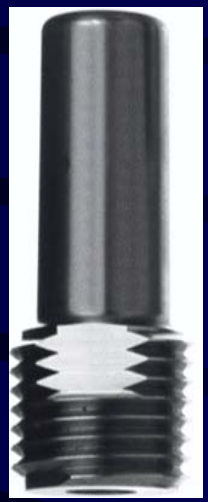
Vermont Gage

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*

Vermont Gage

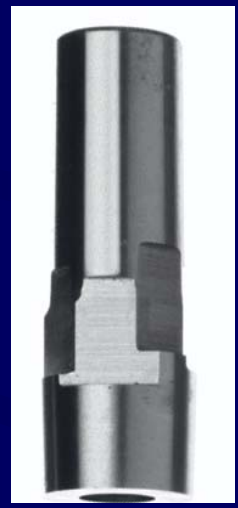
NPTF PIPE PLUGS

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.

Vermont Gage

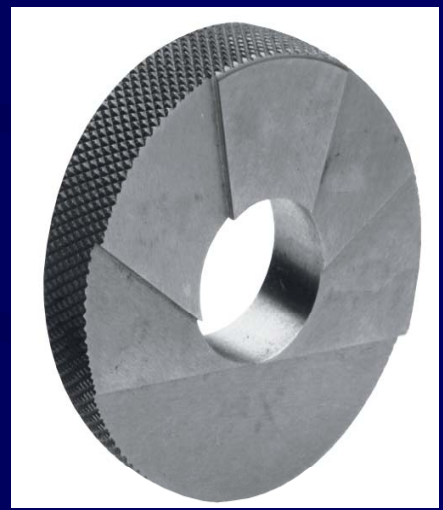
NPTF PIPE RINGS

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 f 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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