

**MIL-STD-112A**  
**Change Notice 2**  
**19 August 1960**

**MILITARY STANDARD**  
**GAGES, RING, PLAIN, GO**

**TO ALL ACTIVITIES:**

1. The following pages of this standard have been revised and supersede the pages listed:

<i>New page</i>	<i>Date</i>	<i>Superseded page</i>	<i>Date</i>
iii	19 August 1960	iii	8 December 1955
1	19 August 1960	1	6 February 1957
2	19 August 1960	2	6 February 1957
3	19 August 1960	3	8 December 1955

2. The following is a cumulative list of earlier changes:

<i>New page</i>	<i>Date</i>	<i>Superseded page</i>	<i>Date</i>
1	6 February 1957	1	8 December 1955
2	6 February 1957	2	8 December 1955
4	6 February 1957	4	8 December 1955
5	6 February 1957	5	8 December 1955
6	6 February 1957	6	8 December 1955
7	6 February 1957	7	8 December 1955

3. Retain this cover page and insert before table of contents of this standard.

4. Destroy previous notice.

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## FIGURES

### Figure

1. Go plain ring gage
2. Plain plug acceptance check gage (wire type)
3. Go plain ring gage
4. Go plain ring gage (flange type)

## TABLES

### Table

- I. Tabulation of design and identification data

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## **1. SCOPE**

**1.1** This standard covers pertinent design data and stock numbers for American Gage Design Standard, go plain ring gages for the inspection of the maximum limits of external diameters that range in size from .059 to 2.510 inches inclusive in increments of .001 and .03125 inches. The class of gage required is listed in accordance with the total component tolerance.

**1.1.1** This standard also covers pertinent design data and stock numbers for the applicable American Gage Design Standard

plain plug acceptance check gages for go plain ring gages up to and including .250 inch in size, except that acceptance check stock numbers are not provided above .125 inch in size for total component tolerance of .008 and above.

**1.2** The stock numbers listed in this standard have been approved by the Cataloging Division, Office of the Assistant Secretary of Defense as Federal stock numbers (FSN). See 3.

## **2. REFERENCED DOCUMENTS**

**2.1** The issues of the following documents in effect on the date of invitation for bids form a part of this standard.

**STANDARD**

**MIL-STD-110 — Gages, Plug, Plain Cylindrical, Go.**

(Application for copies should be addressed to the Superintendent of Documents, U. S. Government Printing Office, Washington 25, D. C.)

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**SPECIFICATIONS**

MIL-G-45653 — Gages, Cylindrical  
Plug and Ring,  
Plain.

(Copies of specifications should be obtained from the procuring activity or as directed by the contracting officer.)

**OTHER PUBLICATIONS**

U.S. Department of Commerce, Com-  
mercial Standard CS8, Gage Blanks.

(Application for copies should be addressed to the Superintendent of Documents, U. S. Government Printing Office, Washington 25, D. C.)

**3. DEFINITIONS**

3.1 The Federal stock number (FSN) consists of the applicable seven digit Federal item identification number designated in table I as "FIIN—Gage stock No." prefixed by the Federal supply classification (FSC),

"5220". The Federal stock number shall be utilized in all instances and specified thus:  
4 digits, hyphen, 3 digits, hyphen, 4 digits.

Example: 5220-748-9311.

**4. GENERAL REQUIREMENTS**

4.1 Table I. Tabulation of design and identification data.

4.1.1 Stock numbers for each go plain ring

gage and related acceptance check plug gage are listed in ascending numerical sequence in columns B and C respectively.

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4.1.2 Column A lists the proper reference to the applicable figure for each stock number.

4.1.3 Column D lists the maximum component dimension and when applied to the total component tolerance in column E provides the data required for selecting the applicable stock number in column B or C.

4.1.3.1 When the total component tolerance is not listed the stock number applicable to the next smaller listed total component tolerance for the maximum component dimension shall be used.

