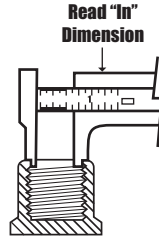
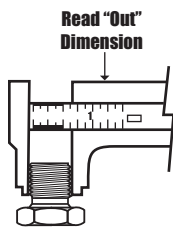
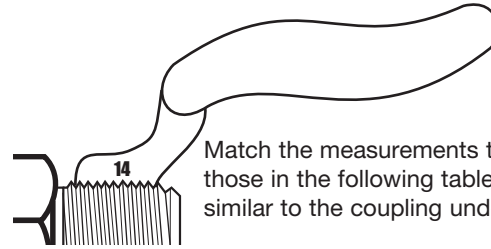


## Measuring Threads

With the caliper measure the thread diameter of the largest point. (Outside diameter (O.D.) of male threads - Inside Diameter (I.D.) of female threads.)

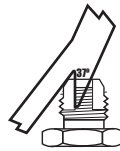
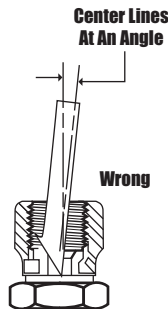
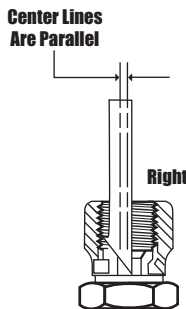


Using the thread gauge, determine the number of threads per inch. Comparison of gauge and coupling threads against a lighted background will insure an accurate reading.

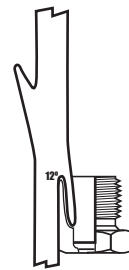


## Measuring Seat Angles

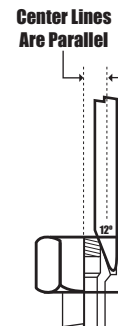
Using the seat gauge, determine the angle of the seat, as illustrated. When the centerline of the seat gauge extends parallel with the projected longitudinal axis of the coupling, then the angles of the gauge and seat match.



DIN 37°



DIN 24°



Compare the measurements taken to a coupling shown in the following tables that appear to be similar.

**NOTE:** Thread binding will occur when different thread configurations are used. DO NOT mix thread configurations.

## Thread Chart

DASH SIZE	2	3	4	5	6	7	8	10	12	14	16	20	24	32	40	48
NPTF Pipe Thread	1/8-27		1/4-18		3/8-18		1/2-14		3/4-14		1-11-1/2	1-1/4-11-1/2	1-1/2-11-1/2	2-11-1/2	2-1/2-8	3-8
NPSM Swivel Thread	1/8-27		1/4-18		3/8-18		1/2-14		3/4-14		1-11-1/2	1-1/4-11-1/2	1-1/2-11-1/2	2-11-1/2		
JIC 37° Flare Thread	5/16-24	3/8-24	7/16-20	1/2-20	9/16-18		3/4-16	7/8-14	1-1/16-12	1-3/16-12	1-5/16-12	1-5/8-12	1-7/8-12	2-1/2-12	3-12	3-1/2-12
SAE 45° Flare Thread	5/16-24	3/8-24	7/16-20	1/2-20	5/8-18	11/16-16	3/4-16	7/8-14	1-1/16-14							
SAE O-Ring Thread	5/16-24	3/8-24	7/16-20	1/2-20	9/16-18		3/4-16	7/8-14	1-1/16-12	1-3/16-12	1-5/16-12	1-5/8-12	1-7/8-12	2-1/2-12		
Flat-Face Thread		9/16-18		11/16-16		13/16-16	1-14	1-3/16-12		1-7/16-12	1-11/16-12	2-12				
Inverted Flare Thread	5/16-28	3/8-24	7/16-24	1/2-20	5/8-18	11/16-18	3/4-18	7/8-18	1/16-16							
Compression Thread	5/16-24	3/8-24	7/16-24	1/2-24	9/16-24	5/8-24	11/16-20	13/16-18	1-18							
Code 61 Flange Head O.D.							1.19	1.34	1.50		1.75	2.00	2.38	2.81	3.31	4.00
Code 62 Flange Head O.D.							1.25		1.62		1.88	2.12	2.50	3.12		
BSPF Thread	1/8-28		1/4-19		3/8-19		1/2-14	5/8-14	3/4-14		1-11	1-1/4-11	1-1/2-11	2-11		
BSPT Thread	1/8-28		1/4-19		3/8-19		1/2-14	5/8-14	3/4-14		1-11	1-1/4-11	1-1/2-11	2-11		
Japanese Pipe Tapered Thread	1/8-28		1/4-19		3/8-19		1/2-14	5/8-14	3/4-14		1-11	1-1/4-11	1-1/2-11	2-11		
Japanese Flare Thread	1/8-28		1/4-19		3/8-19		1/2-14	5/8-14	3/4-14		1-11	1-1/4-11	1-1/2-11	2-11		
Copper/Nylon Air Brake Thread			7/16-24		17/32-24		11/16-20	13/16-18	1-18							

METRIC (mm)	8	10	12	14	16	18	20	22	24	26	30	33	36	42	45	52
Whitworth	8X1.0	10X1.0	12X1.5		16X1.5	18X1.5		22X1.5								
MDL			M12X1.5	M14X1.5	M16X1.5	M18X1.5		M22X1.5		M26X1.5	M30X2.0		M36X2.0		M45X2.0	M52X2.0
MDH					M16X1.5	M18X1.5	M20X1.5		M24X1.5		M30X2.0		M36X2.0	M42X2.0	M45X2.0	M52X2.0
Komatsu						M18X1.5		M22X1.5	M24X1.5		M30X1.5	M33X1.5	M36X1.5	M42X1.5		
French							M20X1.5		M24X1.5		M30X1.5		M36X1.5		M45X1.5	M52X1.5