16}$ — 28 UNEF	0.409 8	0.409 6	0.417 3	0.417 0	0.411 8	0.411 6	0.419 3	0.419 0
$\frac{1}{2}$ — 28 UNEF	0.472 2	0.472 0	0.479 7	0.479 4	0.474 2	0.474 0	0.481 7	0.481 4
$\frac{9}{16}$ — 24 UNEF	0.530 6	0.530 3	0.539 3	0.538 9	0.532 8	0.532 5	0.541 5	0.541 1
$\frac{5}{8}$ — 24 UNEF	0.593 0	0.592 7	0.601 7	0.601 3	0.595 2	0.594 9	0.603 9	0.603 5
($\frac{11}{16}$ — 24 UNEF)	0.655 5	0.655 2	0.664 2	0.663 8	0.657 7	0.657 4	0.666 4	0.666 0
$\frac{3}{4}$ — 20 UNEF	0.712 1	0.711 8	0.722 6	0.722 2	0.714 5	0.714 2	0.725 0	0.724 6
($\frac{13}{16}$ — 20 UNEF)	0.774 6	0.774 3	0.785 1	0.784 7	0.777 0	0.776 7	0.787 5	0.787 1
$\frac{7}{8}$ — 20 UNEF	0.837 1	0.836 8	0.847 6	0.847 2	0.839 5	0.839 2	0.850 0	0.849 6
($\frac{15}{16}$ — 20 UNEF)	0.899 4	0.899 1	0.909 9	0.909 5	0.901 9	0.901 6	0.912 4	0.912 0
1 — 20 UNEF	0.961 9	0.961 6	0.972 4	0.972 0	0.964 4	0.964 1	0.974 9	0.974 5
($1\frac{1}{16}$ — 18 UNEF)	1.020 6	1.020 3	1.032 3	1.031 9	1.023 1	1.022 8	1.034 8	1.034 4
$1\frac{1}{8}$ — 18 UNEF	1.083 1	1.082 8	1.094 8	1.094 4	1.085 6	1.085 3	1.097 3	1.096 9
($1\frac{3}{16}$ — 18 UNEF)	1.145 3	1.145 0	1.157 0	1.156 6	1.148 1	1.147 8	1.159 8	1.159 4
($1\frac{1}{4}$ — 18 UNEF	1.207 8	1.207 5	1.219 5	1.219 1	1.210 6	1.210 3	1.222 3	1.221 9
($1\frac{5}{16}$ — 18 UNEF)	1.270 3	1.270 0	1.282 0	1.281 6	1.273 1	1.272 8	1.284 8	1.284 4
$1\frac{3}{8}$ — 18 UNEF	1.332 8	1.332 5	1.344 5	1.344 1	1.335 6	1.335 3	1.347 3	1.346 9
($1\frac{7}{16}$ — 18 UNEF)	1.395 2	1.394 9	1.406 9	1.406 5	1.398 0	1.397 7	1.409 7	1.409 3
$1\frac{1}{2}$ — 18 UNEF	1.457 7	1.457 4	1.469 4	1.469 0	1.460 5	1.460 2	1.472 2	1.471 8
($1\frac{9}{16}$ — 18 UNEF)	1.520 3	1.519 9	1.531 9	1.531 4	1.523 1	1.522 7	1.534 7	1.534 2
$1\frac{5}{8}$ — 18 UNEF	1.582 8	1.582 4	1.594 4	1.593 9	1.585 6	1.585 2	1.597 2	1.596 7
($1\frac{11}{16}$ — 18 UNEF)	1.645 2	1.644 8	1.656 8	1.656 3	1.648 0	1.647 6	1.659 6	1.659 1

A) Sizes in brackets are shown as second choice in BS 1580.

B) Both the effective diameter and virtual effective diameter should lie within these tolerances.

