

MILITARY STANDARD

GAGES, SNAP, PLAIN ADJUSTABLE

TO ALL ACTIVITIES:

1. The following pages of Mil-Std-118 have been revised and supersede the pages listed.

<i>New page</i>	<i>Date</i>	<i>Superseded page</i>	<i>Date</i>
1	1 November 1962	1	6 February 1957
3	1 November 1962	3	6 February 1957
5	1 November 1962	5	6 February 1957
9	1 November 1962	9	6 February 1957
10	1 November 1962	10	6 February 1957
11	1 November 1962	11	6 February 1957
12	1 November 1962	12	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Superseded page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>
1	6 February 1957	1	14 January 1953
1A	6 February 1957	1	14 January 1953
3	6 February 1957	3	14 January 1953
3A	6 February 1957	3	14 January 1953
5	6 February 1957	5	14 January 1953
9	6 February 1957	9	14 January 1953
10	6 February 1957	10	14 January 1953
11	6 February 1957	11	14 January 1953
12	6 February 1957	12	14 January 1953

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

4. Holder of Mil-Std-118 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.

MIL-STD-118
1 NOVEMBER 1962

1. INTRODUCTION

1.1 This standard establishes technical and related data, including part numbers for American Gage Design Standard Plain Adjustable Snap Gages used for inspection of component dimensions from zero to 11.625 inches inclusive.

1.2 This standard establishes the method of specifying the required setting sizes and setting tolerances of the plain adjustable snap gages on the lists of inspection gages.

1.2.1 The method of specifying the required setting sizes applies only to plain adjustable snap gages that are used for the final acceptance inspection of component material.

2. APPLICATION

2.1 Table I lists the preferred part numbers to be used for design purposes. The table also provides in numerical sequence, the range of plain adjustable snap gages (part numbers) in ascending order and the gage setting tolerance as determined by the total component tolerance within each range.

2.2 Table II lists all the part numbers covering American gage design standard plain adjustable snap gages, and includes the preferred part numbers listed in table I. The table is arranged simultaneously in ascending sequence for part numbers and AGD standard frame designation.

3.1.8.2 Three thirty-seconds (.093) of an inch on gages with ranges between 2.750 and 5.6875 inches.

3.1.8.3 On eighth (.125) of an inch on gages with ranges between 5.6875 and 11.625 inches.

3.1.9 The method outlined above for specifying on the list of inspection gages the exact setting of the plain adjustable snap gages (part numbers) listed in table I can be ap-

plied to any plain adjustable snap gage (part number) shown in table II.

3.2 MARKING

3.2.1 Unless otherwise specified in the procurement document, all gages will require a marking disk marked as specified in figure 13. In addition all gages shall be marked with Mil-Std part number as specified in figures 15, 16, 17, and 18 whichever is applicable.

3.2.2 *Go marking.* Stamp or etch the numerator of the fraction shown on the list of inspection gages next to the prestamped word "Go" on the marking disk of the plain adjustable snap gage (part number) specified on the list of inspection gages. If the numerator is given as .000 on the list of inspection gages, leave the area adjacent to the prestamped word "Go" on the marking disk blank.

3.2.3 *Not go marking.* Stamp or etch the denominator of the fraction shown on the list of inspection gages next to the prestamped words "Not Go" on the marking disk of the plain adjustable snap gage (part number) specified on the list of inspection gages. If the denominator is given as .000 on the list of inspection gages, leave the area adjacent to the prestamped words "Not Go" on the marking disk blank.

3.2.4 *Gage setting tolerance marking.* Stamp the number shown in parenthesis on the list of inspection gages in the space provided between the words go and not go on the marking disk. That number is the gage setting tolerance in ten thousands (.0001) of an inch. (Note: see figure 14 for sample marking.)

3.2.5 The instructions provided in paragraphs 3.2.2 to 3.2.4 inclusive are not applicable unless specifically mentioned in the procurement document.

3.3 Setting and Surveillance.

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3.3.1 Note that the gage setting tolerance is given in ten thousandths (.0001) of an inch on the list of inspection gages and on the marking disk.

3.3.2 Plain adjustable snap gages must be lapped parallel and to size when the gage setting tolerance is .0001 inch.

3.3.3 For go and not go gages. Set inner button at Not Go stamping dimension and apply the gage getting tolerance plus (+). Set outer button at Go stamping dimension and apply the gage setting tolerance minus (—).

