

**MIL-STD-112A**  
**Notice 3**  
**17 September 1962**

**MILITARY STANDARD**

**GAGES, RING, PLAIN, GO**

**TO ALL ACTIVITIES:**

1. The following pages of Mil-Std-112A have been revised and supersede the pages listed:

<i>New page</i>	<i>Date</i>	<i>Superseded page</i>	<i>Date</i>
1	17 September 1962	1	19 August 1960
2	17 September 1962	2	19 August 1960
3	17 September 1962	3	19 August 1960
4	17 September 1962	4	6 February 1957
5	17 September 1962	5	6 February 1957
6	17 September 1962	6	6 February 1957
7	17 September 1962	7	6 February 1957

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

<i>New page</i>	<i>Date</i>	<i>Superseded page</i>	<i>Date</i>
iii	19 August 1960	iii	8 December 1955

3. Retain this notice and insert before table of contents.

4. Holder of Mil-Std-112A will verify that page changes indicated above have been entered and will destroy the previous notice. Activities which stock these notices for issue are warned that each notice together with its appended revised pages, is in effect a separate publication to be retained until the Military Standard is completely revised or canceled.

**FSC 5220**

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## 1. SCOPE

1.1 This standard covers pertinent design data and Mil-Std part 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 Mil-Std Part 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 part numbers are not provided above .125 inch in size for total component tolerance of .008 and above.

## 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.)

### SPECIFICATION

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, Commercial Standard CS8, Gage Blanks.

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

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### **3. DEFINITIONS**

**3.1** The heading of columns B and C in table I should be "Mil-Std part No."

### **4. GENERAL REQUIREMENTS**

**4.1** **TABLE I.** Tabulation of design and identification data.

**4.1.1** Part 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.

**4.1.2** Column A lists the proper reference to the applicable figure for each part 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 part number in column B or C.

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4.1.3.1 When the total component tolerance is not listed, the part 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 part number and, when applied to the figure referenced in column A, provide data required for manufacture and inspection.

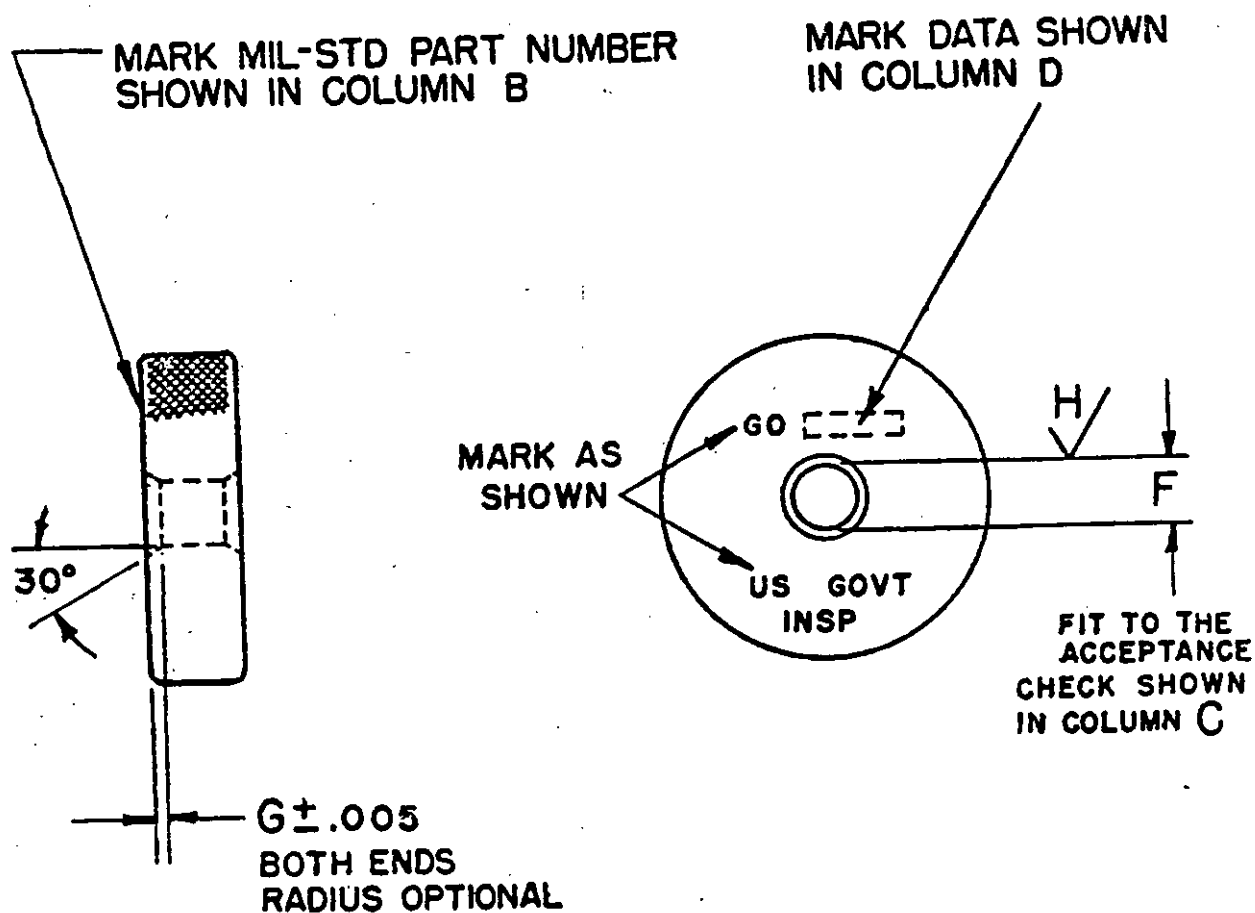
4.1.5 Columns B to D inclusive list the identification data for each part number, and, when applied to the figure referenced in