Table 58 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of GO screw ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A)]	**GO check plugs**				**NOT GO check plugs**			
	Class 2A threads		**Class 3A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.214 6	0.214 5	0.215 6	0.215 5	0.215 3	0.215 2	0.216 3	0.216 2
$\frac{5}{16}$ — 32 UNEF	0.277 1	0.277 0	0.278 1	0.278 0	0.277 8	0.277 7	0.278 8	0.278 7
$\frac{3}{8}$ — 32 UNEF	0.339 6	0.339 5	0.340 6	0.340 5	0.340 3	0.340 2	0.341 3	0.341 2
$\frac{7}{16}$ — 28 UNEF	0.397 1	0.397 0	0.398 2	0.398 1	0.397 8	0.397 7	0.398 9	0.398 8
$\frac{1}{2}$ — 28 UNEF	0.459 6	0.459 5	0.460 7	0.460 6	0.460 3	0.460 2	0.461 4	0.461 3
$\frac{9}{16}$ — 24 UNEF	0.515 5	0.515 4	0.516 7	0.516 6	0.516 3	0.516 2	0.517 5	0.517 4
$\frac{5}{8}$ — 24 UNEF	0.578 0	0.577 9	0.579 2	0.579 1	0.578 8	0.578 7	0.580 0	0.579 9
($\frac{11}{16}$ — 24 UNEF)	0.640 5	0.640 4	0.641 7	0.641 6	0.641 3	0.641 2	0.642 5	0.642 4
$\frac{3}{4}$ — 20 UNEF	0.693 9	0.693 8	0.695 2	0.695 1	0.694 7	0.694 6	0.696 0	0.695 9
($\frac{13}{16}$ — 20 UNEF)	0.756 4	0.756 3	0.757 7	0.757 6	0.757 2	0.757 1	0.758 5	0.758 4
$\frac{7}{8}$ — 20 UNEF	0.818 9	0.818 8	0.820 2	0.820 1	0.819 7	0.819 6	0.821 0	0.820 9
($\frac{15}{16}$ — 20 UNEF)	0.881 3	0.881 2	0.882 7	0.882 6	0.882 1	0.882 0	0.883 5	0.883 4
1 — 20 UNEF	0.943 8	0.943 7	0.945 2	0.945 1	0.944 6	0.944 5	0.946 0	0.945 9
(1 $\frac{1}{16}$ — 18 UNEF)	1.000 3	1.000 2	1.001 7	1.001 6	1.001 1	1.001 0	1.002 5	1.002 4
1$\frac{1}{8}$ — 18 UNEF	1.062 8	1.062 7	1.064 2	1.064 1	1.063 6	1.063 5	1.065 0	1.064 9
(1 $\frac{3}{16}$ — 18 UNEF)	1.125 2	1.125 1	1.126 7	1.126 6	1.126 0	1.125 9	1.127 5	1.127 4
1$\frac{1}{4}$ — 18 UNEF	1.187 7	1.187 6	1.189 2	1.189 1	1.188 5	1.188 4	1.190 0	1.189 9
(1 $\frac{5}{16}$ — 18 UNEF)	1.250 2	1.250 1	1.251 7	1.251 6	1.251 0	1.250 9	1.252 5	1.252 4
1$\frac{3}{8}$ — 18 UNEF	1.312 7	1.312 6	1.314 2	1.314 1	1.313 5	1.313 4	1.315 0	1.314 9
(1 $\frac{7}{16}$ — 18 UNEF)	1.375 2	1.375 1	1.376 7	1.376 6	1.376 0	1.375 9	1.377 5	1.377 4
1$\frac{1}{2}$ — 18 UNEF	1.437 7	1.437 6	1.439 2	1.439 1	1.438 5	1.438 4	1.440 0	1.439 9
(1 $\frac{9}{16}$ — 18 UNEF)	1.500 1	1.499 9	1.501 6	1.501 4	1.501 1	1.500 9	1.502 6	1.502 4
1$\frac{5}{8}$ — 18 UNEF	1.562 6	1.562 4	1.564 1	1.563 9	1.563 6	1.563 4	1.565 1	1.564 9
(1 $\frac{11}{16}$ — 18 UNEF)	1.625 1	1.624 9	1.626 6	1.626 4	1.626 1	1.625 9	1.627 6	1.627 4

A) Sizes in brackets are shown as second choice in BS 1580.

Table 59 **Limits of size for GO and NOT GO plain check plugs for the minor diameter of NOT GO effective diameter ring gauges, solid type**

1	2	3	4	5	6	7	8	9
Designation[A)]	**GO check plugs**				**NOT GO check plugs**			
	Class 2A threads		**Class 3A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
$\frac{1}{4}$ — 32 UNEF	0.218 7	0.218 6	0.220 5	0.220 4	0.219 4	0.219 3	0.221 2	0.221 1
$\frac{5}{16}$ — 32 UNEF	0.218 2	0.218 1	0.283 0	0.282 9	0.281 9	0.281 8	0.283 7	0.283 6
$\frac{3}{8}$ — 32 UNEF	0.343 5	0.343 4	0.345 4	0.345 3	0.344 2	0.344 1	0.346 1	0.346 0
$\frac{7}{16}$ — 28 UNEF	0.401 9	0.401 8	0.403 9	0.403 8	0.402 6	0.402 5	0.404 6	0.404 5
$\frac{1}{2}$ — 28 UNEF	0.464 3	0.464 2	0.466 3	0.466 2	0.465 0	0.464 9	0.467 0	0.466 9
$\frac{9}{16}$ — 24 UNEF	0.521 3	0.521 2	0.523 5	0.523 4	0.522 1	0.522 0	0.524 3	0.524 2
$\frac{5}{8}$ — 24 UNEF	0.583 7	0.583 6	0.585 9	0.585 8	0.584 5	0.584 4	0.586 7	0.586 6
($\frac{11}{16}$ — 24 UNEF)	0.646 2	0.646 1	0.648 4	0.648 3	0.647 0	0.646 9	0.649 2	0.649 1
$\frac{3}{4}$ — 20 UNEF	0.701 0	0.700 9	0.703 4	0.703 3	0.701 8	0.701 7	0.704 2	0.704 1
($\frac{13}{16}$ — 20 UNEF)	0.763 5	0.763 4	0.765 9	0.765 8	0.764 3	0.764 2	0.766 7	0.766 6
$\frac{7}{8}$ — 20 UNEF	0.826 0	0.825 9	0.828 4	0.828 3	0.826 8	0.826 7	0.829 2	0.829 1
($\frac{15}{16}$ — 20 UNEF)	0.888 3	0.888 2	0.890 8	0.890 7	0.889 1	0.889 0	0.891 6	0.891 5
1 — 20 UNEF	0.950 8	0.950 7	0.953 3	0.953 2	0.951 6	0.951 5	0.954 1	0.954 0
($1\frac{1}{16}$ — 18 UNEF)	1.008 3	1.008 2	1.010 8	1.010 7	1.009 1	1.009 0	1.011 6	1.011 5
$1\frac{1}{8}$ — 18 UNEF	1.070 8	1.070 7	1.073 3	1.073 2	1.071 6	1.071 5	1.074 1	1.074 0
($1\frac{3}{16}$ — 18 UNEF)	1.133 0	1.132 9	1.135 8	1.135 7	1.133 8	1.133 7	1.136 6	1.136 5
$1\frac{1}{4}$ — 18 UNEF	1.195 5	1.195 4	1.198 3	1.198 2	1.196 3	1.196 2	1.199 1	1.199 0
($1\frac{5}{16}$ — 18 UNEF)	1.258 0	1.257 9	1.260 8	1.260 7	1.258 8	1.258 7	1.261 6	1.261 5
$1\frac{3}{8}$ — 18 UNEF	1.320 5	1.320 4	1.323 3	1.323 2	1.321 3	1.321 2	1.324 1	1.324 0
($1\frac{7}{16}$ — 18 UNEF)	1.382 9	1.382 8	1.385 7	1.385 6	1.383 7	1.383 6	1.386 5	1.386 4
$1\frac{1}{2}$ — 18 UNEF	1.445 4	1.445 3	1.448 2	1.448 1	1.446 2	1.446 1	1.449 0	1.448 9
($1\frac{9}{16}$ — 18 UNEF)	1.507 9	1.507 7	1.510 7	1.510 5	1.508 9	1.508 7	1.511 7	1.511 5
$1\frac{5}{8}$ — 18 UNEF	1.570 4	1.570 2	1.573 2	1.573 0	1.571 4	1.571 2	1.574 2	1.574 0
($1\frac{11}{16}$ — 18 UNEF)	1.632 8	1.632 6	1.635 6	1.635 4	1.633 8	1.633 6	1.636 6	1.636 4

