

ALLEN ENGINEERING & DESIGN CO. LLC

GAGE ROLLS

EXTERNAL AND INTERNAL

CHART INSTRUCTIONS

ALLEN ENGINEERING AND DESIGN COMPANY LLC

Distributed by:

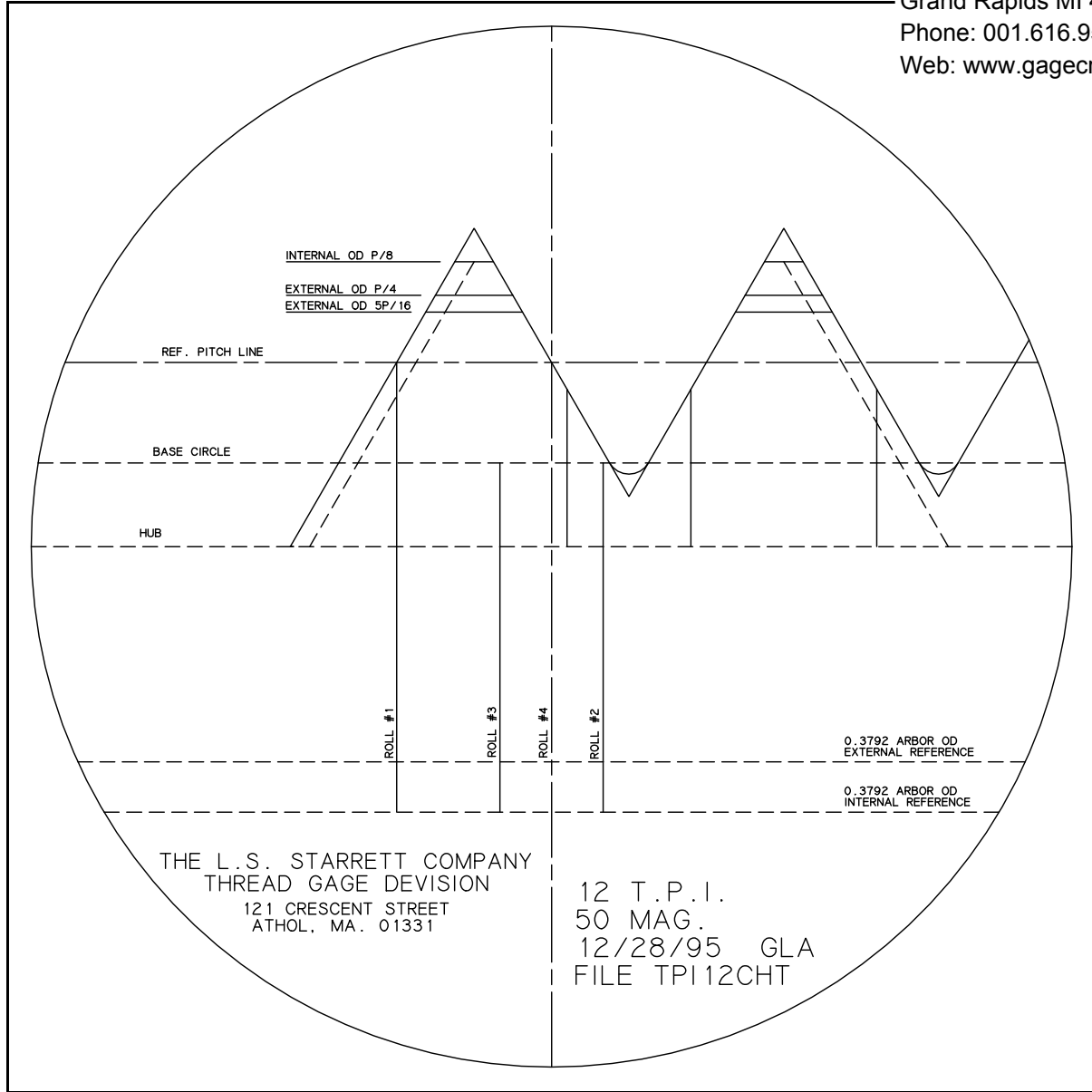
Gage Crib Worldwide Inc

6701 Old 28th St SE, Suite B

Grand Rapids MI 49546 USA

Phone: 001.616.954.6581

Web: www.gagecrib.com