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 part numbers for go plain ring gages are provided in Standard Mil-Std-110. (Apply the part 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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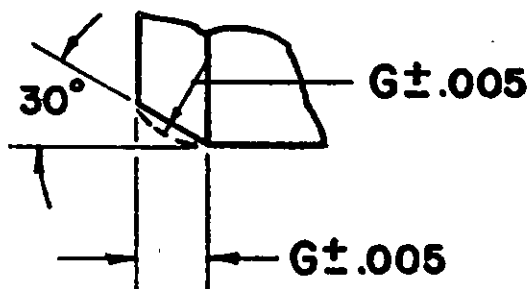
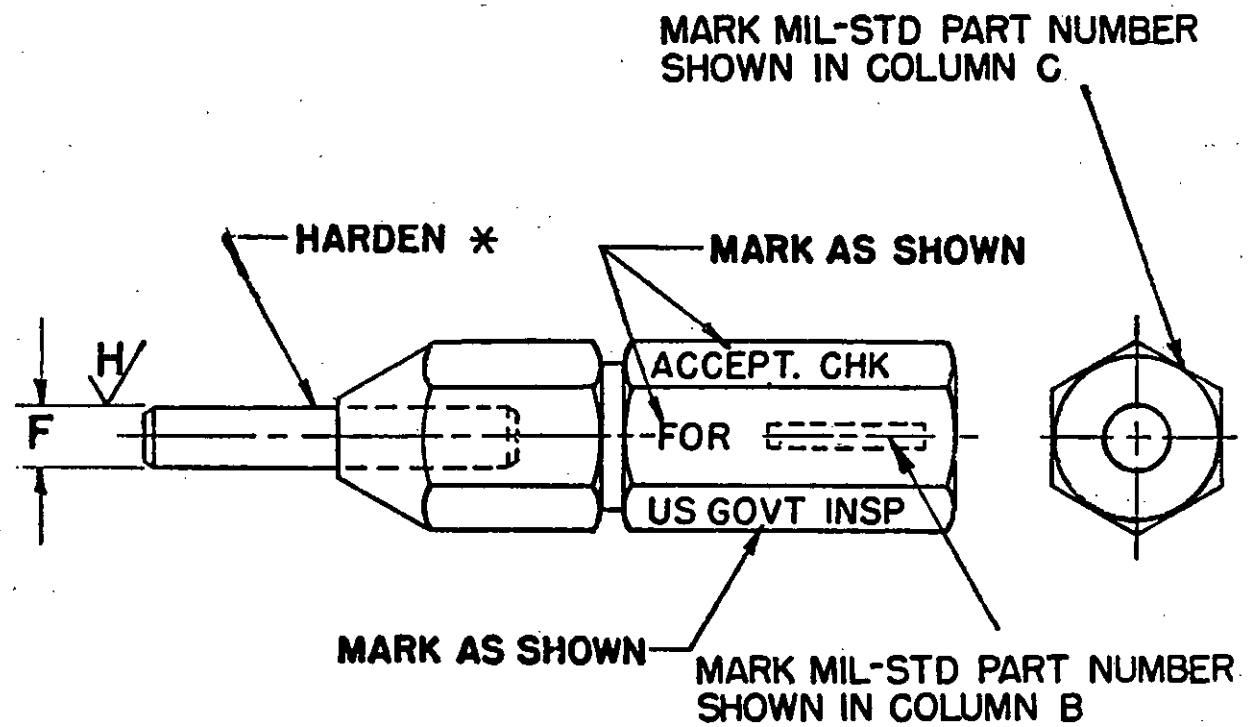