A) Sizes in brackets are shown as second choice in BS 1580.

Table 60 **Limits of size for adjustable GO screw ring and calliper gauges**

1	2	3	4	5	6
	Minor diameter				**Effective diameter**
Designation[A)]	**Class 2A threads**		**Classes 3A threads**		**Both classes of thread**
	Max.	**Min.**	**Max.**	**Min.**	
	in	in	in	in	Since adjustable GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 62 and Table 64 respectively, no limits are given for the effective diameters of these gauges.
$\frac{1}{4}$ — 32 UNEF	0.214 7	0.215 2	0.215 7	0.216 2	
$\frac{5}{16}$ — 32 UNEF	0.277 2	0.277 7	0.278 2	0.278 7	
$\frac{3}{8}$ — 32 UNEF	0.339 7	0.340 2	0.340 7	0.341 2	
$\frac{7}{16}$ — 28 UNEF	0.397 2	0.397 7	0.398 3	0.398 8	
$\frac{1}{2}$ — 28 UNEF	0.459 7	0.460 2	0.460 8	0.461 3	
$\frac{9}{16}$ — 24 UNEF	0.515 7	0.516 2	0.516 9	0.517 4	
$\frac{5}{8}$ — 24 UNEF	0.578 2	0.578 7	0.579 4	0.579 9	
($\frac{11}{16}$ — 24 UNEF)	0.640 7	0.641 2	0.641 9	0.642 4	
$\frac{3}{4}$ — 20 UNEF	0.694 1	0.694 6	0.695 4	0.695 9	
($\frac{13}{16}$ — 20 UNEF)	0.756 6	0.757 1	0.757 9	0.758 4	
$\frac{7}{8}$ — 20 UNEF	0.819 1	0.819 6	0.820 4	0.820 9	
($\frac{15}{16}$ — 20 UNEF)	0.881 5	0.882 0	0.882 9	0.883 4	
1 — 20 UNEF	0.944 0	0.944 5	0.945 4	0.945 9	
(1$\frac{1}{16}$ — 18 UNEF)	1.000 5	1.001 0	1.001 9	1.002 4	
1$\frac{1}{8}$ —18 UNEF	1.063 0	1.063 5	1.064 4	1.064 9	
(1$\frac{3}{16}$ — 18 UNEF)	1.125 4	1.125 9	1.126 9	1.127 4	
1$\frac{1}{4}$ — 18 UNEF	1.187 9	1.188 4	1.189 4	1.189 9	
(1$\frac{5}{16}$ — 18 UNEF)	1.250 4	1.250 9	1.251 9	1.252 4	
1$\frac{3}{8}$ — 18 UNEF	1.312 9	1.313 4	1.314 4	1.314 9	
(1$\frac{7}{16}$ — 18 UNEF)	1.375 4	1.375 9	1.376 9	1.377 4	
1$\frac{1}{2}$ — 18 UNEF	1.437 9	1.438 4	1.439 4	1.439 9	
(1$\frac{9}{16}$ — 18 UNEF)	1.500 4	1.500 9	1.501 9	1.502 4	
1$\frac{5}{8}$ — 18 UNEF	1.562 9	1.563 4	1.564 4	1.564 9	
(1$\frac{11}{16}$ — 18 UNEF)	1.625 4	1.625 9	1.626 9	1.627 4	

A) Sizes in brackets are shown as second choice in BS 1580.

