

MIL-STD-133B
15 MARCH 1963

SUPERSEDING
MIL-STD-133A
27 MARCH 1959

MILITARY STANDARD

GAGES, PLUG, PLAIN CYLINDRICAL,
GO
FOR
MINOR DIAMETERS OF STANDARD
CLASSES OF INTERNAL THREADS



FED SUP CLASS
5220

Mil-Std-133B
15 March 1963

DEPARTMENT OF DEFENSE
WASHINGTON 25, D.C.

**Gages, Plug, Plain Cylindrical, Go for Minor Diameters of Standard
Classes of Internal Threads**

Mil-Std-133B

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.

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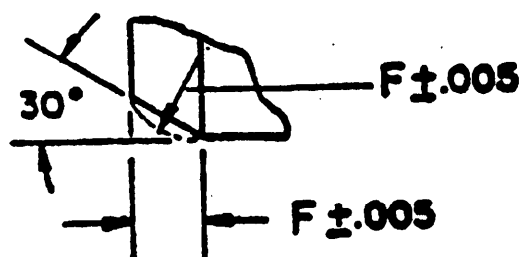
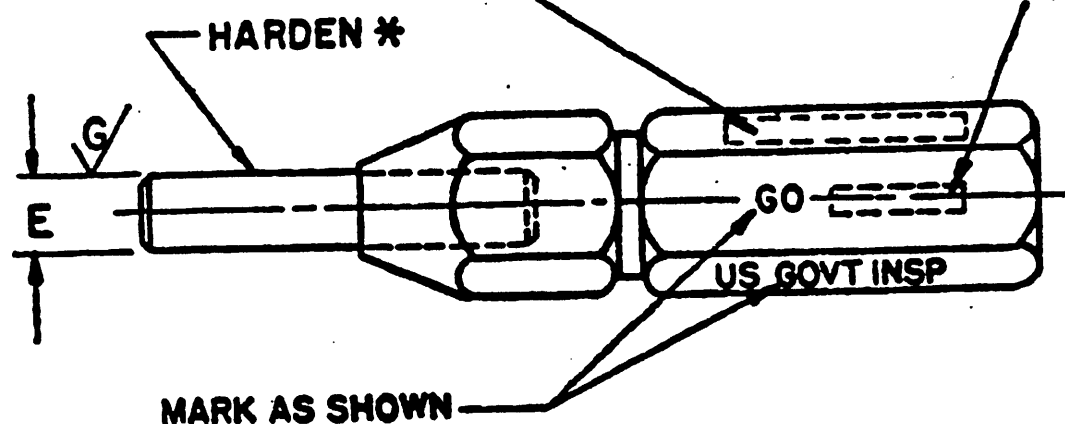
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MARK MIL-STD PART NUMBER
SHOWN IN COLUMN B TABLE I, II, OR III

MARK DATA SHOWN IN
COLUMN C TABLE I, II, OR III



ENLARGED VIEW
CHAMFER OR RADIUS ON
BOTH ENDS OF WIRE

* HARDEN: ROCKWELL OR EQUIVALENT

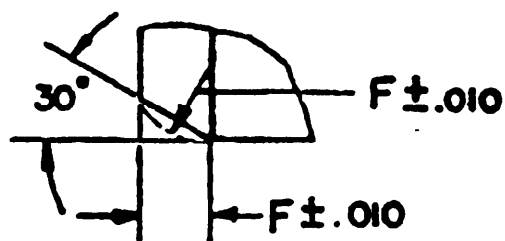
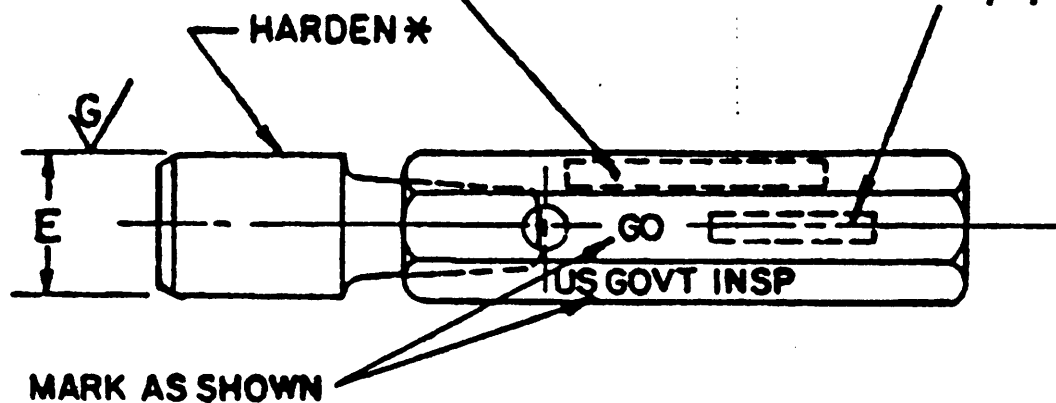
C55 TO C60 FOR DIA UP TO AND INCL .10
C60 TO C63 FOR DIA ABOVE .10 TO AND INCL .20
C63 TO C66 FOR DIA ABOVE .20

FIGURE 1. Go plain plug gage (wire type).

