

**MIL-STD-114C**

**15 MARCH 1968**

**SUPERSEDING**

**MIL-STD-114B**

**27 MARCH 1959**

**MILITARY STANDARD**

**GAGES, PLUG, THREAD**

**GO (CLASS X)**

**FOR**

**UNIFIED & AMERICAN NATIONAL**

**STANDARD INTERNAL THREADS**



**FED SUP CLASS  
5220**

Mil-Std-114C  
15 March 1963

DEPARTMENT OF DEFENSE  
WASHINGTON 25, D.C.

Gages, Plug, Thread, Go (Class X) for Unified & American National  
Standard Internal Threads

Mil-Std-114C

1. This standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, and the Air Force, effective 15 March 1963.

2. Recommended corrections, additions, or deletions should be addressed to Headquarters, DSA, Standardization Division, Washington 25, D. C.

Mil-Std-114C  
15 MARCH 1963

## CONTENTS

Paragraph		Page
1.	Scope	1
2.	Referenced Documents	1
3.	Definitions	2
4.	General Requirements	2
4.1.1	Table I, II, and III - Tabulation of Design and Identification Data	2
4.1.2	Table IV - Listing of Mil-Std Part Numbers in Numerical Sequence	3
5.	Procurement	3

## FIGURES

Figure		
1.	Go Thread Plug Gage (Taperlock Type)	4
2.	Go Thread Plug Gage (Trilock Type)	5

## TABLES

Table		
I.	Tabulation of Design and Identification Data - Unified Standard Thread	6
II.	Tabulation of Design and Identification Data - American National Standard Thread	26
III.	Tabulation of Design and Identification Data - Special (UNS) Threads	27
IV.	Listing of Mil-Std Part Numbers in Numerical Sequence	29

Mil-Std-114C  
15 MARCH 1963

## 1. Scope

1.1 This standard covers pertinent design data and Mil-Std Part Numbers for American Gage Design Standard, single end, go, right-hand thread plug gages for the inspection of the minimum limits of Unified Standard Classes 1B, 2B, 3B and American National Standard Classes 1, 2, 3 internal threads.

1.2 The same go thread plug gage is applied to classes 1, 1B, 2, 2B, 3 and 3B internal threads having the same nominal size and threads per inch. This is a basic gage and the thread designation omits any reference to class.

Example: .2500-20UNC

1.3 The design data for go thread plug gages employs class "X" gage manufacturing tolerances in accordance with the U. S. Department of Commerce Handbook H28 "Screw-Thread Standards for Federal Services".

## 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-10 Surface Roughness Waviness and Lay

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

### Specification

Mil-G-45654 Gages, Plug and Ring, Thread

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

### Other Publications

U.S. Department of Commerce, National Bureau of Standards, Handbook H28 "Screw-Thread Standards for Federal Services".

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.)

Mil-Std-114C  
15 MARCH 1963

### 3. Definitions

Not applicable

### 4. General Requirements

4.1 This standard contains four tables. Table I provides tabulated design data required for manufacture and inspection and is arranged in ascending size sequence according to thread designation for Unified Standard gages. Table II - Design data for American National Standard gages is the same (see 1.2) as Unified Standard gages and no data is listed. Reference should be made to table I for required data. Table III contains thread designations previously listed in the Standard series. They have been redesignated from standard to special (UNS) threads and are listed herein for reference purposes. Table IV is a listing of Mil-Std Part Numbers in ascending numerical sequence, and is provided as an aid for locating the required design data contained in tables I, II, and III for any given Mil-Std Part Number.

#### 4.1.1 Tables I, II, and III. Tabulation of Design and Identification Data.

4.1.1.1 Mil-Std Part Numbers and the corresponding thread designations for each go thread plug gage are listed in columns B and C respectively.

4.1.1.2 Column A lists the proper reference to the applicable figure (drawing) for each Mil-Std Part Number.

4.1.1.3 Columns B to D inclusive list the identification data for each Mil-Std Part Number and, when applied to the figure (drawing) referenced in column A, provide information for proper marking of the gages. It is not necessary to mark the "5220" indicated in column B on the gage. For example: Mil-Std Part Number 5220-751-4001 may be marked 7514001 on the gage.

4.1.1.4 Columns E to J inclusive list the design data for each Mil-Std Part Number and when applied to the figure (drawing) referenced in column A, provide data required for manufacture and inspection.

4.1.1.5 The unit of measurement in columns D, E, F, G, and J is inches. Column H is  $\pm$  minutes of a degree.

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

Mil-Std-114C  
15 MARCH 1963

**4.1.2 Table IV. Listing of Mil-Std Part Numbers in Numerical Sequence.**

**4.1.2.1 All Mil-Std Part Numbers contained in this standard are listed in ascending numerical sequence in column A.**

**4.1.2.2 Column B references the page number in tables I, II, and III where the design and identification data for the applicable Mil-Std Part Numbers may be found.**

**5. Procurement**

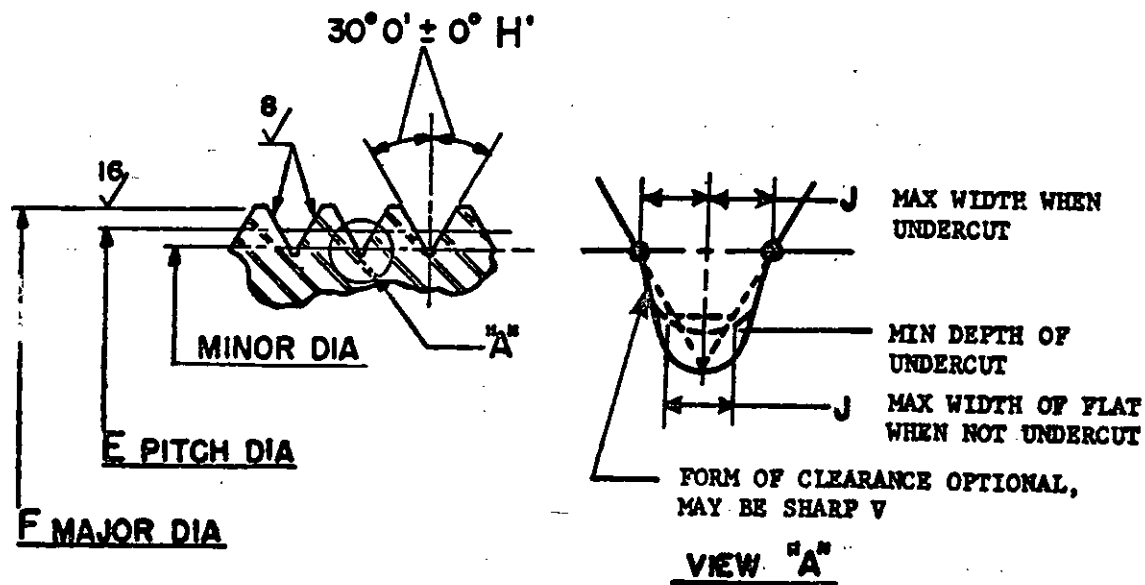
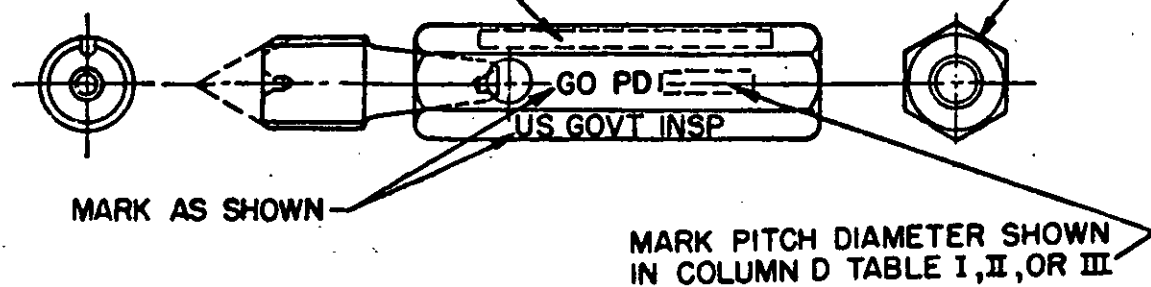
**5.1 The general requirements and tabulated design data contained in this standard are applicable for procurement purposes, as are the referenced manufacturing and inspection specifications.**

**5.2 Ordering Data. Procurement documents should specify the following:**

- (a) Title, number, and date of this standard**
- (b) Number of gages required and Mil-Std Part Number**
- (c) Place of delivery for acceptance inspection**

Mil-Std-114C

15 MARCH 1963

MARK THREAD DESIGNATION SHOWN  
IN COLUMN C TABLE I, II, OR IIIMARK MIL-STD PART NUMBER SHOWN  
IN COLUMN B TABLE I, II, OR III

