



## Recoil Thread Gauges

Thread gauging is recommended wherever precision threads are required. The quality of the tapped hole which accommodates the insert, determines the finished size and hole quality after the insert has been installed. If the finished tapped hole gauges satisfactorily, the installed insert will be within the thread tolerance.

## Technical Information

Recoil gauges 1/2" M12 and below have at least a .0002" or 5um wear allowance on the Go nib. Gauge handle and all gauge nibs are marked with the extreme product limits for particular size and class of fit.

Where precision is required, 3B gauges should be used. When using locking inserts, 3B gauges should be used as close precision is required.

## Recoil Inch Gauge Part Numbers

### Unified Coarse

NOMINAL THREAD SIZE	WORKING GAUGES	
	3B Closefit	2B Medium Fit
2 (.086) - 56	63523	63522
3 (.099) - 48	63533	63532
4 (.112) - 40	63543	63542
5 (.125) - 40	63553	63552
6 (.138) - 32	63563	63562
8 (.138) - 32	63583	63582
10 (.190) - 24	63603	63602
12 (.216) - 24	63623	63622
1/4 (.2500) - 20	63043	63042
5/16 (.3125) - 18	63053	63052
3/8 (.3750) - 16	63063	63062
7/16 (.4375) - 14	63073	63072
1/2 (.5000) - 13	63083	63082
9/16 (.5625) - 12	63093	63092
5/8 (.6250) - 11	63103	63102
11/16 (.6875) - 11	63113	63112
3/4 (.7500) - 10	63123	63122
7/8 (.8750) - 9	63143	63142
1 (1.0000) - 8	63163	63162
1-1/8 (1.1250) - 7	63183	63182
1-1/4 (1.2500) - 7	63203	63202
1-3/8 (1.3750) - 6	63223	63222
1-1/2 (1.5000) - 6	63243	63242

### Unified Fine

NOMINAL THREAD SIZE	WORKING GAUGES	
	3B Closefit	2B Medium Fit
3 (.099) - 56	64533	64532
4 (.112) - 48	64543	64542
6 (.138) - 40	64563	64562
8 (.164) - 36	64583	64582
10 (.190) - 32	64603	64602
1/4 (.2500) - 28	64043	64042
5/16 (.3125) - 24	64053	64052
3/8 (.3750) - 24	64063	64062
7/16 (.4375) - 20	64073	64072
1/2 (.5000) - 20	64083	64082
9/16 (.5625) - 18	64093	64092
5/8 (.6250) - 18	64103	64102
3/4 (.7500) - 16	64123	64122
7/8 (.8750) - 14	64143	64142
1 (1.0000) - 12	64163	64162
1 (1.0000) - 14	64163-14	64162-14
1-1/8 (1.1250) - 12	64183	64182
1-1/4 (1.2500) - 12	64203	64202
1-3/8 (1.3750) - 12	64223	64222
1-1/2 (1.5000) - 12	64243	64242

## Fits and Tolerances

Recoil gauges are supplied for two different classes of fit ( tolerances ). These are close and medium tolerance.

Gauges are used to check the pitch diameter of the tapped hole, the No Go end of the gauge checks the pitch diameter is not too large and the Go end checks the pitch diameter is not too small.

THREAD / TOLERANCE	CLOSE	MEDIUM
Metric	4H5H	5H
UN	3B	2B
Imperial	CLOSE	MEDIUM

## Recoil Metric Gauge Part Numbers

### Metric Coarse

NOMINAL THREAD SIZE	WORKING GAUGES	
	4H5H Closefit	5H Medium Fit
<b>M2 x 0.4</b>	65024	65025
<b>M2.2 x 0.45</b>	65014	65015
<b>M2.5 x 0.45</b>	65254	65255
<b>M3 x 0.5</b>	65034	65035
<b>M3.5 x 0.6</b>	65354	65355
<b>M4 x 0.7</b>	65044	65045
<b>M5 x 0.8</b>	65054	65055
<b>M6 x 1.0</b>	65064	65065
<b>M7 x 1.0</b>	65074	65075
<b>M8 x 1.25</b>	65084	65085
<b>M9 x 1.25</b>	65094	65095
<b>M10 x 1.5</b>	65104	65105
<b>M11 x 1.5</b>	65114	65115
<b>M12 x 1.75</b>	65124	65125
<b>M13 x 1.75</b>	65134	65135
<b>M14 x 2.0</b>	65144	65145
<b>M15 x 2.0</b>	65154	65155
<b>M16 x 2.0</b>	65164	65165
<b>M18 x 2.5</b>	65184	65185
<b>M20 x 2.5</b>	65204	65205
<b>M22 x 2.5</b>	65224	65225
<b>M24 x 3.0</b>	65244	65245
<b>M27 x 3.0</b>	65274	65275
<b>M30 x 3.5</b>	65304	65305
<b>M30 x 3.0</b>	65304-3	65305-3
<b>M36 x 4.0</b>	65364	65365
<b>M39 x 4.0</b>	65394	65395
<b>M42 x 4.5</b>	65424	65425
<b>M42 x 4.0</b>	65424-4	65425-4

### Metric Fine

NOMINAL THREAD SIZE	WORKING GAUGES	
	4H5H Closefit	5H Medium Fit
<b>M8 x 1.0</b>	67084	67085
<b>M10 x 1.0</b>	68104	68105
<b>M10 x 1.25</b>	67104	67105
<b>M11 x 1.0</b>	68114	68115
<b>M11 x 1.25</b>	67114	67115
<b>M12 x 1.25</b>	68124	68125
<b>M12 x 1.5</b>	67124	67125
<b>M13 x 1.25</b>	68134	68135
<b>M13 x 1.5</b>	67134	67135
<b>M14 x 1.5</b>	67144	67145
<b>M15 x 1.5</b>	67154	67155
<b>M16 x 1.5</b>	67164	67165
<b>M18 x 1.5</b>	68184	68185
<b>M18 x 2.0</b>	67184	67185
<b>M20 x 1.5</b>	68204	68205
<b>M20 x 2.0</b>	67204	67205
<b>M22 x 1.5</b>	68224	68225
<b>M22 x 2.0</b>	67224	67225
<b>M24 x 1.5</b>	68244	68245
<b>M24 x 2.0</b>	67244	67245
<b>M26 x 1.5</b>	68264	68265
<b>M27 x 1.5</b>	68274	68275
<b>M27 x 2.0</b>	67274	67275
<b>M30 x 1.5</b>	68304	68305
<b>M30 x 2.0</b>	67304	67305
<b>M36 x 1.5</b>	68364	68365
<b>M36 x 3.0</b>	67364	67365
<b>M39 x 2.0</b>	68394	68395
<b>M39 x 3.0</b>	67394	67395
<b>M42 x 2.0</b>	68424	68425
<b>M42 x 3.0</b>	67424	67425