4.1.4 Columns F to H inclusive list the design data for each stock number and, when applied to the figure referenced in column A,

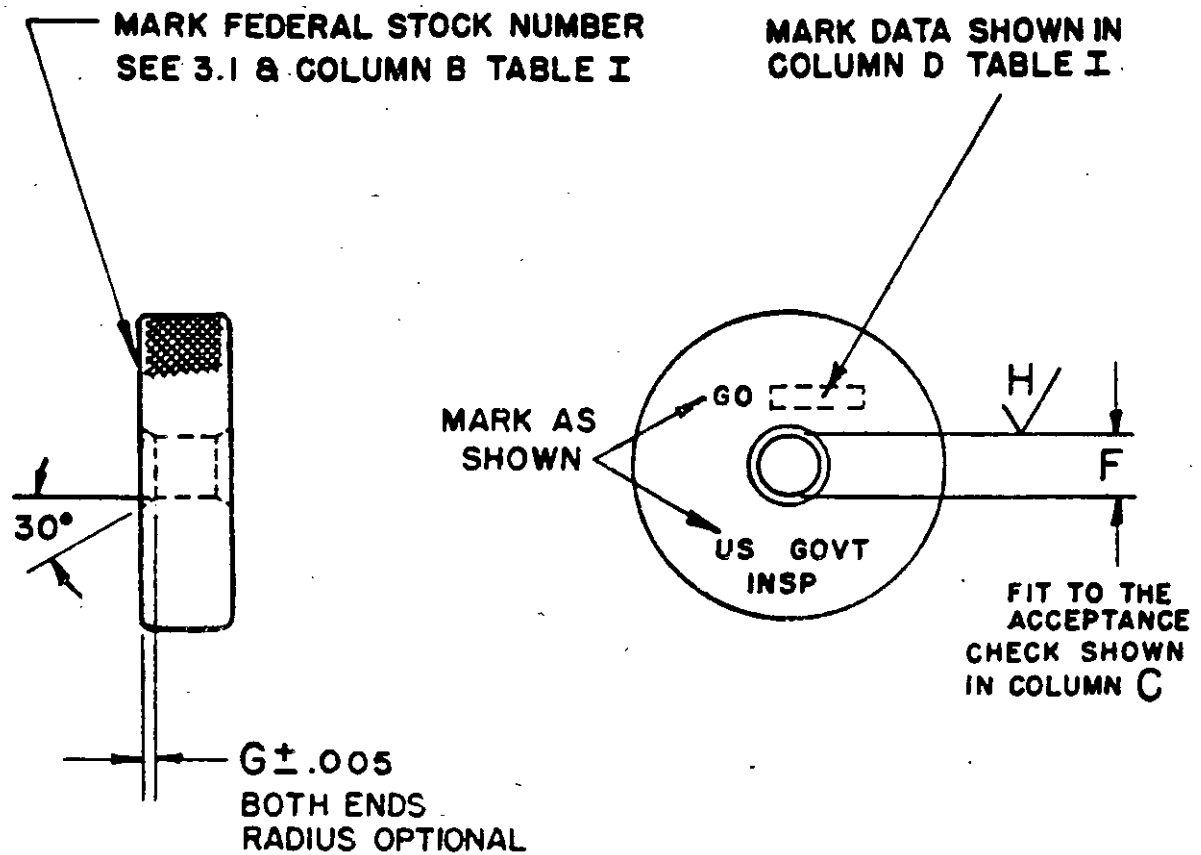
provide data required for manufacture and inspection.

4.1.5 Columns B to D inclusive list the identification data for each stock number, and, when applied to the figure referenced in column A, provide information for proper markings of the gages.

4.1.6 Design data, etc. not specifically covered in this standard shall conform to the latest issue of the documents referenced in paragraph 2 above.

4.1.7 Wear limit check plug stock numbers for go plain ring gages are provided in Standard MIL-STD-110. (Apply the stock number in column B as listed for the master as shown in column E, corresponding to the applicable component dimension in column D.)

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**HARDNESS: ROCKWELL OR EQUIVALENT  
C63 TO C66**

FIG. 1. Go plain ring gage