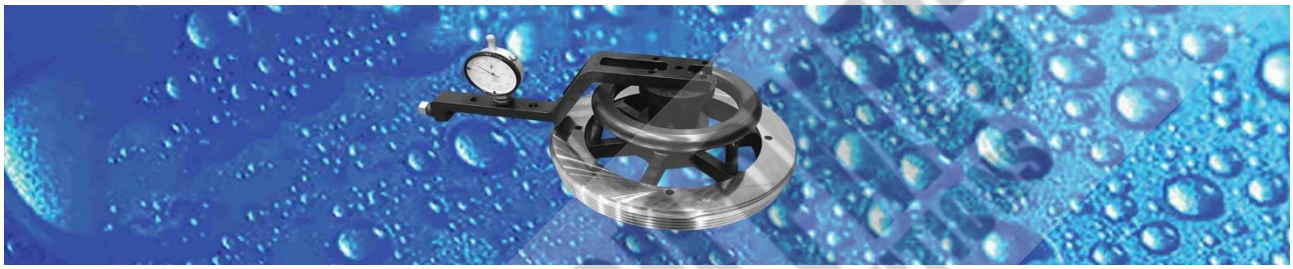
How to Measure the Pitch Diameter of Taper Thread for Socket?

a) **Measuring method** The value C_1 of a set block gauge shall be measured with a dial gauge. Then, plug gauge PB (for pole end face) is fitted with the specified clamping torque as given in figure 11, the space C_1' is measured, and the difference ΔC_1 between C_1' and C_1 is calculated. However, ΔC_1 may be directly measured in the measurement of C_1' by adjusting the scale of the dial gauge to zero point in the measurement of C_1 of the set block gauge.



b) **Calculation** The pitch diameter B' of taper thread to be obtained shall be calculated according to the following formula, and rounded off to two decimal places (see figure 12).

$$B' = B + \frac{\Delta C_1}{3} \quad \cdots\cdots (4)$$

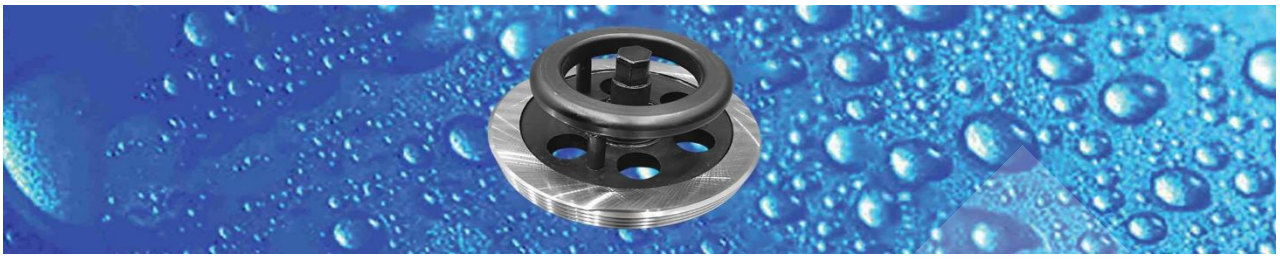
where, B' : pitch diameter of taper thread to be obtained (mm)

B : standard dimension of pitch diameter of taper thread (mm)

C_1 : standard dimension of gauge space as given in tables 4-1 and 4-2 (mm)

ΔC_1 : difference between C_1 and C_1' [3] (mm)

Note [3] The sign of the measured value ΔC_1 is positive when pitch diameter B' is larger than standard dimension B, and negative when smaller.



c) **Illustration**

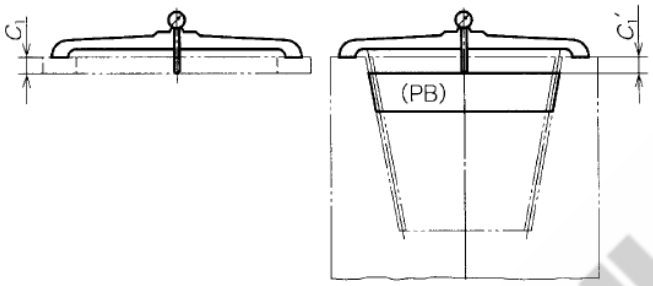


Figure 11 Combination of socket pitch diameter measuring gauge

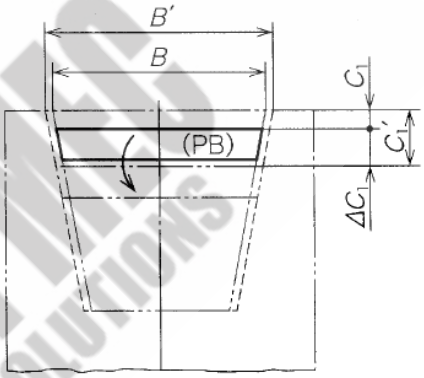
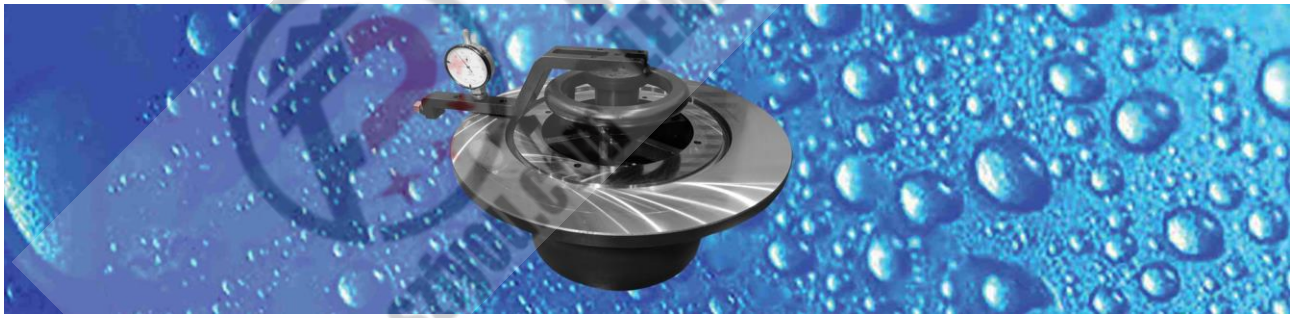


Figure 12 Pitch diameter of socket



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