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

MARK DATA SHOWN IN
COLUMN C TABLE I, II, OR III



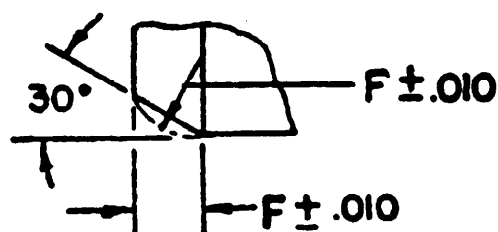
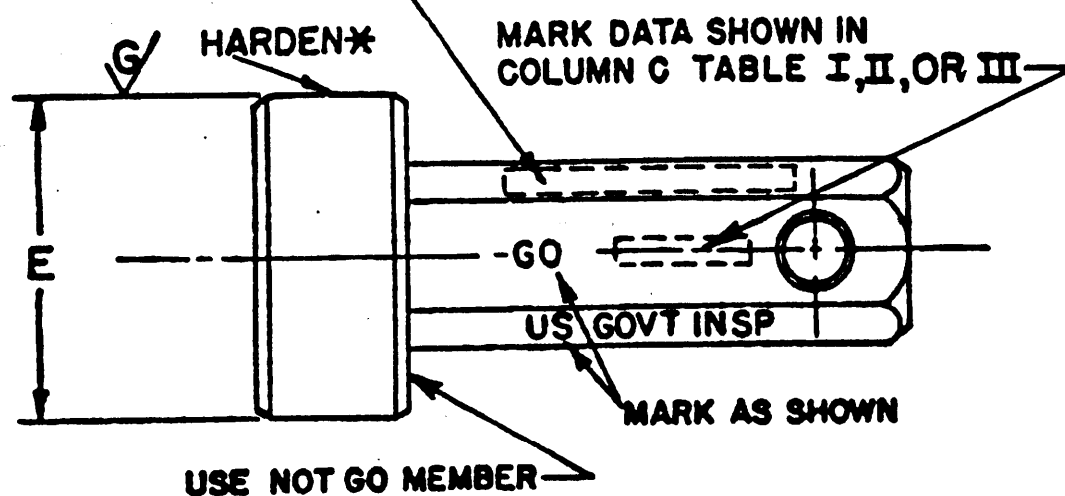
ENLARGED VIEW
CHAMFER OR RADIUS

*HARDEN ROCKWELL OR EQUIVALENT
C63 TO C66

FIGURE 2. Go Plain Plug Gage (Taperlock Type)

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



ENLARGED VIEW
CHAMFER OR RADIUS
ON BOTH ENDS

* HARDEN: ROCKWELL OR EQUIVALENT
C63 TO C66

FIGURE 2. Go plain plug gage (tri-lock type)

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

FIGURE NO.	MARKING ON GAGE HANDLE		COMPONENT THREAD DESIGNATION	GAGE DIMENSIONS		FINISH
	MIL-STD PART NUMBER	GO DIA		DIAMETER	CHAM- FER	
A	B	C	D	E	F	G
1	5220-742-2764	.216	.2500-32UNEF-2B, 3B	.2162 + .0001	.015	8
1	5220-742-3346	.252	.3125-18UNC-1B, 2B, 3B	.2524 + .0003	.015	8
1	5220-742-3442	.258	.3125-20UN-2B, 3B	.2584 + .0003	.015	8
1	5220-742-3586	.267	.3125-24UNF-1B, 2B, 3B	.2674 + .0003	.015	8
1	5220-742-3694	.274	.3125-28UN-2B, 3B	.2742 + .0001	.015	8
1	5220-742-3774	.279	.3125-32UNEF-2B, 3B	.2792 + .0001	.015	8
1	5220-742-4228	.307	.3750-16UNC-1B, 2B, 3B	.3074 + .0003	.030	8
1	5220-742-4450	.321	.3750-20UN-2B, 3B	.3212 + .0001	.030	8
1	5220-742-4594	.330	.3750-24UNF-1B, 2B, 3B	.3302 + .0001	.030	8
1	5220-742-4690	.336	.3750-28UN-2B, 3B	.3362 + .0001	.030	8
1	5220-742-4770	.341	.3750-32UNEF-2B, 3B	.3412 + .0001	.030	8
1	5220-742-5080	.360	.4375-14UNC-1B, 2B, 3B	.3604 + .0003	.030	8
1	5220-742-5240	.370	.4375-16UN-2B, 3B	.3704 + .0003	.030	8
1	5220-742-5448	.383	.4375-20UNF-1B, 2B, 3B	.3834 + .0003	.030	8
1	5220-742-5700	.399	.4375-28UNEF-2B, 3B	.3992 + .0001	.030	8
1	5220-742-5780	.404	.4375-32UN-2B, 3B	.4042 + .0001	.030	8
1	5220-742-5994	.417	.5000-13UNC-1B, 2B, 3B	.4174 + .0003	.030	8
1	5220-742-6234	.432	.5000-16UN-2B, 3B	.4324 + .0003	.030	8
1	5220-742-6456	.446	.5000-20UNF-1B, 2B, 3B	.4462 + .0001	.030	8
1	5220-742-6696	.461	.5000-28UNEF-2B, 3B	.4612 + .0001	.030	8
1	5220-742-6776	.466	.5000-32UN-2B, 3B	.4662 + .0001	.030	8
1	5220-742-6878	.472	.5625-12UNC-1B, 2B, 3B	.4724 + .0003	.030	8

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