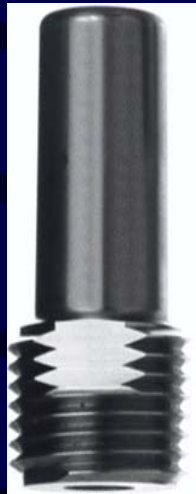




# *NPT PIPE GAGES*



*NPT L-1 PLUG GAGE*

*Tolerance: + or -  
one Turn from the  
notch.*



*NPT L-1 RING GAGE*

*Tolerance: + or -  
one Turn from the  
Small End Face of  
the Ring.*



# ***NPT PIPE THREADS***

- *NPT Threads are Considered “General Purpose” Pipe Threads*
- *NPT Threads Are Intend to be Sealed at the Crest & Root with Teflon Tape, Pipe Dope or Other Types of Sealant..*
- *NPT Threads Do Not Require “Crest Check”, L-3, or L-2 Gages.*
  - *NPT Gages are Made to: ANSI/ASME B1.20.1*



# *NPTF PIPE PLUGS*



***NPTF L-1  
PLUG GAGE***

*The L-1 Plug Inspects  
the Pitch Diameter of  
the Hand Tight (L-1)  
Length of Engagement.*



***NPTF L-3  
PLUG GAGE***

*The L-3 Plug Inspects  
the Taper and Wrench  
Tight (L-3) Length of  
Engagement.*



***CREST CHECK PLUG  
(6 Step ) GAGE***

*The Crest Check Plug  
Inspects the Truncation  
Limits & Taper of the  
Minor Diameter.*



# ***NPTF PIPE RINGS***



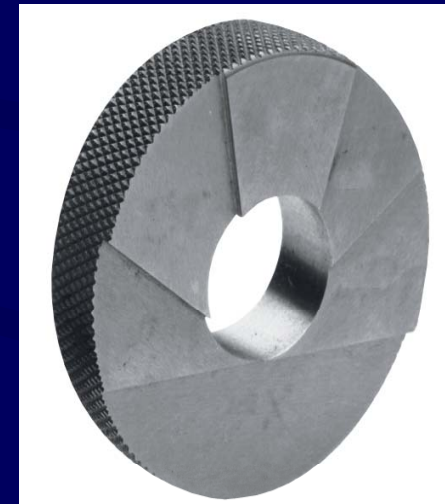
***NPTF L-1  
RING GAGE***

*The L-1 Ring Inspects  
the Pitch Diameter of  
the Hand Tight (L-1)  
Length of Engagement.*



***NPTF L-2  
RING GAGE***

*The L-2 Ring Inspects  
the Taper and  
Wrench Tight (L-2)  
Length of  
Engagement.*



***CREST CHECK RING  
(6 Step ) GAGE***

*The Crest Check Ring  
Inspect the  
Truncation Limits &  
Taper of the Major  
Diameter.*



# ***NPTF PIPE GAGES***

- *NPTF Gages are Considered “Dry Seal” Pipe Threads.*
- *NPTF Gages are Relationship Gages.*
- *NPTF L-1 Tolerance is + or - One Turn from the, (Notch on the Plug or Small End Face of the Ring).*
- *NPTF L-2 Ring or L-3 Plug Tolerance is + or - One Half Turn j Location of the L-1 Gage.*
- *NPTF Crest Check Gage will be Between one of these Sets of Notches, (  $MN$  &  $MN_t$ ,  $B$  &  $B_t$ ,  $MX$  &  $MX_t$  ). These Notches are in Relation to Where the L-1 & ( L-3 or L-2 ) Gages Measured.*



# *NPTF Classes of Product Threads*

*Class 1 Threads - “Acceptability is determined by coordinated use of L-1 & L-2 gages for external product threads and L-1 & L-3 internal product threads. Crest and root truncation is generally considered to be controlled by tooling or other means”.*

*ANSI/ASME B1.20.5*

*Class 2 Threads - Same as above, “however, inspection of root and crest truncation is required.”, (ANSI/ASME B1.20.3). This means that 6-step root & crest check gages or other methods are required to inspect product root & crest truncation.*



***Remember!!!***

***Never force a Gage into or on a Part Being Check***

***Handle gages as you would any precision tool, misuse or mishandling can result in nicks or other deformities which can destroy the integrity of the gage.***

***Store gages in a secure location, preferably in individual compartments or containers. Gages should be dipped in an oil-wax based seal or coated with a rust preventive prior to storing***

***Ship gages packed separately, coated with rust preventive, with sufficient packing material to avoid damage.***





***Any Questions, Contact Us***

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