Table 61 **Limits of size for adjustable NOT GO screw ring and calliper gauges**

1	2	3	4	5	6
Designation[A)]	**Minor diameter**				**Effective diameter**
	Class 2A threads		**Classes 3A threads**		**Both classes of thread**
	Max.	**Min.**	**Max.**	**Min.**	
	in	in	in	in	Since adjustable NOT GO ring and calliper gauges are set to size on effective diameter by means of setting plugs, as specified in Table 63 and Table 65 respectively, no limits are given for the effective diameters of these gauges.
$\frac{1}{4}$ — 32 UNEF	0.218 7	0.219 2	0.220 5	0.221 0	
$\frac{5}{16}$ — 32 UNEF	0.281 2	0.281 7	0.283 0	0.283 5	
$\frac{3}{8}$ — 32 UNEF	0.343 5	0.344 0	0.345 4	0.345 9	
$\frac{7}{16}$ — 28 UNEF	0.401 9	0.402 4	0.403 9	0.404 4	
$\frac{1}{2}$ — 28 UNEF	0.464 3	0.464 8	0.466 3	0.466 8	
$\frac{9}{16}$ — 24 UNEF	0.521 3	0.521 8	0.523 5	0.524 0	
$\frac{5}{8}$ — 24 UNEF	0.583 7	0.584 2	0.585 9	0.586 4	
($\frac{11}{16}$ — 24 UNEF)	0.646 2	0.646 7	0.648 4	0.648 9	
$\frac{3}{4}$ — 20 UNEF	0.701 0	0.701 5	0.703 4	0.703 9	
($\frac{13}{16}$ — 20 UNEF)	0.763 5	0.764 0	0.765 9	0.766 4	
$\frac{7}{8}$ — 20 UNEF	0.826 0	0.826 5	0.828 4	0.828 9	
($\frac{15}{16}$ — 20 UNEF)	0.888 3	0.888 8	0.890 8	0.891 3	
1 — 20 UNEF	0.950 8	0.951 3	0.953 3	0.953 8	
(1$\frac{1}{16}$ — 18 UNEF)	1.008 3	1.008 8	1.010 8	1.011 3	
1$\frac{1}{8}$ — 18 UNEF	1.070 8	1.071 3	1.073 3	1.073 8	
(1$\frac{3}{16}$ — 18 UNEF)	1.133 0	1.133 5	1.135 8	1136 3	
1$\frac{1}{4}$ — 18 UNEF	1.195 5	1.196 0	1.198 3	1.198 8	
(1$\frac{5}{16}$ — 18 UNEF)	1.258 0	1.258 5	1.260 8	1.261 3	
1$\frac{3}{8}$ — 18 UNEF	1.320 5	1.321 0	1.323 3	1.323 8	
(1$\frac{7}{16}$ — 18 UNEF)	1.382 9	1.383 4	1.385 7	1.386 2	
1$\frac{1}{2}$ — 18 UNEF	1.445 4	1.445 9	1.448 2	1.448 7	
(1$\frac{9}{16}$ — 18 UNEF)	1.507 9	1.508 4	1.510 7	1.511 2	
1$\frac{5}{8}$ — 18 UNEF	1.570 4	1.570 9	1.573 2	1.573 7	
(1$\frac{11}{16}$ — 18 UNEF)	1.632 8	1.633 3	1.635 6	1.636 1	

A) Sizes in brackets are shown as second choice in BS 1580-1.

Table 62 **Limits of size for double length setting plugs for adjustable GO screw ring gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation[A]	**Class 2A threads**						**Class 3A threads**					
	Major diameter				**Effective diameter**		**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**		**Full flank portion**		**Truncated portion**		**Both portions**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.249 3	0.249 0	0.242 5	0.242 2	0.228 7	0.228 6	0.250 3	0.250 0	0.243 5	0.243 2	0.229 7	0.229 6
$\frac{5}{16}$ — 32 UNEF	0.311 8	0.311 5	0.305 0	0.304 7	0.291 2	0.291 1	0.312 8	0.312 5	0.306 0	0.305 7	0.292 2	0.292 1
$\frac{3}{8}$ — 32 UNEF	0.374 3	0.374 0	0.367 5	0.367 2	0.353 7	0.353 6	0.375 3	0.375 0	0.368 5	0.368 2	0.354 7	0.354 6
$\frac{7}{16}$ — 28 UNEF	0.436 9	0.436 4	0.429 3	0.428 8	0.413 2	0.413 1	0.438 0	0.437 5	0.430 4	0.429 9	0.414 3	0.414 2
$\frac{1}{2}$ — 28 UNEF	0.499 4	0.498 9	0.491 8	0.491 3	0.475 7	0.475 6	0.500 5	0.500 0	0.492 9	0.492 4	0.476 8	0.476 7
$\frac{9}{16}$ — 24 UNEF	0.561 8	0.561 3	0.553 4	0.552 9	0.534 20	0.534 05	0.563 0	0.562 5	0.554 6	0.554 1	0.535 40	0.535 25
$\frac{5}{8}$ — 24 UNEF	0.624 3	0.623 8	0.615 9	0.615 4	0.596 70	0.596 55	0.625 5	0.625 0	0.617 1	0.616 6	0.597 90	0.597 75
($\frac{11}{16}$ — 24 UNEF)	0.686 8	0.686 3	0.678 4	0.677 9	0.659 20	0.659 05	0.688 0	0.687 5	0.679 6	0.679 1	0.660 40	0.660 25
$\frac{3}{4}$ — 20 UNEF	0.749 2	0.748 7	0.739 7	0.739 2	0.716 20	0.716 05	0.750 5	0.750 0	0.741 0	0.740 5	0.717 50	0.717 35
($\frac{13}{16}$ — 20 UNEF)	0.811 7	0.811 2	0.802 2	0.801 7	0.778 70	0.778 55	0.813 0	0.812 5	0.803 5	0.803 0	0.780 00	0.779 85
$\frac{7}{8}$ — 20 UNEF	0.874 2	0.873 7	0.864 7	0.864 2	0.841 20	0.841 05	0.875 5	0.875 0	0.866 0	0.865 5	0.842 50	0.842 35
($\frac{15}{16}$ — 20 UNEF)	0.936 6	0.936 1	0.927 1	0.926 6	0.903 60	0.903 45	0.938 0	0.937 5	0.928 5	0.928 0	0.905 00	0.904 85
1 — 20 UNEF	0.999 1	0.998 6	0.989 6	0.989 1	0.966 10	0.965 95	1.000 5	1.000 0	0.991 0	0.990 5	0.967 50	0.967 35
($\frac{11}{16}$ — 18 UNEF)	1.061 6	1.061 1	1.051 4	1.050 9	1.025 00	1.024 85	1.063 0	1.062 5	1.052 8	1.052 3	1.026 40	1.026 25
$1\frac{1}{8}$ — 18 UNEF	1.124 1	1.123 6	1.113 9	1.113 4	1.087 50	1.087 35	1.125 5	1.125 0	1.115 3	1.114 8	1.088 90	1.088 75
($1\frac{3}{16}$ — 18 UNEF)	1.186 5	1.186 0	1.176 3	1.175 8	1.149 90	1.149 75	1.188 0	1.187 5	1.177 8	1.177 3	1.151 40	1.151 25
$1\frac{1}{4}$ — 18 UNEF	1.249 0	1.248 5	1.238 8	1.238 3	1.212 40	1.212 25	1.250 5	1.250 0	1.240 3	1.239 8	1.213 90	1.213 75
($1\frac{5}{16}$ — 18 UNEF)	1.311 5	1.311 0	1.301 3	1.300 8	1.274 90	1.274 75	1.313 0	1.312 5	1.302 8	1.302 3	1.276 40	1.276 25
$1\frac{3}{8}$ — 18 UNEF	1.374 0	1.373 5	1.363 8	1.363 3	1.337 40	1.337 25	1.375 5	1.375 0	1.365 3	1.364 8	1.338 90	1.338 75
($1\frac{7}{16}$ — 18 UNEF)	1.436 5	1.436 0	1.426 3	1.425 8	1.399 90	1.399 75	1.438 0	1.437 5	1.427 8	1.427 3	1.401 40	1.401 25
$1\frac{1}{2}$ — 18 UNEF	1.499 0	1.498 5	1.488 8	1.488 3	1.462 40	1.462 25	1.500 5	1.500 0	1.490 3	1.489 8	1.463 90	1.463 75
($1\frac{9}{16}$ — 18 UNEF)	1.561 5	1.561 0	1.551 3	1.550 8	1.524 9	1.524 7	1.563 0	1.562 5	1.552 8	1.552 3	1.526 4	1.526 2
$1\frac{5}{8}$ — 18 UNEF	1.624 0	1.623 5	1.613 8	1.613 3	1.587 4	1.587 2	1.625 5	1.625 0	1.615 3	1.614 8	1.588 9	1.588 7
($1\frac{11}{16}$ — 18 UNEF)	1.686 5	1.686 0	1.676 3	1.675 8	1.649 9	1.649 7	1.688 0	1.687 5	1.677 8	1.677 3	1.651 4	1.651 2