TOLERANCE ON LEAD C

FIGURE 1. Go thread plug gage (taperlock type)

Mil-Std-114C  
15 MARCH 1963

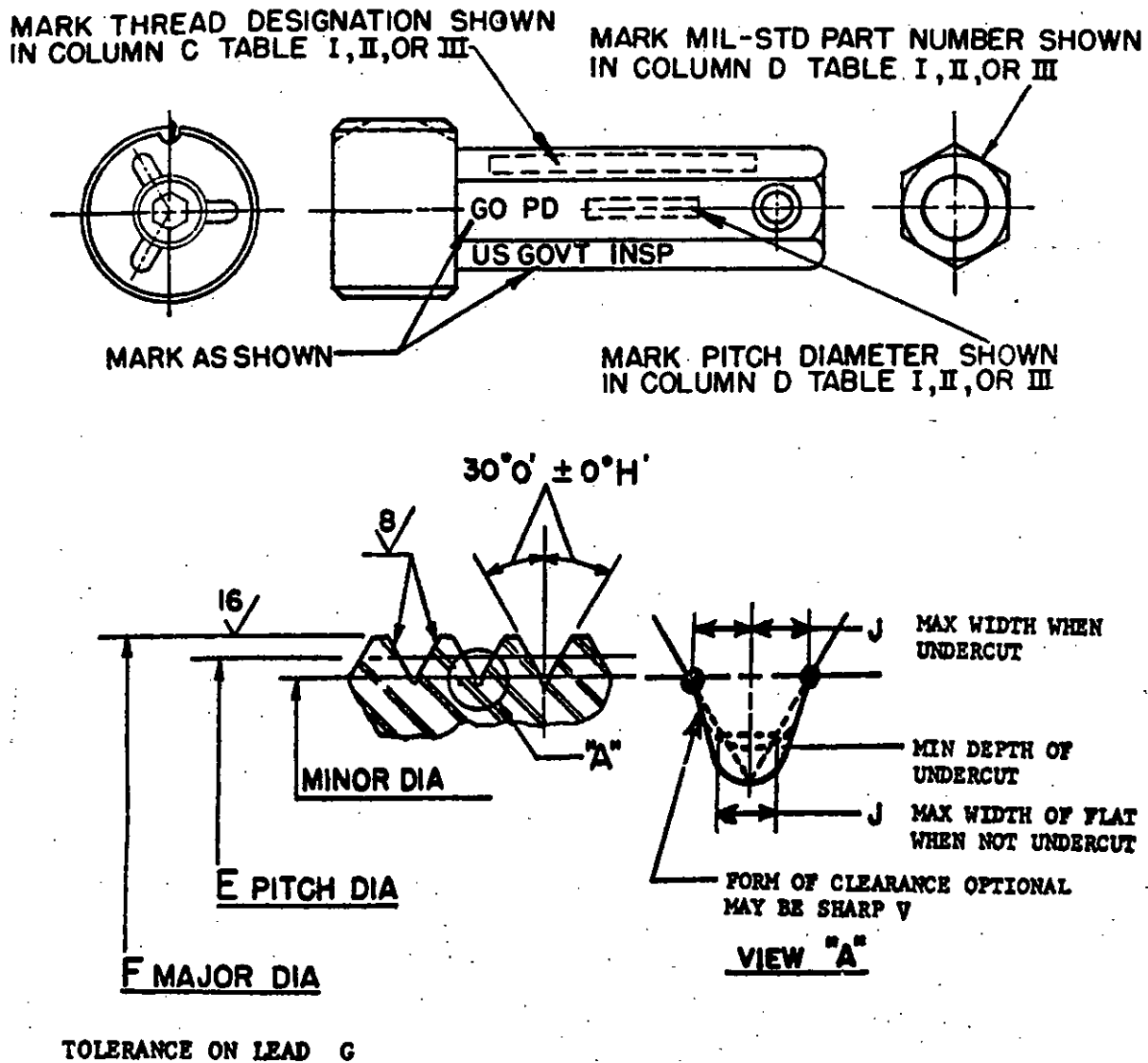


FIGURE 2. Go thread plug gage (trilock type)



MIL-STD-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS					
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	J
A	B	C	D	E	F	G	H	J	
1	5220-751-4001	(0) .060-80UNF	.0519	.0519 + .0002	.0600 + .0003	.0002	30	.0016	
1	5220-751-4002	(1) .073-64UNC	.0629	.0629 + .0002	.0730 + .0004	.0002	30	.0020	
1	5220-751-4003	(1) .073-72UNF	.0640	.0640 + .0002	.0730 + .0003	.0002	30	.0017	
1	5220-751-4004	(2) .086-56UNC	.0744	.0744 + .0002	.0860 + .0004	.0002	30	.0022	
1	5220-751-4005	(2) .086-64UNF	.0759	.0759 + .0002	.0860 + .0004	.0002	30	.0020	
1	5220-751-4006	(3) .099-48UNC	.0855	.0855 + .0002	.0990 + .0004	.0002	30	.0026	
1	5220-751-4007	(3) .099-56UNF	.0874	.0874 + .0002	.0990 + .0004	.0002	30	.0022	
1	5220-751-4008	(4) .112-40UNC	.0958	.0958 + .0002	.1120 + .0004	.0002	20	.0031	
1	5220-751-4009	(4) .112-48UNF	.0985	.0985 + .0002	.1120 + .0004	.0002	30	.0026	
1	5220-751-4010	(5) .125-40UNC	.1088	.1088 + .0002	.1250 + .0004	.0002	20	.0031	
1	5220-751-4011	(5) .125-44UNF	.1102	.1102 + .0002	.1250 + .0004	.0002	20	.0028	
1	5220-751-4012	(6) .138-32UNC	.1177	.1177 + .0003	.1380 + .0005	.0003	15	.0039	
1	5220-751-4013	(6) .138-40UNF	.1218	.1218 + .0002	.1380 + .0004	.0002	20	.0031	
1	5220-751-4014	(8) .164-32UNC	.1437	.1437 + .0003	.1640 + .0005	.0003	15	.0039	
1	5220-751-4015	(8) .164-36UNF	.1460	.1460 + .0002	.1640 + .0004	.0002	20	.0035	
1	5220-751-4016	(10) .190-24UNC	.1629	.1629 + .0003	.1900 + .0005	.0003	15	.0052	

Mil-Std-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

Q	Q	MARKING ON GAGE HANDLE		GO PITCH DIA	THREAD PLUG GAGE DIMENSIONS				ROOT CLEAR
		MIL-STD PART NUMBER	THREAD DESIGNATION		PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	
A	B	C	D	E	F	G	H	J	
1	5220-751-4017	(10) .190-32UNF	.1697	.1697 + .0003	.1900 + .0005	.0003	15	.0039	
1	5220-751-4018	(12) .216-24UNC	.1889	.1889 + .0003	.2160 + .0005	.0003	15	.0052	
1	5220-751-4019	(12) .216-28UNF	.1928	.1928 + .0003	.2160 + .0005	.0003	15	.0045	
1	5220-751-7090	(12) .216-32UNEF	.1957	.1957 + .0003	.2160 + .0005	.0003	15	.0039	
1	5220-751-4020	.2500-20UNC	.2175	.2175 + .0003	.2500 + .0005	.0003	15	.0062	
1	5220-751-4021	.2500-28UNF	.2268	.2268 + .0003	.2500 + .0005	.0003	15	.0045	
1	5220-751-4022	.2500-32UNEF	.2297	.2297 + .0003	.2500 + .0005	.0003	15	.0039	
1	5220-751-4023	.3125-18UNC	.2764	.2764 + .0003	.3125 + .0005	.0003	10	.0069	
1	7517139	.3125-20UN	.2800	.2800 + .0003	.3125 + .0005	.0003	15	.0062	
1	5220-751-4024	.3125-24UNF	.2854	.2854 + .0003	.3125 + .0005	.0003	15	.0052	
1	7517140	.3125-28UN	.2893	.2893 + .0003	.3125 + .0005	.0003	15	.0045	
1	5220-751-4025	.3125-32UNEF	.2922	.2922 + .0003	.3125 + .0005	.0003	15	.0030	
1	5220-751-4026	.3750-16UNC	.3344	.3344 + .0003	.3750 + .0006	.0003	10	.0078	
1	7517141	.3750-20UN	.3425	.3425 + .0003	.3750 + .0005	.0003	15	.0062	
1	5220-751-4027	.3750-24UNF	.3479	.3479 + .0003	.3750 + .0005	.0003	15	.0052	
1	7517142	.3750-28UN	.3518	.3518 + .0003	.3750 + .0005	.0003	15	.0045	