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ON REVERSE SIDE MARK 7479382

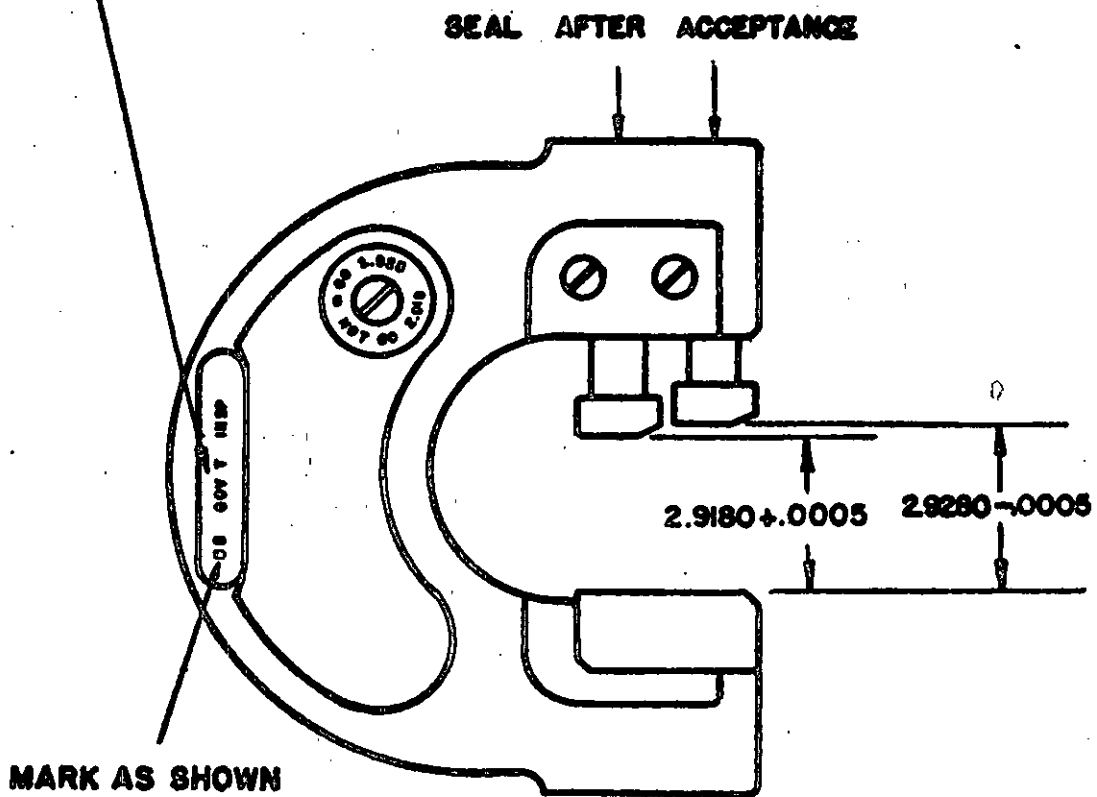
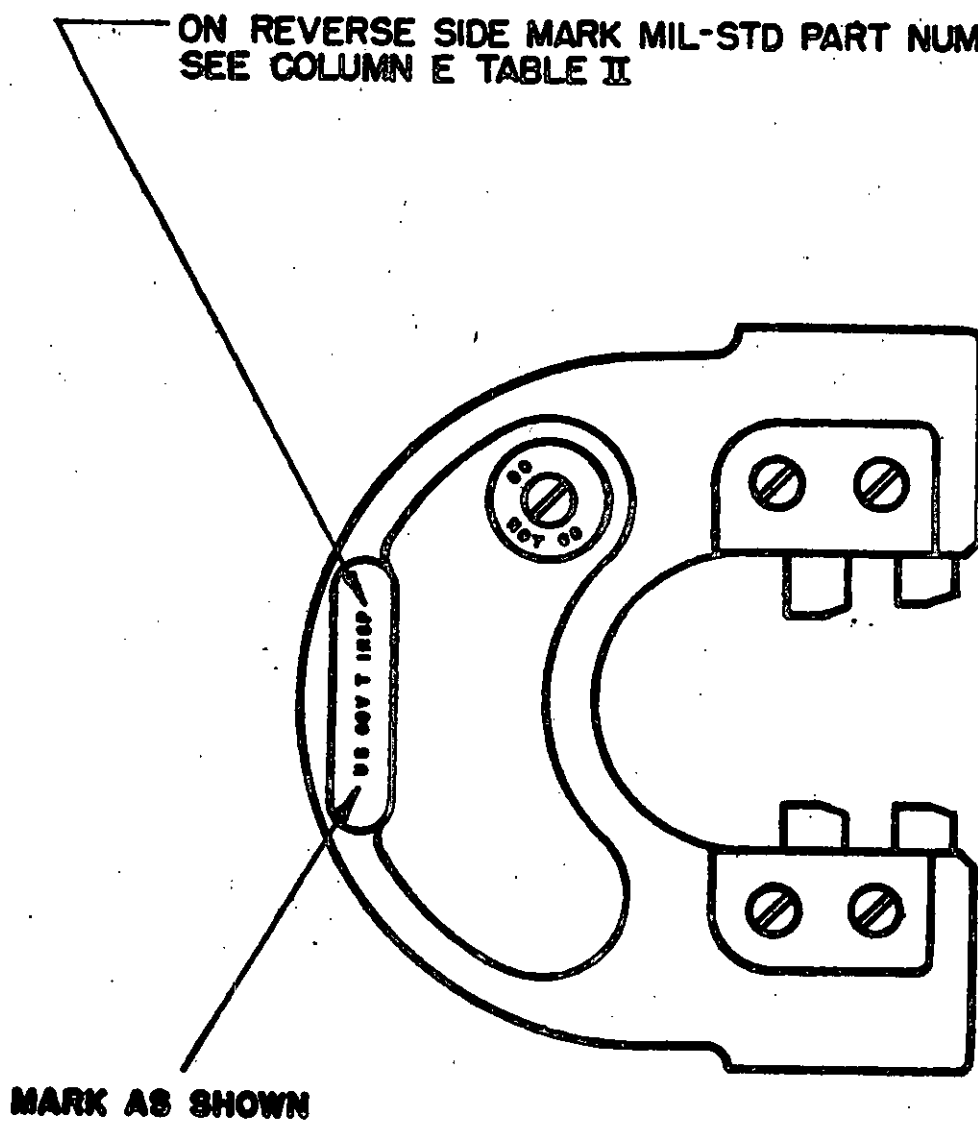