**HARDNESS: ROCKWELL OR EQUIVALENT**  
**C63 TO C66**

FIGURE 1. *Go plain ring gage.*

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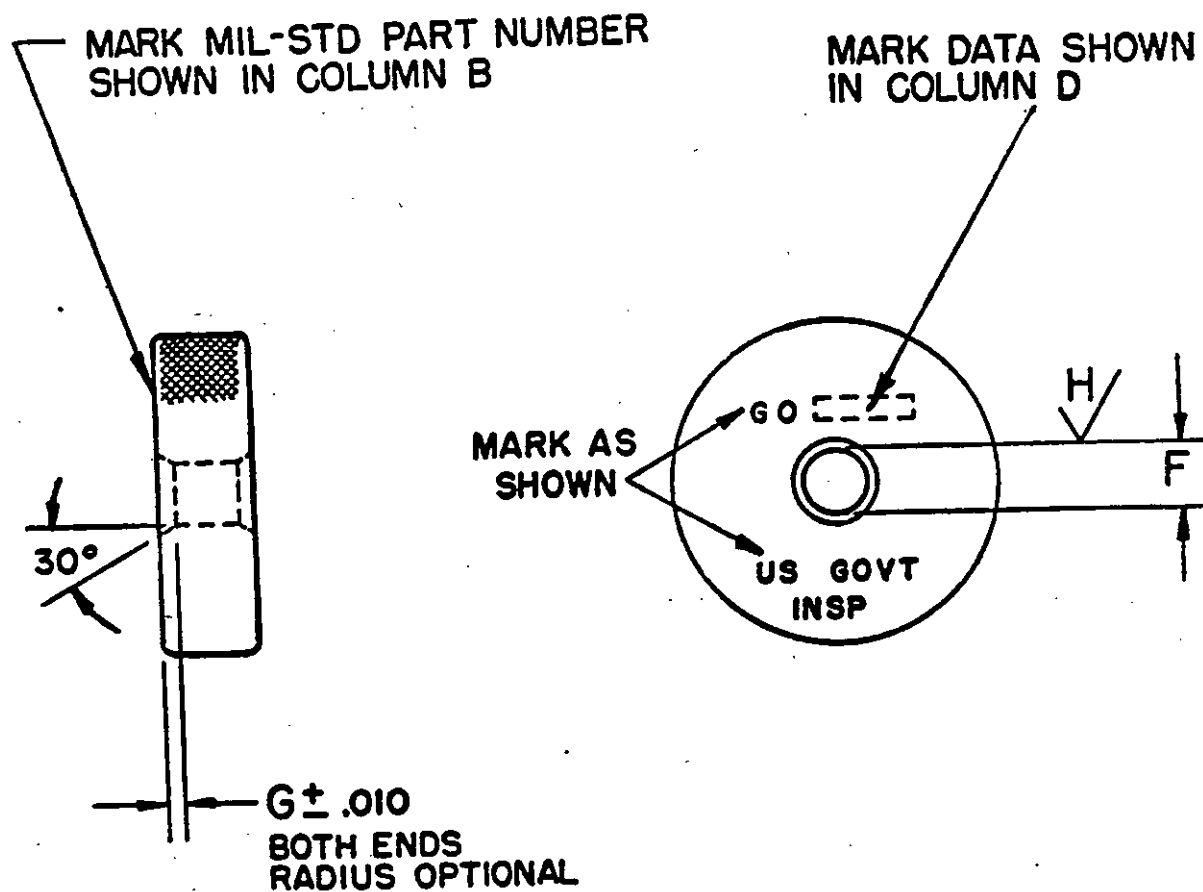
**ENLARGED VIEW**  
**CHAMFER OR RADIUS ON**  
**BOTH ENDS OF WIRE**