Mil-Std-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
1	5220-751-4028	.3750-32UNEF	.3547	.3547 + .0003	.3750 + .0005	.0003	15	.0039
1	5220-751-4029	.4375-14UNC	.3911	.3911 + .0003	.4375 + .0006	.0003	10	.0089
1	7517143	.4375-16UN	.3969	.3969 + .0003	.4375 + .0006	.0003	10	.0078
1	5220-751-4030	.4375-20UNF	.4050	.4050 + .0003	.4375 + .0005	.0003	15	.0062
1	5220-751 4031	.4375-28UNEF	.4143	.4143 + .0003	.4375 + .0005	.0003	15	.0045
1	7517144	.4375-32UN	.4172	.4172 + .0003	.4375 + .0005	.0003	15	.0039
1	5220-751-4032	.5000-13UNC	.4500	.4500 + .0003	.5000 + .0006	.0003	10	.0096
1	7517145	.5000-16UN	.4594	.4594 + .0003	.5000 + .0006	.0003	10	.0078
1	5220-751-4033	.5000-20UNF	.4675	.4675 + .0003	.5000 + .0005	.0003	15	.0062
1	5220-751-4034	.5000-28UNEF	.4768	.4768 + .0003	.5000 + .0005	.0003	15	.0045
1	7517146	.5000-32UN	.4797	.4797 + .0003	.5000 + .0005	.0003	15	.0039
1	5220-751-4035	.5625-12UNC	.5084	.5084 + .0003	.5625 + .0006	.0003	10	.0104
1	7517147	.5625-16UN	.5219	.5219 + .0003	.5625 + .0006	.0003	10	.0078
1	5220-751-4036	.5625-18UNF	.5264	.5264 + .0003	.5625 + .0005	.0003	10	.0069
1	7517148	.5625-20UN	.5300	.5300 + .0003	.5625 + .0005	.0003	15	.0062
1	5220-751-4037	.5625-24UNEF	.5354	.5354 + .0003	.5625 + .0005	.0003	15	.0052

Mil-Std-114C  
 15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS					
MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	
A	B	C	D	E	F	G	H	J
1	7517149	.5625-28UN	.5393	.5393 + .0003	.5625 + .0005	.0003	15	.0045
1	7517150	.5625-32UN	.5422	.5422 + .0003	.5625 + .0005	.0003	15	.0039
1	5220-751-4038	.6250-11UNC	.5660	.5660 + .0003	.6250 + .0006	.0003	10	.0114
1	5220-751-0114	.6250-12UN	.5709	.5709 + .0003	.6250 + .0006	.0003	10	.0104
1	7517151	.6250-16UN	.5844	.5844 + .0003	.6250 + .0006	.0003	10	.0078
1	5220-751-4039	.6250-18UNF	.5889	.5889 + .0003	.6250 + .0005	.0003	10	.0069
1	7517152	.6250-20UN	.5925	.5925 + .0003	.6250 + .0005	.0003	15	.0062
1	5220-751-4040	.6250-24UNEF	.5979	.5979 + .0003	.6250 + .0005	.0003	15	.0052
1	7517153	.6250-28UN	.6018	.6018 + .0003	.6250 + .0005	.0003	15	.0045
1	7517154	.6250-32UN	.6047	.6047 + .0003	.6250 + .0005	.0003	15	.0039
1	5220-751-0120	.6875-12UN	.6334	.6334 + .0003	.6875 + .0006	.0003	10	.0104
1	7517155	.6875-16UN	.6469	.6469 + .0003	.6875 + .0006	.0003	10	.0078
1	7517156	.6875-20UN	.6550	.6550 + .0003	.6875 + .0005	.0003	15	.0062
1	5220-751-4041	.6875-24UNEF	.6604	.6604 + .0003	.6875 + .0005	.0003	15	.0052
1	7517157	.6875-28UN	.6643	.6643 + .0003	.6875 + .0005	.0003	15	.0045
1	7517158	.6875-32UN	.6672	.6672 + .0003	.6875 + .0005	.0003	15	.0039

MIL-STD-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS					
MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	
B	C	D	E	F	G	H	J	
1 5220-751-4042	.7500-10UNC	.6850	.6850 + .0003	.7500 + .0006	.0003	10	.0125	
1 5220-751-0126	.7500-12UN	.6959	.6959 + .0003	.7500 + .0006	.0003	10	.0104	
1 5220-751-4043	.7500-16UNF	.7094	.7094 + .0003	.7500 + .0006	.0003	10	.0078	
1 5220-751-4044	.7500-20UNEF	.7175	.7175 + .0003	.7500 + .0005	.0003	15	.0062	
1 7517159	.7500-28UN	.7268	.7268 + .0003	.7500 + .0005	.0003	15	.0045	
1 7517160	.7500-32UN	.7297	.7297 + .0003	.7500 + .0005	.0003	15	.0039	
1 5220-751-0132	.8125-12UN	.7584	.7584 + .0003	.8125 + .0006	.0003	10	.0104	
1 5220-751-0134	.8125-16UN	.7719	.7719 + .0003	.8125 + .0006	.0003	10	.0078	
1 5220-751-4045	.8125-20UNEF	.7800	.7800 + .0003	.8125 + .0005	.0003	15	.0062	
1 7517161	.8125-28UN	.7893	.7893 + .0003	.8125 + .0005	.0003	15	.0045	
1 7517162	.8125-32UN	.7922	.7922 + .0003	.8125 + .0005	.0003	15	.0039	
1 5220-751-4046	.8750-9UNC	.8028	.8028 + .0003	.8750 + .0007	.0003	10	.0139	
1 5220-751-0140	.8750-12UN	.8209	.8209 + .0003	.8750 + .0006	.0003	10	.0104	
1 5220-751-4047	.8750-14UNF	.8286	.8286 + .0003	.8750 + .0006	.0003	10	.0089	
1 5220-751-0144	.8750-16UN	.8344	.8344 + .0003	.8750 + .0006	.0003	10	.0078	
1 5220-751-4048	.8750-20UNEF	.8425	.8425 + .0003	.8750 + .0005	.0003	15	.0062	

Mil-Std-114C  
 15 MARCH 1968

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
1	7517163	.8750-28UN	.8518	.8518 + .0003	.8750 + .0005	.0003	15	.0045
1	7517164	.8750-32UN	.8547	.8547 + .0003	.8750 + .0005	.0003	15	.0039
1	5220-751-0148	.9375-12UN	.8834	.8834 + .0003	.9375 + .0006	.0003	10	.0104
1	5220-751-0150	.9375-16UN	.8969	.8969 + .0003	.9375 + .0006	.0003	10	.0078
1	5220-751-4049	.9375-20UNEF	.9050	.9050 + .0003	.9375 + .0005	.0003	15	.0062
1	7517165	.9375-28UN	.9143	.9143 + .0003	.9375 + .0005	.0003	15	.0045
1	7517166	.9375-32UN	.9172	.9172 + .0003	.9375 + .0005	.0003	15	.0039
1	5220-751-4050	1.0000-8UNC	.9188	.9188 + .0004	1.0000 + .0007	.0004	5	.0156
1	5220-751-4051	1.0000-12UNF, 12N	.9459	.9459 + .0003	1.0000 + .0006	.0003	10	.0104
1	5220-751-0160	1.0000-16UN	.9594	.9594 + .0003	1.0000 + .0006	.0003	10	.0078
1	5220-751-4053	1.0000-20UNEF	.9675	.9675 + .0003	1.0000 + .0005	.0003	15	.0062
1	7517167	1.0000-28UN	.9768	.9768 + .0003	1.0000 + .0005	.0003	15	.0045
1	7517168	1.0000-32UN	.9797	.9797 + .0003	1.0000 + .0005	.0003	15	.0039
1	7517169	1.0625-8UN	.9813	.9813 + .0004	1.0625 + .0007	.0004	5	.0156
1	5220-751-4054	1.0625-12UN	1.0084	1.0084 + .0003	1.0625 + .0006	.0003	10	.0104
1	5220-751-0166	1.0625-16UN	1.0219	1.0219 + .0003	1.0625 + .0006	.0003	10	.0078