FIGURE 14.

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ON REVERSE SIDE MARK MIL-STD PART NUMBER
SEE COLUMN E TABLE II



MARK AS SHOWN

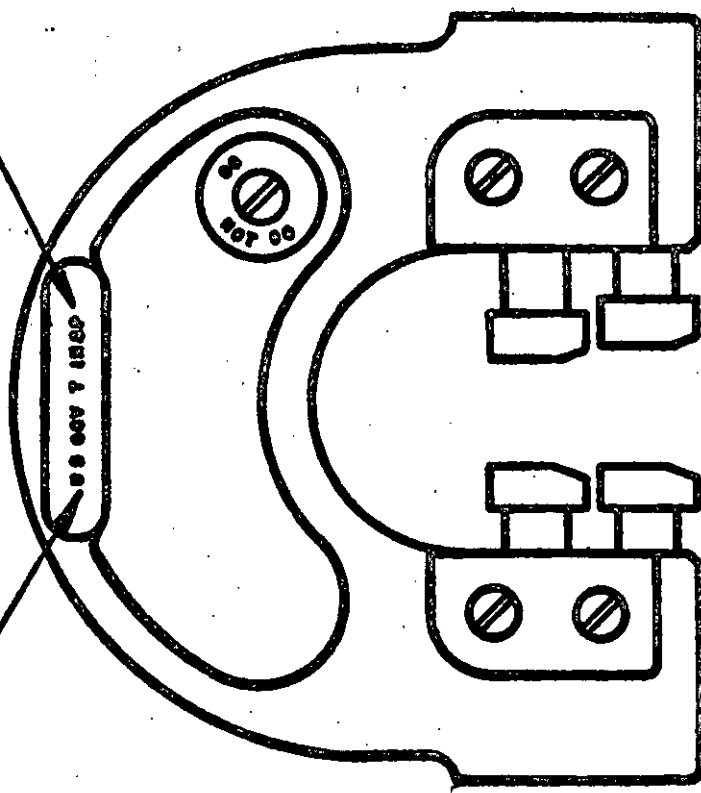
AGD MODEL A
PART NUMBERS (7479300-7479330)

FIGURE 15.