[A] Sizes in brackets are shown as second choice in BS 1580.

Table 63 **Limits of size for double length setting plugs for adjustable NOT GO screw ring gauges**

1	2	3	4	5	6	7	8	9	10	11	12	13
Designation[A]	**Class 2A threads**						**Class 3A threads**					
	Major diameter				**Effective diameter**		**Major diameter**				**Effective diameter**	
	Full flank portion		**Truncated portion**		**Both portions**		**Full flank portion**		**Truncated portion**		**Both portions**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.249 2	0.248 9	0.239 0	0.238 7	0.225 5	0.225 4	0.250 3	0.250 0	0.240 8	0.240 5	0.227 3	0.227 2
$\frac{5}{16}$ — 32 UNEF	0.311 7	0.311 4	0.301 5	0.301 2	0.288 0	0.287 9	0.312 8	0.312 5	0.303 3	0.303 0	0.289 8	0.289 7
$\frac{3}{8}$ — 32 UNEF	0.374 0	0.373 7	0.363 8	0.363 5	0.350 3	0.350 2	0.375 3	0.375 0	0.365 7	0.365 4	0.352 2	0.352 1
$\frac{7}{16}$ — 28 UNEF	0.436 9	0.436 4	0.425 1	0.424 6	0.409 6	0.409 5	0.438 0	0437 5	0.427 1	0.426 6	0.411 6	0.411 5
$\frac{1}{2}$ — 28 UNEF	0.449 3	0.498 8	0·487 5	0.487 0	0.472 0	0.471 9	0.500 5	0.500 0	0.489 5	0.489 0	0.474 0	0.473 9
$\frac{9}{16}$ — 24 UNEF	0.561 8	0.561 3	0.548 3	0.547 8	0.530 30	0.530 15	0.563 0	0.562 5	0.550 5	0.550 0	0.532 50	0.532 35
$\frac{5}{8}$ — 24 UNEF	0.624 3	0.623 8	0.610 7	0.610 2	0.592 70	0.592 55	0.625 5	0.625 0	0.612 9	0.612 4	0.594 90	0.594 75
($\frac{11}{16}$ — 24 UNEF)	0.686 8	0.686 3	0.673 2	0.672 7	0.655 20	0.655 05	0.688 0	0.687 5	0.675 4	0.674 9	0.657 40	0.657 25
$\frac{3}{4}$ — 20 UNEF	0.749 2	0.748 7	0.733 5	0.733 0	0.711 80	0.711 65	0.750 5	0.750 0	0.735 9	0.735 4	0·714 20	0.714 05
($\frac{13}{16}$ — 20 UNEF)	0.811 7	0.811 2	0.796 0	0.795 5	0.774 30	0.774 15	0.813 0	0.812 5	0.798 4	0.797 9	0.776 70	0.776 55
$\frac{7}{8}$ — 20 UNEF	0.874 2	0.873 7	0.858 5	0.858 0	0.836 80	0.836 65	0.875 5	0.875 0	0.860 9	0.860 4	0.839 20	0.839 05
($\frac{15}{16}$ — 20 UNEF)	0.936 6	0.936 1	0.920 8	0.920 3	0.899 10	0.898 95	0.938 0	0.937 5	0.923 3	0.922 8	0.901 60	0.901 45
1 — 20 UNEF	0.999 1	0.998 6	0.983 3	0.982 8	0.961 60	0.961 45	1.000 5	1.000 0	0.985 8	0.985 3	0.964 10	0.963 95
($\frac{1}{16}$ — 18 UNEF)	1.061 6	1.061 1	1.044 4	1.043 9	1.020 30	1.020 15	1.063 0	1.062 5	1.046 9	1.046 4	1.022 80	1.022 65
$1\frac{1}{8}$ — 18 UNEF	1.124 1	1.123 6	1.106 9	1.106 4	1.082 80	1.082 65	1.125 5	1.125 0	1.109 4	1.108 9	1.085 30	1.085 15
($1\frac{3}{16}$ — 18 UNEF)	1.186 5	1.186 0	1.169 1	1.168 6	1.145 00	1.144 85	1.188 0	1.187 5	1.171 9	1.171 4	1.147 80	1.147 65
$1\frac{1}{4}$ — 18 UNEF	1.249 0	1.248 5	1.231 6	1.231 1	1.207 50	1.207 35	1.250 5	1.250 0	1.234 4	1.233 9	1.210 30	1.210 15
($1\frac{5}{16}$ — 18 UNEF)	1.311 5	1.311 0	1.294 1	1.293 6	1.270 00	1.269 85	1.313 0	1.312 5	1.296 9	1.296 4	1.272 80	1.272 65
$1\frac{3}{8}$ — 18 UNEF	1.374 0	1.373 5	1.356 6	1.356 1	1.332 50	1.332 35	1.375 5	1.375 0	1.359 4	1.358 9	1.335 30	1.335 15
($1\frac{7}{16}$ — 18 UNEF)	1.436 5	1.436 0	1.419 0	1.418 5	1.394 90	1.394 75	1.438 0	1.437 5	1.421 8	1.421 3	1.397 70	1.397 55