Mil-Std-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

Q	Q	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS					
		MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	A	B	C	D	E	F	G	H	J
1	1	5220-751-4055	1.0625-18UNEF	1.0264	1.0264 + .0003	1.0625 + .0005	.0003	10	.0069
1	1	7517170	1.0625-20UN	1.0300	1.0300 + .0003	1.0625 + .0005	.0003	15	.0062
1	1	7517171	1.0625-28UN	1.0393	1.0393 + .0003	1.0625 + .0005	.0003	15	.0045
1	1	5220-751-4056	1.1250-7UNC	1.0322	1.0322 + .0004	1.1250 + .0007	.0004	5	.0179
1	1	5220-751-4057	1.1250-8UN	1.0438	1.0438 + .0004	1.1250 + .0007	.0004	5	.0156
1	1	5220-751-4058	1.1250-12UNF	1.0709	1.0709 + .0003	1.1250 + .0006	.0003	10	.0104
1	1	5220-751-0176	1.1250-16UN	1.0844	1.0844 + .0003	1.1250 + .0006	.0003	10	.0078
1	1	5220-751-4059	1.1250-18UNEF	1.0889	1.0889 + .0003	1.1250 + .0005	.0003	10	.0069
1	1	7517172	1.1250-20UN	1.0925	1.0925 + .0003	1.1250 + .0005	.0003	15	.0062
1	1	7517173	1.1250-28UN	1.1018	1.1018 + .0003	1.1250 + .0005	.0003	15	.0045
1	1	7517174	1.1875-8UN	1.1063	1.1063 + .0004	1.1875 + .0007	.0004	5	.0156
1	1	5220-751-4060	1.1875-12UN	1.1334	1.1334 + .0003	1.1875 + .0006	.0003	10	.0104
1	1	5220-751-0182	1.1875-16UN	1.1469	1.1469 + .0003	1.1875 + .0006	.0003	10	.0078
1	1	5220-751-4061	1.1875-18UNEF	1.1514	1.1514 + .0003	1.1875 + .0005	.0003	10	.0069
1	1	7517175	1.1875-20UN	1.1550	1.1550 + .0003	1.1875 + .0005	.0003	15	.0062
1	1	7517176	1.1875-28UN	1.1643	1.1643 + .0003	1.1875 + .0005	.0003	15	.0045

Mil-Std-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS					
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	
A	B	C	D	E	F	G	H	J	
1	5220-751-4062	1.2500-7UNC	1.1572	1.1572 + .0004	1.2500 + .0007	.0004	5	.0179	
1	5220-751-4063	1.2500-8UN	1.1688	1.1688 + .0004	1.2500 + .0007	.0004	5	.0156	
1	5220-751-4064	1.2500-12UNF	1.1959	1.1959 + .0003	1.2500 + .0006	.0003	10	.0104	
1	5220-751-0192	1.2500-16UN	1.2094	1.2094 + .0003	1.2500 + .0006	.0003	10	.0078	
1	5220-751-4065	1.2500-18UNEF	1.2139	1.2139 + .0003	1.2500 + .0005	.0003	10	.0069	
1	7517177	1.2500-20UN	1.2175	1.2175 + .0003	1.2500 + .0005	.0003	15	.0062	
1	7517178	1.2500-28UN	1.2268	1.2268 + .0003	1.2500 + .0005	.0003	15	.0045	
1	7517179	1.3125-8UN	1.2313	1.2313 + .0004	1.3125 + .0007	.0004	5	.0156	
1	5220-751-4066	1.3125-12UN	1.2584	1.2584 + .0003	1.3125 + .0006	.0003	10	.0104	
1	5220-751-0198	1.3125-16UN	1.2719	1.2719 + .0003	1.3125 + .0006	.0003	10	.0078	
1	5220-751-4067	1.3125-18UNEF	1.2764	1.2764 + .0003	1.3125 + .0005	.0003	10	.0069	
1	7517180	1.3125-20UN	1.2800	1.2800 + .0003	1.3125 + .0005	.0003	15	.0062	
1	7517181	1.3125-28UN	1.2893	1.2893 + .0003	1.3125 + .0005	.0003	15	.0045	
1	5220-751-4068	1.3750-6UNC	1.2667	1.2667 + .0004	1.3750 + .0008	.0004	5	.0208	
1	5220-751-4069	1.3750-8UN	1.2938	1.2938 + .0004	1.3750 + .0007	.0004	5	.0156	
1	5220-751-4070	1.3750-12UNF	1.3209	1.3209 + .0003	1.3750 + .0006	.0003	10	.0104	



MIL-Std-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MIL-STD PART NUMBER	MARKING ON GAGE HANDLE		GO PITCH DIA	THREAD PLUG GAGE DIMENSIONS				
		THREAD DESIGNATION	PITCH		PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	D	E	F	G	H	J
1	5220-751-0208	1.3750-16UN	1.3344	1.3344	1.3344 + .0003	1.3750 + .0006	.0003	10	.0078
1	5220-751-4071	1.3750-18UNEF	1.3389	1.3389	1.3389 + .0003	1.3750 + .0005	.0003	10	.0069
1	7517182	1.3750-20UN	1.3425	1.3425	1.3425 + .0003	1.3750 + .0005	.0003	15	.0062
1	7517183	1.3750-28UN	1.3518	1.3518	1.3518 + .0003	1.3750 + .0005	.0003	15	.0045
1	7517184	1.4375-6UN	1.3292	1.3292	1.3292 + .0004	1.4375 + .0008	.0004	5	.0208
1	7517185	1.4375-8UN	1.3563	1.3563	1.3563 + .0004	1.4375 + .0007	.0004	5	.0156
1	5220-751-4072	1.4375-12UN	1.3834	1.3834	1.3834 + .0003	1.4375 + .0006	.0003	10	.0104
1	5220-751-0214	1.4375-16UN	1.3969	1.3969	1.3969 + .0003	1.4375 + .0006	.0003	10	.0078
1	5220-751-4073	1.4375-18UNEF	1.4014	1.4014	1.4014 + .0003	1.4375 + .0005	.0003	10	.0069
1	7517186	1.4375-20UN	1.4050	1.4050	1.4050 + .0003	1.4375 + .0005	.0003	15	.0062
1	7517187	1.4375-28UN	1.4143	1.4143	1.4143 + .0003	1.4375 + .0005	.0003	15	.0045
1	5220-751-4074	1.5000-6UNC	1.3917	1.3917	1.3917 + .0004	1.5000 + .0008	.0004	5	.0208
1	5220-751-4075	1.5000-8UN	1.4188	1.4188	1.4188 + .0004	1.5000 + .0007	.0004	5	.0156
1	5220-751-4076	1.5000-12UNF	1.4459	1.4459	1.4459 + .0003	1.5000 + .0006	.0003	10	.0104
1	5220-751-0224	1.5000-16UN	1.4594	1.4594	1.4594 + .0003	1.5000 + .0006	.0003	10	.0078
1	5220-751-4077	1.5000-18UNEF	1.4639	1.4639	1.4639 + .0003	1.5000 + .0005	.0003	10	.0069

Mil-Std-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG NO	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
1	7517188	1.5000-20UN	1.4675	1.4675 + .0003	1.5000 + .0005	.0003	15	.0062
1	7517189	1.5000-28UN	1.4768	1.4768 + .0003	1.5000 + .0005	.0003	15	.0045
2	7517190	1.5625-6UN	1.4542	1.4542 + .0005	1.5625 + .0008	.0004	5	.0208
2	7517191	1.5625-8UN	1.4813	1.4813 + .0005	1.5625 + .0007	.0004	5	.0156
2	7517192	1.5625-12UN	1.5084	1.5084 + .0004	1.5625 + .0006	.0003	10	.0104
2	5220-751-0228	1.5625-16UN	1.5219	1.5219 + .0004	1.5625 + .0006	.0003	10	.0078
2	5220-751-4078	1.5625-18UNEF	1.5264	1.5264 + .0004	1.5625 + .0005	.0003	10	.0069
2	7517193	1.5625-20UN	1.5300	1.5300 + .0004	1.5625 + .0005	.0003	15	.0062
2	7517194	1.6250-6UN	1.5167	1.5167 + .0005	1.6250 + .0008	.0004	5	.0208
2	5220-751-4079	1.6250-8UN	1.5438	1.5438 + .0005	1.6250 + .0007	.0004	5	.0156
2	5220-751-4080	1.6250-12UN	1.5709	1.5709 + .0004	1.6250 + .0006	.0003	10	.0104
2	5220-751-0236	1.6250-16UN	1.5844	1.5844 + .0004	1.6250 + .0006	.0003	10	.0078
2	5220-751-4081	1.6250-18UNEF	1.5889	1.5889 + .0004	1.6250 + .0005	.0003	10	.0069
2	7517195	1.6250-20UN	1.5925	1.5925 + .0004	1.6250 + .0005	.0003	15	.0062
2	7517196	1.6875-6UN	1.5792	1.5792 + .0005	1.6875 + .0008	.0004	5	.0208
2	7517197	1.6875-8UN	1.6063	1.6063 + .0005	1.6875 + .0007	.0004	5	.0156