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ON REVERSE SIDE MARK MIL-STD PART NUMBER
SEE TABLE II



MARK AS SHOWN

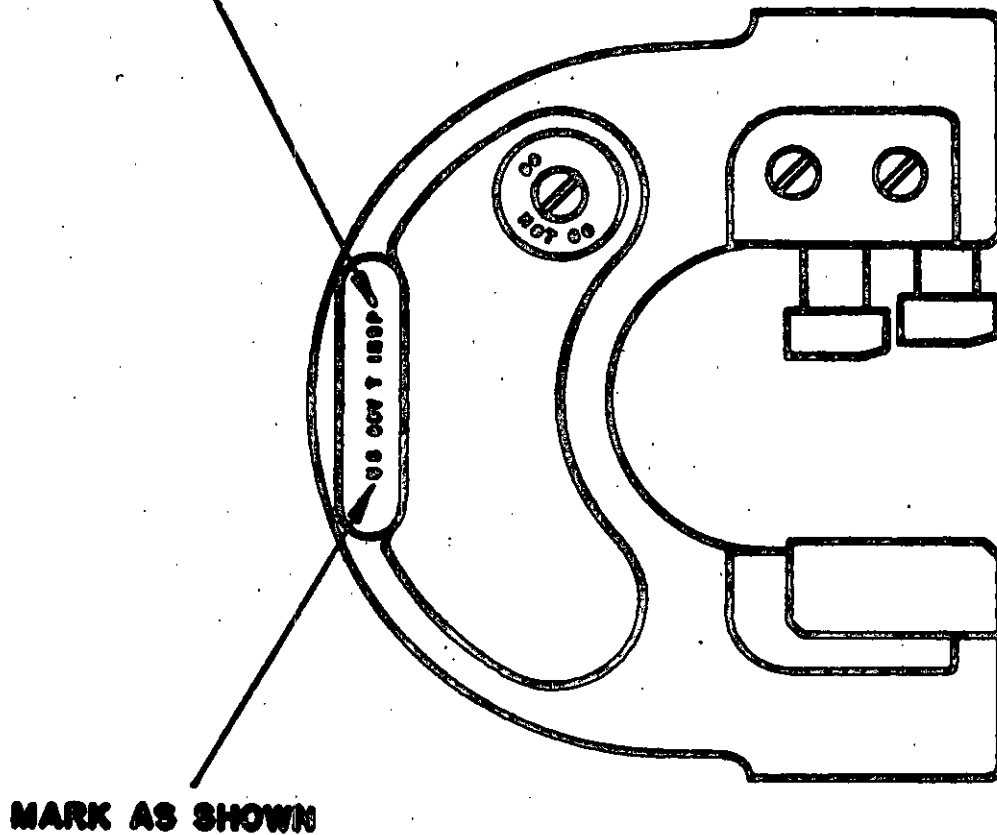
AGD MODEL B
PART NUMBERS (7479332 - 7479359)

FIGURE 16.

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ON REVERSE SIDE MARK MIL-STD PART NUMBER
SEE TABLE II



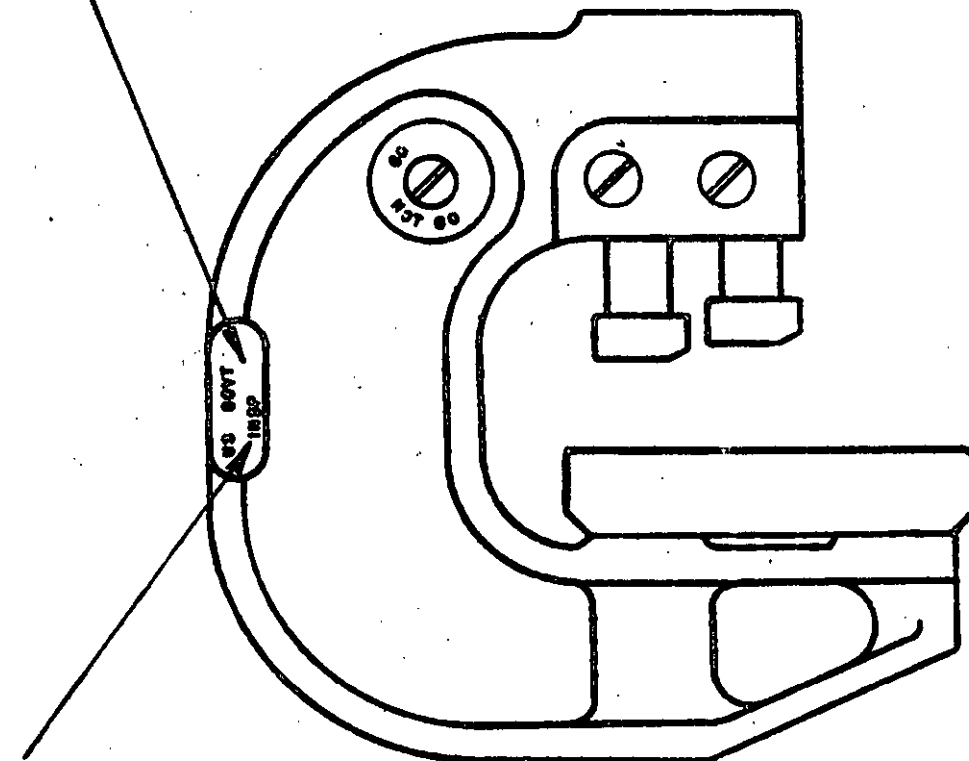
**AGD MODELS C & MC
PART NUMBERS (7479360 - 7479421)
AND (7479460 - 7479467)**

FIGURE 17.

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ON REVERSE SIDE MARK MIL-STD PART NUMBER
SEE TABLE J



MARK AS SHOWN

AGD MODEL E
PART NUMBERS (7479422-7479459)

FIGURE 18.

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