$1\frac{1}{2}$ — 18 UNEF	1.499 0	1.498 5	1.481 5	1.481 0	1.457 40	1.457 25	1.500 5	1.500 0	1.484 3	1.483 8	1.460 20	1.460 05
($1\frac{9}{16}$ — 18 UNEF)	1.561 5	1.561 0	1.544 0	1.543 5	1.519 9	1.519 7	1.563 0	1.562 5	1.546 8	1.546 3	1.522 7	1.522 5
$1\frac{5}{8}$ — 18 UNEF	1.624 0	1.623 5	1.606 5	1.606 0	1.582 4	1.582 2	1.625 5	1.625 0	1.609 3	1.608 8	1.585 2	1.585 0
($1\frac{11}{16}$ — 18 UNEF)	1.686 5	1.686 0	1.668 9	1.668 4	1.644 8	1.644 6	1.688 0	1.687 5	1.671 7	1.671 2	1.647 6	1.647 4

[A] Sizes in brackets are shown as second choice in BS 1580.

Table 64 **Limits of size for single length setting plugs for adjustable GO screw calliper gauges**

1	2	3	4	5	6	7	8	9
Designation[A)]	**Classes 1A and 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.242 7	0.241 7	0.228 3	0.228 1	0.243 7	0.242 7	0.229 3	0.229 1
$\frac{5}{16}$ — 32 UNEF	0.305 2	0.304 2	0.290 8	0.290 6	0.306 2	0.305 2	0.291 8	0.291 6
$\frac{3}{8}$ — 32 UNEF	0.367 7	0.366 7	0.353 3	0.353 1	0.368 7	0.367 7	0.354 3	0.354 1
$\frac{7}{16}$ — 28 UNEF	0.429 3	0.428 3	0.412 8	0.412 6	0.430 4	0.429 4	0.413 9	0.413 7
$\frac{1}{2}$ — 28 UNEF	0.491 8	0.490 8	0.475 3	0.475 1	0.492 9	0.491 9	0.476 4	0.476 2
$\frac{9}{16}$ — 24 UNEF	0.553 0	0.552 0	0.533 7	0.533 5	0.554 2	0.553 2	0.534 9	0.534 7
$\frac{5}{8}$ — 24 UNEF	0.615 5	0.614 5	0.596 2	0.596 0	0.616 7	0.615 7	0.597 4	0.597 2
($\frac{11}{16}$ — 24 UNEF)	0.678 0	0.677 0	0.658 7	0.658 5	0.679 2	0.678 2	0.659 9	0.659 7
$\frac{3}{4}$ — 20 UNEF	0.738 7	0.737 7	0.715 6	0.715 4	0.740 0	0.739 0	0.716 9	0.716 7
($\frac{13}{16}$ — 20 UNEF)	0.801 2	0.800 2	0.778 1	0.777 9	0.802 5	0.801 5	0.779 4	0.779 2
$\frac{7}{8}$ — 20 UNEF	0.863 7	0.862 7	0.840 6	0.840 4	0.865 0	0.864 0	0.841 9	0.841 7
($\frac{15}{16}$ — 20 UNEF)	0.926 1	0.925 1	0.903 0	0.902 8	0.927 5	0.926 5	0.904 4	0.904 2
1 — 20 UNEF	0.988 6	0.987 6	0.965 5	0.965 3	0.990 0	0.989 0	0.966 9	0.966 7
($1\frac{1}{16}$ — 18 UNEF)	1.050 0	1.049 0	1.024 4	1.024 2	1.051 4	1.050 4	1.025 8	1.025 6
$1\frac{1}{8}$ — 18 UNEF	1.112 5	1.111 5	1.086 9	1.086 7	1.113 9	1.112 9	1.088 3	1.088 1
($1\frac{3}{16}$ — 18 UNEF)	1.174 9	1.173 9	1.149 3	1.149 1	1.176 4	1.175 4	1.150 8	1.150 6
$1\frac{1}{4}$ — 18 UNEF	1.237 4	1.236 4	1.211 8	1.211 6	1.238 9	1.237 9	1.213 3	1.213 1
($1\frac{5}{16}$ — 18 UNEF)	1.299 9	1.298 9	1.274 3	1.274 1	1.301 4	1.300 4	1.275 8	1.275 6
$1\frac{3}{8}$ — 18 UNEF	1.362 4	1.361 4	1.336 8	1.336 6	1.363 9	1.362 9	1.338 3	1.338 1
($1\frac{7}{16}$ — 18 UNEF)	1.424 9	1.423 9	1.399 3	1.399 1	1.426 4	1.425 4	1.400 8	1.400 6
$1\frac{1}{2}$ — 18 UNEF	1.487 4	1.486 4	1.461 8	1.461 6	1.488 9	1.487 9	1.463 3	1.463 1
($1\frac{9}{16}$ — 18 UNEF)	1.549 9	1.548 9	1.524 4	1.524 1	1.551 4	1.550 4	1.525 9	1.525 6
$1\frac{5}{8}$ — 18 UNEF	1.612 4	1.611 4	1.586 9	1.586 6	1.613 9	1.612 9	1.588 4	1.588 1
($1\frac{11}{16}$ — 18 UNEF)	1.674 9	1.673 9	1.649 4	1.649 1	1.676 4	1.675 4	1.650 9	1.650 6