Mil-Std-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)									
MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS						
MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR		
A	B	C	D	E	F	G	H	J	
2	7517198	1.6875-12UN	1.6334	1.6334 + .0004	1.6875 + .0006	.0003	10	.0104	
2	5220-751-0240	1.6875-16UN	1.6469	1.6469 + .0004	1.6875 + .0006	.0003	10	.0078	
2	5220-751-4082	1.6875-18UNEF	1.6514	1.6514 + .0004	1.6875 + .0005	.0003	10	.0069	
2	7517199	1.6875-20UN	1.6550	1.6550 + .0004	1.6875 + .0005	.0003	15	.0062	
2	5220-751-4083	1.7500-5UNC	1.6201	1.6201 + .0005	1.7500 + .0008	.0004	5	.0250	
2	7517200	1.7500-6UN	1.6417	1.6417 + .0005	1.7500 + .0008	.0004	5	.0208	
2	5220-751-4084	1.7500-8UN	1.6688	1.6688 + .0005	1.7500 + .0007	.0004	5	.0156	
2	5220-751-4085	1.7500-12UN	1.6959	1.6959 + .0004	1.7500 + .0006	.0003	10	.0104	
2	5220-751-4086	1.7500-16UN	1.7094	1.7094 + .0004	1.7500 + .0006	.0003	10	.0078	
2	7517201	1.7500-20UN	1.7175	1.7175 + .0004	1.7500 + .0005	.0003	15	.0062	
2	7517202	1.8125-6UN	1.7042	1.7042 + .0005	1.8125 + .0008	.0004	5	.0208	
2	7517203	1.8125-8UN	1.7313	1.7313 + .0005	1.8125 + .0007	.0004	5	.0156	
2	7517204	1.8125-12UN	1.7584	1.7584 + .0004	1.8125 + .0006	.0003	10	.0104	
2	5220-751-4087	1.8125-16UN	1.7719	1.7719 + .0004	1.8125 + .0006	.0003	10	.0078	
2	7517205	1.8125-20UN	1.7800	1.7800 + .0004	1.8125 + .0005	.0003	15	.0062	
2	7517206	1.8750-6UN	1.7667	1.7667 + .0005	1.8750 + .0008	.0004	5	.0208	

Mil-Std-114c

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
2	5220-751-4088	1.8750-8UN	1.7938	1.7938 + .0005	1.8750 + .0007	.0004	5	.0156
2	5220-751-4089	1.8750-12UN	1.8209	1.8209 + .0004	1.8750 + .0006	.0003	10	.0104
2	5220-751-4090	1.8750-16UN	1.8344	1.8344 + .0004	1.8750 + .0006	.0003	10	.0078
2	7517207	1.8750-20UN	1.8425	1.8425 + .0004	1.8750 + .0005	.0003	15	.0062
2	7517208	1.9375-6UN	1.8292	1.8292 + .0005	1.9375 + .0008	.0004	5	.0208
2	7517209	1.9375-8UN	1.8563	1.8563 + .0005	1.9375 + .0007	.0004	5	.0156
2	7517210	1.9375-12UN	1.8834	1.8834 + .0004	1.9375 + .0006	.0003	10	.0104
2	5220-751-4091	1.9375-16UN	1.8969	1.8969 + .0004	1.9375 + .0006	.0003	10	.0078
2	7517211	1.9375-20UN	1.9050	1.9050 + .0004	1.9375 + .0005	.0003	15	.0062
2	5220-751-4092	2.0000-4UNC	1.8557	1.8557 + .0005	2.0000 + .0008	.0004	5	.0278
2	7517212	2.0000-6UN	1.8917	1.8917 + .0005	2.0000 + .0008	.0004	5	.0208
2	5220-751-4093	2.0000-8UN	1.9188	1.9188 + .0005	2.0000 + .0007	.0004	5	.0156
2	5220-751-4094	2.0000-12UN	1.9459	1.9459 + .0004	2.0000 + .0006	.0003	10	.0104
2	5220-751-4095	2.0000-16UN	1.9594	1.9594 + .0004	2.0000 + .0006	.0003	10	.0078
2	7517213	2.0000-20UN	1.9675	1.9675 + .0004	2.0000 + .0005	.0003	15	.0062
2	7517214	2.1250-6UN	2.0167	2.0167 + .0005	2.1250 + .0008	.0004	5	.0208

MIL-Std-114C

15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)										
Q. NO.	MARKING ON GAGE HANDLE				THREAD PLUG GAGE DIMENSIONS					
	HIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	J	
A	B	C	D	E	F	G	H	J		
2	5220-751-4097	2.1250-8UN	2.0438	2.0438 + .0005	2.1250 + .0007	.0004	5	.0156		
2	5220-751-4098	2.1250-12UN	2.0709	2.0709 + .0004	2.1250 + .0006	.0003	10	.0104		
2	5220-751-4099	2.1250-16UN	2.0844	2.0844 + .0004	2.1250 + .0006	.0003	10	.0078		
2	7517215	2.1250-20UN	2.0925	2.0925 + .0004	2.1250 + .0005	.0003	15	.0062		
2	5220-751-4101	2.2500-4UNC	2.1057	2.1057 + .0005	2.2500 + .0008	.0004	5	.0278		
2	7517216	2.2500-6UN	2.1417	2.1417 + .0005	2.2500 + .0008	.0004	5	.0208		
2	5220-751-4102	2.2500-8UN	2.1688	2.1688 + .0005	2.2500 + .0007	.0004	5	.0156		
2	5220-751-4103	2.2500-12UN	2.1959	2.1959 + .0004	2.2500 + .0006	.0003	10	.0104		
2	5220-751-4104	2.2500-16UN	2.2094	2.2094 + .0004	2.2500 + .0006	.0003	10	.0078		
2	7517217	2.2500-20UN	2.2175	2.2175 + .0004	2.2500 + .0005	.0003	15	.0062		
2	7517218	2.3750-6UN	2.2667	2.2667 + .0005	2.3750 + .0008	.0004	5	.0208		
2	7517219	2.3750-8UN	2.2938	2.2938 + .0005	2.3750 + .0007	.0004	5	.0156		
2	5220-751-4106	2.3750-12UN	2.3209	2.3209 + .0004	2.3750 + .0006	.0003	10	.0104		
2	5220-751-4107	2.3750-16UN	2.3344	2.3344 + .0004	2.3750 + .0006	.0003	10	.0078		
2	7517220	2.3750-20UN	2.3425	2.3425 + .0004	2.3750 + .0005	.0003	15	.0062		
2	5220-751-4109	2.5000-4UNC	2.3376	2.3376 + .0005	2.5000 + .0009	.0004	5	.0312		

. M11-Std-114C  
 15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR J
A	B	C	D	E	F	G	H
2	751722	2.5000-6UN	2.3917	2.3917 + .0005	2.5000 + .0008	.0004	5
2	5220-751-4110	2.5000-8UN	2.4188	2.4188 + .0005	2.5000 + .0007	.0004	5
2	5220-751-4111	2.5000-12UN	2.4459	2.4459 + .0004	2.5000 + .0006	.0003	10
2	5220-751-4112	2.5000-16UN	2.4594	2.4594 + .0004	2.5000 + .0006	.0003	10
2	7517222	2.5000-20UN	2.4675	2.4675 + .0004	2.5000 + .0005	.0003	15
2	7517223	2.6250-6UN	2.5167	2.5167 + .0005	2.6250 + .0008	.0004	5
2	7517224	2.6250-8UN	2.5438	2.5438 + .0005	2.6250 + .0007	.0004	5
2	5220-751-4113	2.6250-12UN	2.5709	2.5709 + .0004	2.6250 + .0006	.0003	10
2	5220-751-4114	2.6250-16UN	2.5844	2.5844 + .0004	2.6250 + .0006	.0003	10
2	7517225	2.6250-20UN	2.5925	2.5925 + .0004	2.6250 + .0005	.0003	15
2	5220-751-4115	2.7500-4UNC	2.5876	2.5876 + .0005	2.7500 + .0009	.0004	5
2	7517226	2.7500-6UN	2.6417	2.6417 + .0005	2.7500 + .0008	.0004	5
2	5220-751-4116	2.7500-8UN	2.6688	2.6688 + .0005	2.7500 + .0007	.0004	5
2	5220-751-4117	2.7500-12UN	2.6959	2.6959 + .0004	2.7500 + .0006	.0003	10
2	5220-751-4118	2.7500-16UN	2.7094	2.7094 + .0004	2.7500 + .0006	.0003	10
2	7517227	2.7500-20UN	2.7175	2.7175 + .0004	2.7500 + .0005	.0003	15