**\* HARDEN: ROCKWELL OR EQUIVALENT**  
**C55 TO C60 FOR DIA UP TO AND INCL .10**  
**C60 TO C63 FOR DIA ABOVE .10 TO AND INCL .20**  
**C63 TO C66 FOR DIA ABOVE .20**

FIGURE 2. Plain plug acceptance check gage (wire type).

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

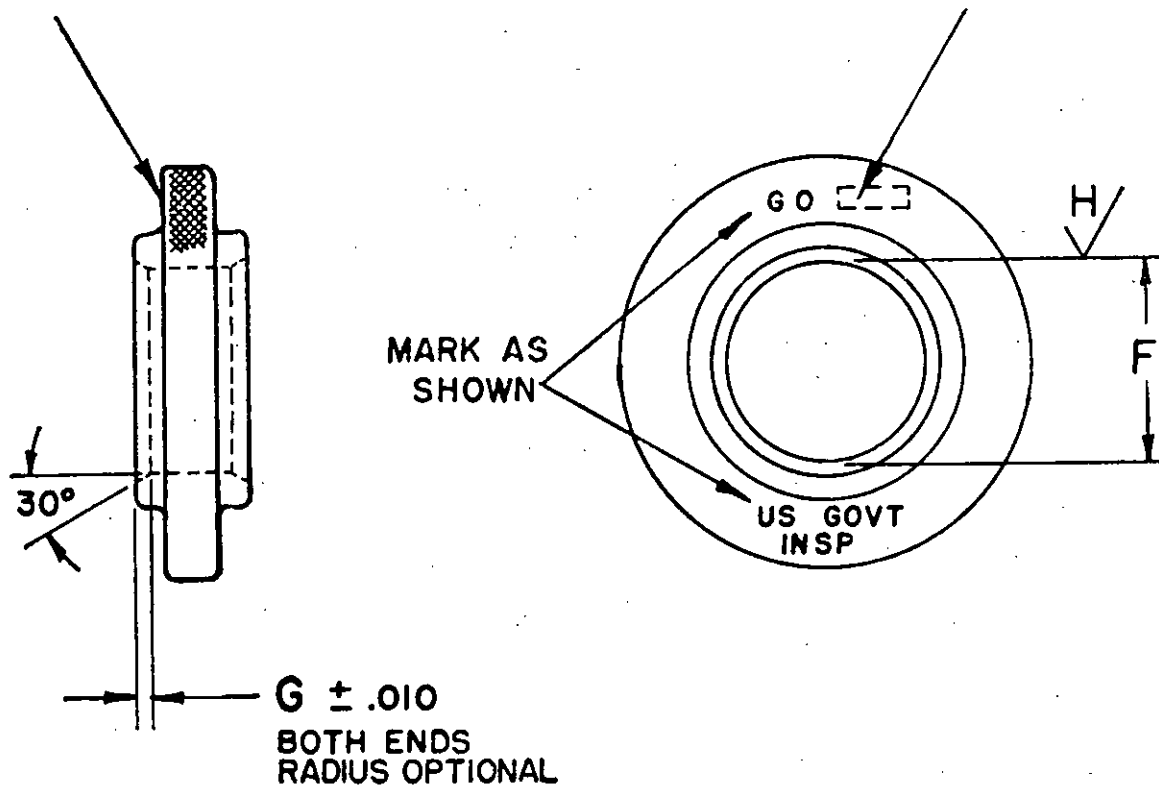
FIGURE 3. Go plain ring gage.

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MARK MIL-STD PART NUMBER  
SHOWN IN COLUMN B

MARK DATA SHOWN  
IN COLUMN D



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

FIGURE 4. Go plain ring gage (flange type).

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