[A)] Sizes in brackets are shown as second choice in BS 1580.

Table 65 **Limits of size for single length setting plugs for adjustable NOT GO screw calliper gauges**

1	2	3	4	5	6	7	8	9
Designation[A)]	**Class 2A threads**				**Class 3A threads**			
	Major diameter		**Effective diameter**		**Major diameter**		**Effective diameter**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.242 7	0.241 7	0.225 2	0.225 0	0.243 7	0.242 7	0.227 0	0.226 8
$\frac{5}{16}$ — 32 UNEF	0.305 2	0.304 2	0.287 7	0.287 5	0.306 2	0.305 2	0.289 5	0.289 3
$\frac{3}{8}$ — 32 UNEF	0.367 7	0.366 7	0.350 0	0.349 8	0.368 7	0.367 7	0.351 9	0.351 7
$\frac{7}{16}$ — 28 UNEF	0.429 3	0.428 3	0.409 3	0.409 1	0.430 4	0.429 4	0.411 3	0.411 1
$\frac{1}{2}$ — 28 UNEF	0.491 8	0.490 8	0.471 7	0.471 5	0.492 9	0.491 9	0.473 7	0.473 5
$\frac{9}{16}$ — 24 UNEF	0.553 0	0.552 0	0.530 0	0.529 8	0.554 2	0.553 2	0.532 2	0.532 0
$\frac{5}{8}$ — 24 UNEF	0.615 5	0.614 5	0.592 4	0.592 2	0.616 7	0.615 7	0.594 6	0.594 4
($\frac{11}{16}$ — 24 UNEF)	0.678 0	0.677 0	0.654 9	0.654 7	0.679 2	0.678 2	0.657 1	0.656 9
$\frac{3}{4}$ — 20 UNEF	0.738 7	0.737 7	0.711 4	0.711 2	0.740 0	0.739 0	0.713 8	0.713 6
($\frac{13}{16}$ — 20 UNEF)	0.801 2	0.800 2	0.773 9	0.773 7	0.802 5	0.801 5	0.776 3	0.776 1
$\frac{7}{8}$ — 20 UNEF	0.863 7	0.862 7	0.836 4	0.836 2	0.865 0	0.864 0	0.838 8	0.838 6
($\frac{15}{16}$ — 20 UNEF)	0.926 1	0.925 1	0.898 7	0.898 5	0.927 5	0.926 5	0.901 2	0.901 0
1 — 20 UNEF	0.988 6	0.987 6	0.961 2	0.961 0	0.990 0	0.989 0	0.963 7	0.963 5
($1\frac{1}{16}$ — 18 UNEF)	1.050 0	1.049 0	1.019 9	1.019 7	1.051 4	1.050 4	1.022 4	1.022 2
$1\frac{1}{8}$ — 18 UNEF	1.112 5	1.111 5	1.082 4	1.082 2	1.113 9	1.112 9	1.084 9	1.084 7
($1\frac{3}{16}$ — 18 UNEF)	1.174 9	1.173 9	1.144 6	1.144 4	1.176 4	1.175 4	1.147 4	1.147 2
$1\frac{1}{4}$ — 18 UNEF	1.237 4	1.236 4	1.207 1	1.206 9	1.238 9	1.237 9	1.209 9	1.209 7
($1\frac{5}{16}$ — 18 UNEF)	1.299 9	1.298 9	1.269 6	1.269 4	1.301 4	1.300 4	1.272 4	1.272 2
$1\frac{3}{8}$ — 18 UNEF	1.362 4	1.361 4	1.332 1	1.331 9	1.363 9	1.362 9	1.334 9	1.334 7
($1\frac{7}{16}$ — 18 UNEF)	1.424 9	1.423 9	1.394 5	1.394 3	1.426 4	1.425 4	1.397 3	1.397 1
$1\frac{1}{2}$ — 18 UNEF	1.487 4	1.486 4	1.457 0	1.456 8	1.488 9	1.487 9	1.459 8	1.459 6
($1\frac{9}{16}$ — 18 UNEF)	1.549 9	1.548 9	1.519 6	1.519 3	1.551 4	1.550 4	1.522 4	1.522 1
$1\frac{5}{8}$ — 18 UNEF	1.612 4	1.611 4	1.582 1	1.581 8	1.613 9	1.612 9	1.584 9	1.584 6
($1\frac{11}{16}$ — 18 UNEF)	1.674 9	1.673 9	1.644 5	1.644 2	1.676 4	1.675 4	1.647 3	1.647 0

