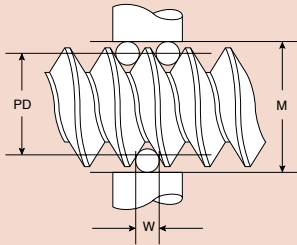
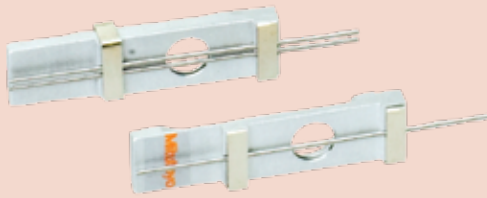


3-Wire Thread Measuring System

Individual Holder and Wire Set



- PD = Pitch Diameter
- M = Measurement over wires
- W = Wire diameter
- C = Constant
- C = .86603 x Pitch (inches) -3W
- P.D. = M-C
- W = .57735 x P

Applications

- Measure set of thread plug gages and working thread plug gages.
- Monitor the wear on working thread plug gages.
- Monitor and control pitch diameter variation during thread fabrication.
- Reduce measurement time to a fraction of the time normally taken using the traditional three wire method.
- Use in conjunction with go/no-go thread ring gages to control thread size to the most demanding specifications.
- Determine out of roundness and taper that may exist in threaded parts.
- Applications for preplating and post plating thread measurement.

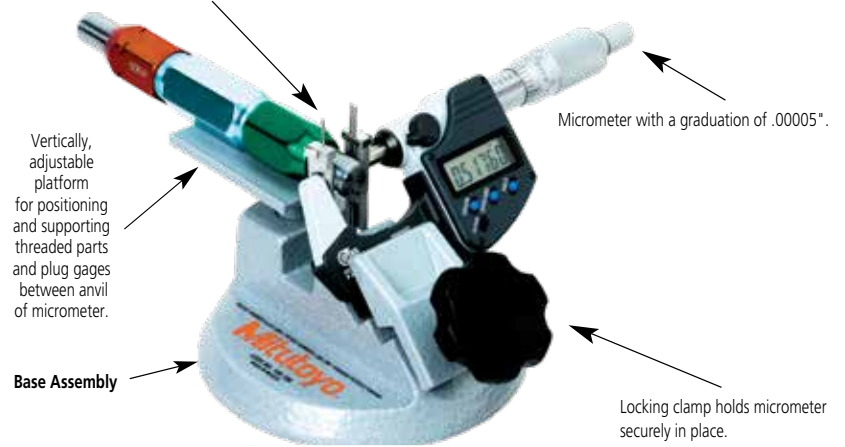
Tolerance of Wires:

- Diameter +/- .000010"
- Roundness +/- .000010"
- Surface finish 2 micro inches AA, lapped.
- Hardness HRC 59-64
- Certification of accuracy included.
- Traceable to NIST.
- Meets or exceeds all ANSI and ISO specs.

FEATURES

- Fast and accurate method of thread measuring available for use with micrometer

Wire holders and 3 thread measuring wires assembled for each thread pitch.



INCH STANDARD HOLDERS AND WIRES SETS

Order No. ^{1,2}	Threads Per Inch	Thread Measuring Wire Diameter
64AAA201	120	.00481
64AAA202	100	.00577
64AAA203	95	.00601
64AAA204	90	.00642
64AAA205	80	.00722
64AAA206	72	.00802
64AAA207	64	.00902
64AAA208	56	.01031
64AAA209	50	.01155
64AAA210	48	.01203
64AAA211	44	.01312
64AAA212	40	.01443
64AAA213	36	.01604
64AAA214	32	.01804
64AAA215	30	.01925
64AAA216	28	.02062
64AAA217	27	.02138
64AAA218	26	.02221
64AAA219	24	.02406
64AAA220	22	.02624
64AAA221	20	.02887
64AAA222	18	.03208
64AAA223	16	.03608
64AAA224	14	.04124
64AAA225	13	.04441
64AAA226	12	.04811
64AAA227	11.5	.05020
64AAA228	11	.05249
64AAA229	10	.05774
64AAA230	9	.06415
64AAA231	8	.07217
64AAA232	7.5	.07698
64AAA233	7	.08248
64AAA234	6	.09623
64AAA235	5.5	.10497
64AAA236	5	.11547

¹ For 6.35mm Spindle Diameter holder only, add "H" suffix to Order No. (i.e. 64AAA201H)

² For 8mm Spindle Diameter holder only, add "H8" suffix to Order No. (i.e. 64AAA201H8)

Compatible with micrometers with 0.25" anvils & spindles.

Stand Assembly
Order No. 156-106

METRIC HOLDERS AND WIRES SETS

Order No. ¹	Pitch	mm Diameter	Inch Diameter
64AAA251	.2mm	.1155	.00455
64AAA252	.225mm	.1299	.00511
64AAA253	.25mm	.1443	.00568
64AAA254	.30mm	.1732	.00682
64AAA255	.35mm	.2021	.00796
64AAA256	.40mm	.2309	.00909
64AAA257	.45mm	.2598	.01023
64AAA258	.50mm	.2887	.01137
64AAA259	.55mm	.3175	.01250
64AAA260	.60mm	.3464	.01364
64AAA261	.70mm	.4041	.01591
64AAA262	.75mm	.4330	.01705
64AAA263	.80mm	.4619	.01818
64AAA264	.85mm	.4907	.01932
64AAA265	.90mm	.5196	.02046
64AAA266	1.00mm	.5774	.02273
64AAA267	1.25mm	.7217	.02841
64AAA268	1.50mm	.8660	.03410
64AAA269	1.75mm	1.0104	.03978
64AAA270	2.00mm	1.1547	.04546
64AAA271	2.50mm	1.4434	.05683
64AAA272	3.00mm	1.7321	.06819
64AAA273	3.50mm	2.0207	.07956
64AAA274	4.00mm	2.3094	.09092

¹ For 6.35mm Spindle Diameter holder only, add "H" suffix to Order No. (i.e. 64AAA201H)