MIL-Std-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

Q	QIA	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS					
		MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HAIF ON ANGLE TOL	ROOT ON CLEAR
A		B	C	D	E	F	G	H	J
2		7517228	2.8750-6UN	2.7667	2.7667 + .0005	2.8750 + .0008	.0004	5	.0208
2		7517229	2.8750-8UN	2.7938	2.7938 + .0005	2.8750 + .0007	.0004	5	.0156
2		5220-751-4119	2.8750-12UN	2.8209	2.8209 + .0004	2.8750 + .0006	.0003	10	.0104
2		5220-751-4120	2.8750-16UN	2.8344	2.8344 + .0004	2.8750 + .0006	.0003	10	.0078
2		7517230	2.8750-20UN	2.8425	2.8425 + .0004	2.8750 + .0005	.0003	15	.0062
2		5220-751-4121	3.0000-4UNC	2.8376	2.8376 + .0005	3.0000 + .0009	.0004	5	.0312
2		7517231	3.0000-6UN	2.8917	2.8917 + .0005	3.0000 + .0008	.0004	5	.0208
2		5220-751-4122	3.0000-8UN	2.9188	2.9188 + .0005	3.0000 + .0007	.0004	5	.0156
2		5220-751-4123	3.0000-12UN	2.9459	2.9459 + .0004	3.0000 + .0006	.0003	10	.0104
2		5220-751-4124	3.0000-16UN	2.9594	2.9594 + .0004	3.0000 + .0006	.0003	10	.0078
2		7517232	3.0000-20UN	2.9675	2.9675 + .0004	3.0000 + .0005	.0003	15	.0062
2		7517233	3.1250-6UN	3.0167	3.0167 + .0005	3.1250 + .0008	.0004	5	.0208
2		7517234	3.1250-8UN	3.0438	3.0438 + .0005	3.1250 + .0007	.0004	5	.0156
2		5220-751-4125	3.1250-12UN	3.0709	3.0709 + .0004	3.1250 + .0006	.0003	10	.0104
2		5220-751-4126	3.1250-16UN	3.0844	3.0844 + .0004	3.1250 + .0006	.0003	10	.0078
2		5220-751-4127	3.2500-4UNC	3.0876	3.0876 + .0005	3.2500 + .0009	.0004	5	.0312

Mil-Std-114C  
 15 MARCH 1968

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

Table I. Tabulation of Design and Identification Data - Unified Standard Interchangeable Gages (Continued)									
MARKING ON GAGE HANDLE				THREAD PLUG GAGE DIMENSIONS					
FIG. NO.	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL		ROOT CLEAR	
						ON LEAD	HALF ANGLE TOL		
A	B	C	D	E	F	G	H	J	
2	7517222	3.2500-6UN	3.1417	3.1417 + .0005	3.2500 + .0008	.0004	5	.0208	
2	5220-751-4128	3.2500-8UN	3.1688	3.1688 + .0005	3.2500 + .0007	.0004	5	.0156	
2	5220-751-4129	3.2500-12UN	3.1959	3.1959 + .0004	3.2500 + .0006	.0003	10	.0104	
2	5220-751-4130	3.2500-16UN	3.2094	3.2094 + .0004	3.2500 + .0006	.0003	10	.0078	
2	7517236	3.3750-6UN	3.2667	3.2667 + .0005	3.3750 + .0008	.0004	5	.0208	
2	7517237	3.3750-8UN	3.2938	3.2938 + .0005	3.3750 + .0007	.0004	5	.0156	
2	5220-751-4131	3.3750-12UN	3.3209	3.3209 + .0004	3.3750 + .0006	.0003	10	.0104	
2	5220-751-4132	3.3750-16UN	3.3344	3.3344 + .0004	3.3750 + .0006	.0003	10	.0078	
2	5220-751-4133	3.5000-4UNC	3.3376	3.3376 + .0005	3.5000 + .0009	.0004	5	.0312	
2	7517238	3.5000-6UN	3.3917	3.3917 + .0005	3.5000 + .0008	.0004	5	.0208	
2	5220-751-4134	3.5000-8UN	3.4188	3.4188 + .0005	3.5000 + .0007	.0004	5	.0156	
2	5220-751-4135	3.5000-12UN	3.4459	3.4459 + .0004	3.5000 + .0006	.0003	10	.0104	
2	5220-751-4136	3.5000-16UN	3.4594	3.4594 + .0004	3.5000 + .0006	.0003	10	.0078	
2	7517239	3.6250-6UN	3.5167	3.5167 + .0005	3.6250 + .0008	.0004	5	.0208	
2	7517240	3.6250-8UN	3.5438	3.5438 + .0005	3.6250 + .0007	.0004	5	.0156	
2	5220-751-4137	3.6250-12UN	3.5709	3.5709 + .0004	3.6250 + .0006	.0003	10	.0104	



Mil-Std-114c  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS					
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
2	5220-751-4138	3.6250-16UN	3.5844	3.5844 + .0004	3.6250 + .0006	.0003	10	.0078
2	5220-751-4139	3.7500-4UNC	3.5876	3.5876 + .0005	3.7500 + .0009	.0004	5	.0312
2	7517241	3.7500-6UN	3.6417	3.6417 + .0005	3.7500 + .0008	.0004	5	.0208
2	5220-751-4140	3.7500-8UN	3.6688	3.6688 + .0005	3.7500 + .0007	.0004	5	.0156
2	5220-751-4141	3.7500-12UN	3.6959	3.6959 + .0004	3.7500 + .0006	.0003	10	.0104
2	5220-751-4142	3.7500-16UN	3.7094	3.7094 + .0004	3.7500 + .0006	.0003	10	.0078
2	7517242	3.8750-6UN	3.7667	3.7667 + .0005	3.8750 + .0008	.0004	5	.0208
2	7517243	3.8750-8UN	3.7938	3.7938 + .0005	3.8750 + .0007	.0004	5	.0156
2	5220-751-4143	3.8750-12UN	3.8209	3.8209 + .0004	3.8750 + .0006	.0003	10	.0104
2	5220-751-4144	3.8750-16UN	3.8344	3.8344 + .0004	3.8750 + .0006	.0003	10	.0078
2	5220-751-4145	4.0000-4UNC	3.8376	3.8376 + .0005	4.0000 + .0009	.0004	5	.0312
2	7517244	4.0000-6UN	3.8917	3.8917 + .0005	4.0000 + .0008	.0004	5	.0208
2	5220-751-4146	4.0000-8UN	3.9188	3.9188 + .0005	4.0000 + .0007	.0004	5	.0156
2	5220-751-4147	4.0000-12UN	3.9459	3.9459 + .0004	4.0000 + .0006	.0003	10	.0104
2	5220-751-4148	4.0000-16UN	3.9594	3.9594 + .0004	4.0000 + .0006	.0003	10	.0078
2	7517245	4.1250-6UN	4.0167	4.0167 + .0006	4.1250 + .0013	.0004	5	.0208

MIL-STD-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MIL-STD PART NUMBER	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS				
		THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B	C	D	E	F	G	H	J
2	751724	4.1250-12UN	4.0709	4.0709 + .0006	4.1250 + .0009	.0003	10	.0104
2	7517247	4.1250-16UN	4.0844	4.0844 + .0006	4.1250 + .0009	.0003	10	.0078
2	7517248	4.2500-4UN	4.0876	4.0876 + .0006	4.2500 + .0015	.0004	5	.0312
2	7517249	4.2500-6UN	4.1417	4.1417 + .0006	4.2500 + .0013	.0004	5	.0208
2	5220-751-4150	4.2500-12UN	4.1959	4.1959 + .0006	4.2500 + .0009	.0003	10	.0104
2	5220-751-4151	4.2500-16UN	4.2094	4.2094 + .0006	4.2500 + .0009	.0003	10	.0078
2	7517250	4.3750-6UN	4.2667	4.2667 + .0006	4.3750 + .0013	.0004	5	.0208
2	7517251	4.3750-12UN	4.3209	4.3209 + .0006	4.3750 + .0009	.0003	10	.0104
2	7517252	4.3750-16UN	4.3344	4.3344 + .0006	4.3750 + .0009	.0003	10	.0078
2	7517253	4.5000-4UN	4.3376	4.3376 + .0006	4.5000 + .0015	.0004	5	.0312
2	7517254	4.5000-6UN	4.3917	4.3917 + .0006	4.5000 + .0013	.0004	5	.0208
2	5220-751-4153	4.5000-12UN	4.4459	4.4459 + .0006	4.5000 + .0009	.0003	10	.0104
2	5220-751-4154	4.5000-16UN	4.4594	4.4594 + .0006	4.5000 + .0009	.0003	10	.0078
2	7517255	4.6250-6UN	4.5167	4.5167 + .0006	4.6250 + .0013	.0004	5	.0208
2	7517256	4.6250-12UN	4.5709	4.5709 + .0006	4.6250 + .0009	.0003	10	.0104
2	7517257	4.6250-16UN	4.5844	4.5844 + .0006	4.6250 + .0009	.0003	10	.0078