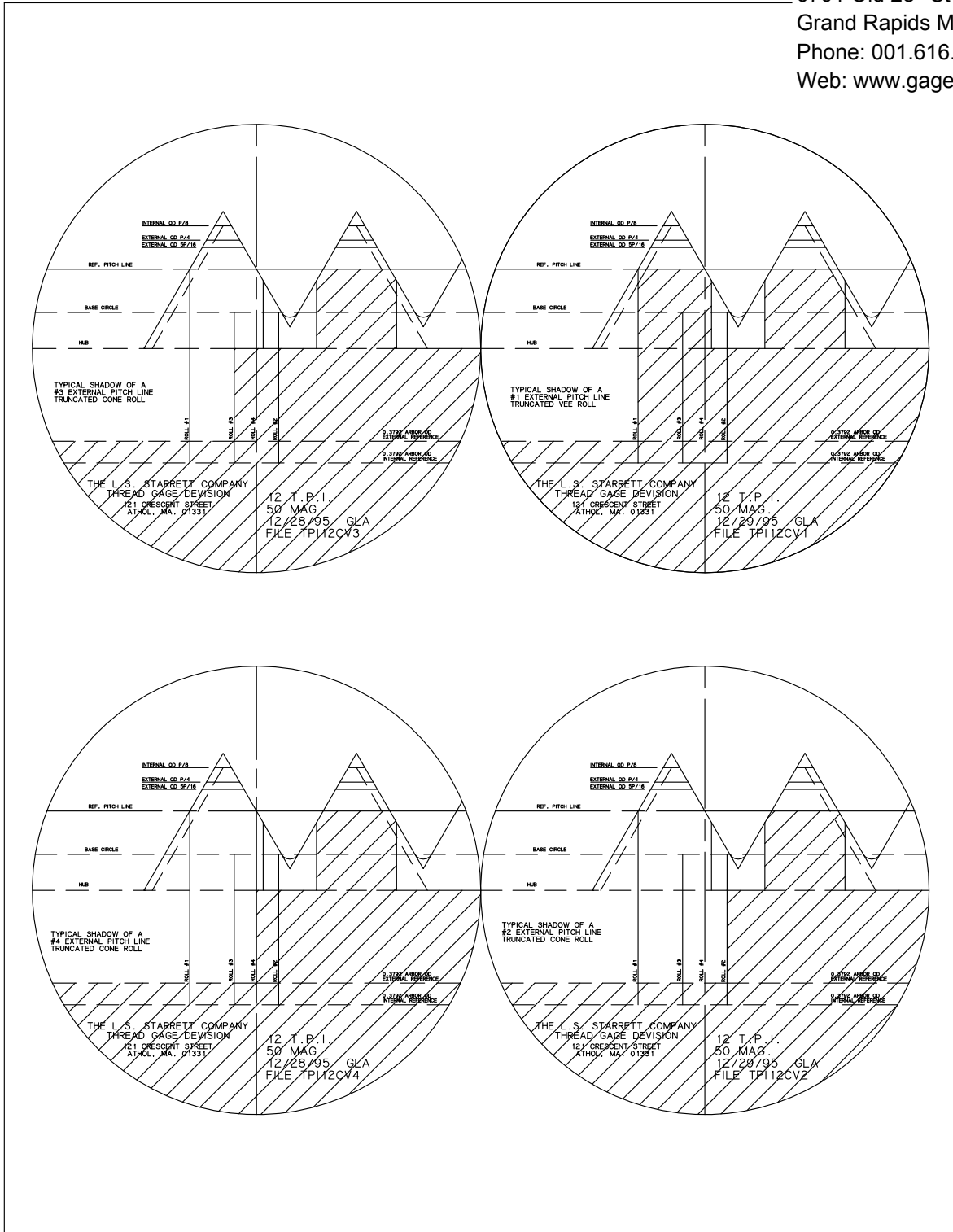


The typical chart shown above can be used to check wear of 60 degree Unified National Series types thread gaging rolls. The chart is designed to function with a Starrett Optical Measuring Projector Sigma HB400 series or equivalent. An ideal use of the above chart is to photo copy it and mark it up as a work sheet.