[A)] Sizes in brackets are shown as second choice in BS 1580.

Table 66 **Limits of size for GO and NOT GO plain calliper (GAP) gauges for major diameters**

1	2	3	4	5	6	7	8	9
Designation[A)]	**GO gauges**				**NOT GO gauges**			
	Class 2A threads		**Class 3A threads**		**Class 2A threads**		**Class 3A threads**	
	Min.	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**	**Min.**	**Max.**
	in	in	in	in	in	in	in	in
$\frac{1}{4}$ — 32 UNEF	0.248 7	0.249 0	0.249 7	0.250 0	0.242 7	0.243 0	0.243 7	0.244 0
$\frac{5}{16}$ — 32 UNEF	0.311 2	0.311 5	0.312 2	0.312 5	0.305 2	0.305 5	0.306 2	0.306 5
$\frac{3}{8}$ — 32 UNEF	0.373 7	0.374 0	0.374 7	0.375 0	0.367 7	0.368 0	0.368 7	0.369 0
$\frac{7}{16}$ — 28 UNEF	0.436 1	0.436 4	0.437 2	0.437 5	0.429 6	0.429 9	0.430 7	0.431 0
$\frac{1}{2}$ — 28 UNEF	0.498 6	0.498 9	0.499 7	0.500 0	0.492 1	0.492 4	0.493 2	0.493 5
$\frac{9}{16}$ — 24 UNEF	0.561 0	0.561 3	0.562 2	0.562 5	0.553 8	0.554 1	0.555 0	0.555 3
$\frac{5}{8}$ — 24 UNEF	0.623 5	0.623 8	0.624 7	0.625 0	0.616 3	0.616 6	0.617 5	0.617 8
($\frac{11}{16}$ — 24 UNEF)	0.686 0	0.686 3	0.687 2	0.687 5	0.678 8	0.679 1	0.680 0	0.680 3
$\frac{3}{4}$ — 20 UNEF	0.748 4	0.748 7	0.749 7	0.750 0	0.740 3	0.740 6	0.741 6	0.741 9
($\frac{13}{16}$ — 20 UNEF)	0.810 9	0.811 2	0.812 2	0.812 5	0.802 8	0.803 1	0.804 1	0.804 4
$\frac{7}{8}$ — 20 UNEF	0.873 4	0.873 7	0.874 7	0.875 0	0.865 3	0.865 6	0.866 6	0.866 9
($\frac{15}{16}$ — 20 UNEF)	0.935 8	0.936 1	0.937 2	0.937 5	0.927 7	0.928 0	0.929 1	0.929 4
1 — 20 UNEF	0.998 3	0.998 6	0.999 7	1.000 0	0.990 2	0.990 5	0.991 6	0.991 9
($1\frac{1}{16}$ — 18 UNEF)	1.060 8	1.061 1	1.062 2	1.062 5	1.052 1	1.052 4	1.053 5	1.053 8
$1\frac{1}{8}$ — 18 UNEF	1.123 3	1.123 6	1.124 7	1.125 0	1.114 6	1.114 9	1.116 0	1.116 3
($1\frac{3}{16}$ — 18 UNEF)	1.185 7	1.186 0	1.187 2	1.187 5	1.177 0	1.177 3	1.178 5	1.178 8
$1\frac{1}{4}$ — 18 UNEF	1.248 2	1.248 5	1.249 7	1.250 0	1.239 5	1.239 8	1.241 0	1.241 3
($1\frac{5}{16}$ — 18 UNEF)	1.310 7	1.311 0	1.312 2	1.312 5	1.302 0	1.302 3	1.303 5	1.303 8
$1\frac{3}{8}$ — 18 UNEF	1.373 2	1.373 5	1.374 7	1.375 0	1.364 5	1.364 8	1.366 0	1.366 3
($1\frac{7}{16}$ — 18 UNEF)	1.435 7	1.436 0	1.437 2	1.437 5	1.427 0	1.427 3	1.428 5	1.428 8
$1\frac{1}{2}$ — 18 UNEF	1.498 2	1.498 5	1.499 7	1.500 0	1.489 5	1.489 8	1.491 0	1.491 3
($1\frac{9}{16}$ — 18 UNEF)	1.560 6	1.561 0	1.562 1	1.562 5	1.551 9	1.552 3	1.553 4	1.553 8
$1\frac{5}{8}$ — 18 UNEF	1.623 1	1.623 5	1.624 6	1.625 0	1.614 4	1.614 8	1.615 9	1.616 3
($1\frac{11}{16}$ — 18 UNEF)	1.685 6	1.686 0	1.687 1	1.687 5	1.676 9	1.677 3	1.678 4	1.678 8

A) Sizes in brackets are shown as second choice in BS 1580.

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