M11-Std-114C  
15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)									
FIG. NO.	MIL-STD PART NUMBER	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS					
		THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	
A	B	C	D	E	F	G	H	J	
2	7517258	4.7500-4UN	4.5876	4.5876 + .0006	4.7500 + .0015	.0004	5	.0312	
2	7517259	4.7500-6UN	4.6417	4.6417 + .0006	4.7500 + .0013	.0004	5	.0208	
2	5220-751-4156	4.7500-12UN	4.6959	4.6959 + .0006	4.7500 + .0009	.0003	10	.0104	
2	5220-751-4157	4.7500-16UN	4.7094	4.7094 + .0006	4.7500 + .0009	.0003	10	.0078	
2	7517260	4.8750-6UN	4.7667	4.7667 + .0006	4.8750 + .0013	.0004	5	.0208	
2	7517261	4.8750-12UN	4.8209	4.8209 + .0006	4.8750 + .0009	.0003	10	.0104	
2	7517262	4.8750-16UN	4.8344	4.8344 + .0006	4.8750 + .0009	.0003	10	.0078	
2	7517263	5.0000-4UN	4.8376	4.8376 + .0006	5.0000 + .0015	.0004	5	.0312	
2	7517264	5.0000-6UN	4.8917	4.8917 + .0006	5.0000 + .0013	.0004	5	.0208	
2	5220-751-4159	5.0000-12UN	4.9459	4.9459 + .0006	5.0000 + .0009	.0003	10	.0104	
2	5220-751-4160	5.0000-16UN	4.9594	4.9594 + .0006	5.0000 + .0009	.0003	10	.0078	
2	7517265	5.1250-12UN	5.0709	5.0709 + .0006	5.1250 + .0009	.0003	10	.0104	
2	7517266	5.1250-16UN	5.0844	5.0844 + .0006	5.1250 + .0009	.0003	10	.0078	
2	7517267	5.2500-4UN	5.0876	5.0876 + .0006	5.2500 + .0015	.0004	5	.0312	
2	5220-751-4162	5.2500-12UN	5.1959	5.1959 + .0006	5.2500 + .0009	.0003	10	.0104	
2	5220-751-4163	5.2500-16UN	5.2094	5.2094 + .0006	5.2500 + .0009	.0003	10	.0078	

Mil-Std-114C  
 15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIG. NO.	MIL-STD PART NUMBER	MARKING ON GAGE HANDLE		GO PITCH DIA	THREAD PLUG GAGE DIMENSIONS				
		THREAD DESIGNATION	C		PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR
A	B			D	E	F	G	H	J
2	751726	5.3750-12UN		5.3209	5.3209 + .0006	5.3750 + .0009	.0003	10	.0104
2	7517269	5.3750-16UN		5.3344	5.3344 + .0006	5.3750 + .0009	.0003	10	.0078
2	7517270	5.5000-4UN		5.3376	5.3376 + .0006	5.5000 + .0015	.0004	5	.0312
2	5220-751-4165	5.5000-12UN		5.4459	5.4459 + .0006	5.5000 + .0009	.0003	10	.0104
2	5220-751-4166	5.5000-16UN		5.4594	5.4594 + .0006	5.5000 + .0009	.0003	10	.0078
2	7517271	5.6250-12UN		5.5709	5.5709 + .0006	5.6250 + .0009	.0003	10	.0104
2	7517272	5.6250-16UN		5.5844	5.5844 + .0006	5.6250 + .0009	.0003	10	.0078
2	7517273	5.7500-4UN		5.5876	5.5876 + .0006	5.7500 + .0015	.0004	5	.0312
2	5220-751-4168	5.7500-12UN		5.6959	5.6959 + .0006	5.7500 + .0009	.0003	10	.0104
2	5220-751-4169	5.7500-16UN		5.7094	5.7094 + .0006	5.7500 + .0009	.0003	10	.0078
2	7517274	5.8750-12UN		5.8209	5.8209 + .0006	5.8750 + .0009	.0003	10	.0104
2	7517275	5.8750-16UN		5.8344	5.8344 + .0006	5.8750 + .0009	.0003	10	.0078
2	7517276	6.0000-4UN		5.8376	5.8376 + .0006	6.0000 + .0015	.0004	5	.0312
2	5220-751-4171	6.0000-12UN		5.9459	5.9459 + .0006	6.0000 + .0009	.0003	10	.0104
2	5220-751-4172	6.0000-16UN		5.9594	5.9594 + .0006	6.0000 + .0009	.0003	10	.0078

MIL-STD-114C  
15 MARCH 1963

Table II. Tabulation of Design and Identification Data - American National Standard Thread

FIG. NO.	MARKING ON GAGE HANDLE			THREAD PLUG GAGE DIMENSIONS				
	MIL-STD PART NUMBER	THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR J
A	B	C	D	E	F	G	H	J

Design data for American National Standard Thread gages is the same as for Unified Standard Thread gages. Refer to table I for required data.

Mil-Std-114C  
15 MARCH 1963

Table III. Tabulation of Design and Identification Data - Special (UNS) Threads

FIG. NO.	MIL-STD PART NUMBER	MARKING ON GAGE HANDLE		THREAD PLUG GAGE DIMENSIONS					
		THREAD DESIGNATION	GO PITCH DIA	PITCH DIAMETER	MAJOR DIAMETER	TOL ON LEAD	HALF ANGLE TOL	ROOT CLEAR	
A	B	C	D	E	F	G	H	J	
1	5220-751-0609	.5000-12UNS	.4459	.4459 +.0003	.5000 +.0006	.0003	10	.0104	
1	5220-751-4052	1.0000-14NS	.9536	.9536 +.0003	1.0000 +.0006	.0003	10	.0089	
2	5220-751-4096	2.0625-16UNS	2.0219	2.0219 +.0004	2.0625 +.0006	.0003	10	.0078	
2	5220-751-4100	2.1875-16UNS	2.1469	2.1469 +.0004	2.1875 +.0006	.0003	10	.0078	
2	5220-751-4105	2.3125-16UNS	2.2719	2.2719 +.0004	2.3125 +.0006	.0003	10	.0078	
2	5220-751-4108	2.4375-16UNS	2.3969	2.3969 +.0004	2.4375 +.0006	.0003	10	.0078	
2	5220-751-4149	4.2500-8UN	4.1688	4.1688 +.0006	4.2500 +.0011	.0004	5	.0156	
2	5220-751-4152	4.5000-8UN	4.4188	4.4188 +.0006	4.5000 +.0011	.0004	5	.0156	
2	5220-751-4155	4.7500-8UN	4.6688	4.6688 +.0006	4.7500 +.0011	.0004	5	.0156	
2	5220-751-4158	5.0000-8UN	4.9188	4.9188 +.0006	5.0000 +.0011	.0004	5	.0156	
2	5220-751-4161	5.2500-8UN	5.1688	5.1688 +.0006	5.2500 +.0011	.0004	5	.0156	
2	5220-751-4164	5.5000-8UN	5.4188	5.4188 +.0006	5.5000 +.0011	.0004	5	.0156	
2	5220-751-4167	5.7500-8UN	5.6688	5.6688 +.0006	5.7500 +.0011	.0004	5	.0156	
2	5220-751-4170	6.0000-8UN	5.9188	5.9188 +.0006	6.0000 +.0011	.0004	5	.0156	

Note: The length of engagement for 8UN thread series is equal to the nominal diameter

Mil-Std-114C  
15 MARCH 1963

Table IV. Listing of Mil-Std Part Numbers in Numerical Sequence

MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*
A	B	A	B	A	B	A	B	A	B	A	B
5220-751-0098	27	5220-751-4003	6	5220-751-4027	7	5220-751-4051	11	5220-751-4075	14		
5220-751-0114	9	5220-751-4004	6	5220-751-4028	8	5220-751-4052	27	5220-751-4076	14		
5220-751-0120	9	5220-751-4005	6	5220-751-4029	8	5220-751-4053	11	5220-751-4077	14		
5220-751-0126	10	5220-751-4006	6	5220-751-4030	8	5220-751-4054	11	5220-751-4078	15		
5220-751-0132	10	5220-751-4007	6	5220-751-4031	8	5220-751-4055	12	5220-751-4079	15		
5220-751-0134	10	5220-751-4008	6	5220-751-4032	8	5220-751-4056	12	5220-751-4080	15		
5220-751-0140	10	5220-751-4009	6	5220-751-4033	8	5220-751-4057	12	5220-751-4081	15		
5220-751-0144	10	5220-751-4010	6	5220-751-4034	8	5220-751-4058	12	5220-751-4082	16		
5220-751-0148	11	5220-751-4011	6	5220-751-4035	8	5220-751-4059	12	5220-751-4083	16		
5220-751-0150	11	5220-751-4012	6	5220-751-4036	8	5220-751-4060	12	5220-751-4084	16		
5220-751-0160	11	5220-751-4013	6	5220-751-4037	8	5220-751-4061	12	5220-751-4085	16		
5220-751-0166	11	5220-751-4014	6	5220-751-4038	9	5220-751-4062	13	5220-751-4086	16		
5220-751-0176	12	5220-751-4015	6	5220-751-4039	9	5220-751-4063	13	5220-751-4087	16		
5220-751-0182	12	5220-751-4016	6	5220-751-4040	9	5220-751-4064	13	5220-751-4088	17		
5220-751-0192	13	5220-751-4017	7	5220-751-4041	9	5220-751-4065	13	5220-751-4089	17		
5220-751-0198	13	5220-751-4018	7	5220-751-4042	10	5220-751-4066	13	5220-751-4090	17		
5220-751-0208	14	5220-751-4019	7	5220-751-4043	10	5220-751-4067	13	5220-751-4091	17		
5220-751-0214	14	5220-751-4020	7	5220-751-4044	10	5220-751-4068	13	5220-751-4092	17		
5220-751-0224	14	5220-751-4021	7	5220-751-4045	10	5220-751-4069	13	5220-751-4093	17		
5220-751-0228	15	5220-751-4022	7	5220-751-4046	10	5220-751-4070	13	5220-751-4094	17		
5220-751-0236	15	5220-751-4023	7	5220-751-4047	10	5220-751-4071	14	5220-751-4095	17		
5220-751-0240	16	5220-751-4024	7	5220-751-4048	10	5220-751-4072	14	5220-751-4096	27		
5220-751-4001	6	5220-751-4025	7	5220-751-4049	11	5220-751-4073	14	5220-751-4097	18		
5220-751-4002	6	5220-751-4026	7	5220-751-4050	11	5220-751-4074	14	5220-751-4098	18		