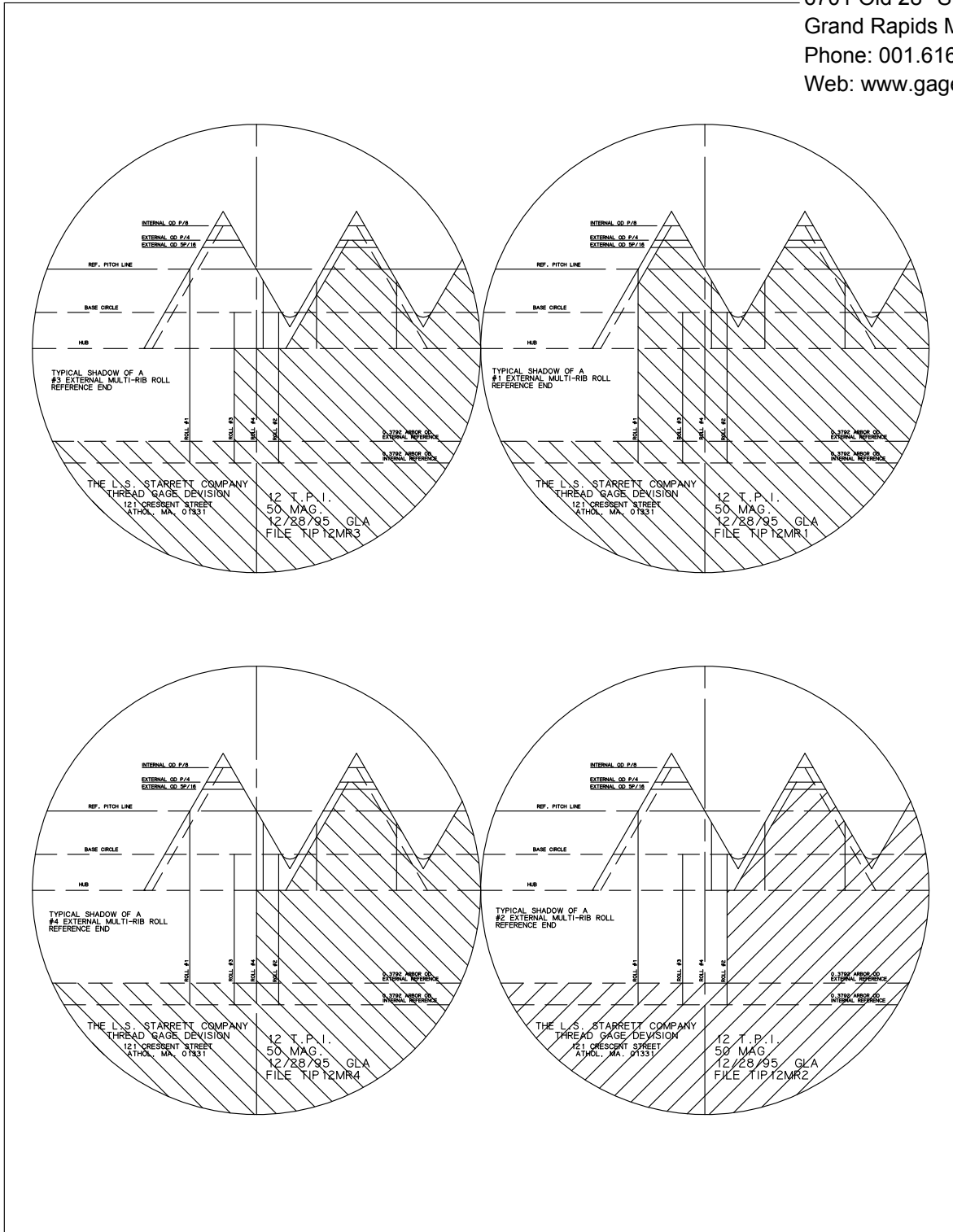
Roll Chart's Primary Use	
*	
1.	Check flank wear.
*	
2.	Checks root clearance because of flank wear.
3.	Detects wobble do to a worn hole.
Inspection Of New Rolls	
*	
1.	The general form may be quickly checked. (Cone & Vee, Multi-Ribbed, UN, UNJ, Pitch, External, Internal, Etc.)
2.	Pitch Diameter is checked to be with in specified limits for External and Internal system
3.	Stand off at the reference end of the roll is checked to be 1, 2, 3, 4.
4.	Check first and last flank for relief. (Multi-ribbed and Vee rolls)
*	
5.	Outside Diameter is truncated to the correct reference line. (UN, UNJ, Etc.)

* May be used for 1140 Internal Segments also.

Distributed by:
 Gage Crib Worldwide Inc
 6701 Old 28th St SE, Suite B
 Grand Rapids MI 49546 USA
 Phone: 001.616.954.6581
 Web: www.gagecrib.com



THE ABOVE 4 ILLUSTRATIONS WITH SHADOWED SECTION
 SHOW THE STANDARD EXTERNAL CONE & VEE UN PROFILES
 HAVING P/2 TRUNCATION.



THE ABOVE 4 ILLUSTRATIONS WITH SHADOWED SECTION
 SHOW THE STANDARD EXTERNAL MULTI-RIBBED UN PROFILES
 HAVING P/4 TRUNCATION.