\* Applicable page number in table I, II, or III for design and identification data



Mil-Std-114C  
15 MARCH 1963

**Table IV. Listing of Mil-Std Part Numbers in Numerical Sequence (Continued)**

MIL-STD. PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*	MIL-STD PART NUMBER	PAGE NO.*
A	B										
5220-751-4099	18	5220-751-4123	20	5220-751-4147	22	5220-751-4171	25	7517160	10		
5220-751-4100	27	5220-751-4124	20	5220-751-4148	22	5220-751-4172	25	7517161	10		
5220-751-4101	18	5220-751-4125	20	5220-751-4149	27	5220-751-7090	7	7517162	10		
5220-751-4102	18	5220-751-4126	20	5220-751-4150	23	7517139	7	7517163	11		
5220-751-4103	18	5220-751-4127	20	5220-751-4151	23	7517140	7	7517164	11		
5220-751-4104	18	5220-751-4128	21	5220-751-4152	27	7517141	7	7517165	11		
5220-751-4105	27	5220-751-4129	21	5220-751-4153	23	7517142	7	7517166	11		
5220-751-4106	18	5220-751-4130	21	5220-751-4154	23	7517143	8	7517167	11		
5220-751-4107	18	5220-751-4131	21	5220-751-4155	27	7517144	8	7517168	11		
5220-751-4108	27	5220-751-4132	21	5220-751-4156	24	7517145	8	7517169	11		
5220-751-4109	18	5220-751-4133	21	5220-751-4157	24	7517146	8	7517170	12		
5220-751-4110	19	5220-751-4134	21	5220-751-4158	27	7517147	8	7517171	12		
5220-751-4111	19	5220-751-4135	21	5220-751-4159	24	7517148	8	7517172	12		
5220-751-4112	19	5220-751-4136	21	5220-751-4160	24	7517149	9	7517173	12		
5220-751-4113	19	5220-751-4137	21	5220-751-4161	27	7517150	9	7517174	12		
5220-751-4114	19	5220-751-4138	22	5220-751-4162	24	7517151	9	7517175	12		
5220-751-4115	19	5220-751-4139	22	5220-751-4163	24	7517152	9	7517176	12		
5220-751-4116	19	5220-751-4140	22	5220-751-4164	27	7517153	9	7517177	13		
5220-751-4117	19	5220-751-4141	22	5220-751-4165	25	7517154	9	7517178	13		
5220-751-4118	19	5220-751-4142	22	5220-751-4166	25	7517155	9	7517179	13		
5220-751-4119	20	5220-751-4143	22	5220-751-4167	27	7517156	9	7517180	13		
5220-751-4120	20	5220-751-4144	22	5220-751-4168	25	7517157	9	7517181	13		
5220-751-4121	20	5220-751-4145	22	5220-751-4169	25	7517158	9	7517182	14		
5220-751-4122	20	5220-751-4146	22	5220-751-4170	27	7517159	10	7517183	14		

\* Applicable page number in table I, II, or III for design and identification data



Mil-Std-114C  
15 MARCH 1963

Table IV. Listing of Mil-Std Part Numbers in Numerical Sequence (Continued)

MIL-STD PART NUMBER	PAGE NO. *	MIL-STD PART NUMBER	PAGE NO. *	MIL-STD PART NUMBER	PAGE NO. *	MIL-STD PART NUMBER	PAGE NO. *	MIL-STD PART NUMBER	PAGE NO. *
A	B	A	B	A	B	A	B	A	B
7517184	14	7517208	17	7517232	20	7517256	23		
7517185	14	7517209	17	7517233	20	7517257	23		
7517186	14	7517210	17	7517234	20	7517258	24		
7517187	14	7517211	17	7517235	21	7517259	24		
7517188	15	7517212	17	7517236	21	7517260	24		
7517189	15	7517213	17	7517237	21	7517261	24		
7517190	15	7517214	17	7517238	21	7517262	24		
7517191	15	7517215	18	7517239	21	7517263	24		
7517192	15	7517216	18	7517240	21	7517264	24		
7517193	15	7517217	18	7517241	22	7517265	24		
7517194	15	7517218	18	7517242	22	7517266	24		
7517195	15	7517219	18	7517243	22	7517267	24		
7517196	15	7517220	18	7517244	22	7517268	25		
7517197	15	7517221	19	7517245	22	7517269	25		
7517198	16	7517222	19	7517246	23	7517270	25		
7517199	16	7517223	19	7517247	23	7517271	25		
7517200	16	7517224	19	7517248	23	7517272	25		
7517201	16	7517225	19	7517249	23	7517273	25		
7517202	16	7517226	19	7517250	23	7517274	25		
7517203	16	7517227	19	7517251	23	7517275	25		
7517204	16	7517228	20	7517252	23	7517276	25		
7517205	16	7517229	20	7517253	23				
7517206	16	7517230	20	7517254	23				
7517207	17	7517231	20	7517255	23				

\* Applicable page number in table I, II, or III for design and identification data

Mil-Std-114C  
15 March 1963

Notice: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data, is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

Copies of specifications, standards, drawings, and publications required by contractors in connection with specific procurement functions should be obtained from the procuring agency or as directed by the contracting officer.

Copies of this standard for military use may be obtained as indicated in the foreword to the DOD Index of Military Specifications and Standards.

Copies of this standard may be obtained for other than official use by individuals, firms, and contractors from the Superintendent of Documents, U. S. Government Printing Office, Washington 25, D. C.

Both the title and the identifying symbol number should be stipulated when requesting copies of military standards.

**Custodians:**

Army - MU  
Navy - WEPS  
Air Force - MAA

**Preparing Activity**

Army - MU

**STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL***(See Instructions – Reverse Side)***1. DOCUMENT NUMBER****2. DOCUMENT TITLE****3a. NAME OF SUBMITTING ORGANIZATION****4. TYPE OF ORGANIZATION (Mark one)**☐**VENDOR**☐**USER**☐**MANUFACTURER**☐**OTHER (Specify):** \_\_\_\_\_**b. ADDRESS (Street, City, State, ZIP Code)****5. PROBLEM AREAS****a. Paragraph Number and Wording:****b. Recommended Wording:****c. Reason/Rationale for Recommendation:****6. REMARKS****7a. NAME OF SUBMITTER (Last, First, MI) – Optional****b. WORK TELEPHONE NUMBER (Include Area Code) – Optional****c. MAILING ADDRESS (Street, City, State, ZIP Code) – Optional****8. DATE OF SUBMISSION (YYMMDD)**

(TO DETACH THIS FORM, CUT ALONG THIS LINE.)

**INSTRUCTIONS:** In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

**NOTE:** This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

---

(Fold along this line)

---

(Fold along this line)

DEPARTMENT OF THE ARMY



NO POSTAGE  
NECESSARY  
IF MAILED  
IN THE  
UNITED STATES

OFFICIAL BUSINESS  
PENALTY FOR PRIVATE USE \$300

**BUSINESS REPLY MAIL**

FIRST CLASS PERMIT NO. 12062 WASHINGTON D. C.

POSTAGE WILL BE PAID BY THE DEPARTMENT OF THE ARMY

Commander  
US Army Armement Research and Development Command  
ATTN: DRDAR-TST-S  
Dover, NJ 07801

