

MIL-STD-273B**Notice 1****28 August 1964****MILITARY STANDARD****GAGES, PLUG, THREAD, SETTING, CLASS W, FOR THE GO GAGES UNIFIED
STANDARD CLASSES 2A AND 3A AND AMERICAN NATIONAL STANDARD
CLASS 3 EXTERNAL THREADS.****TO ALL HOLDERS OF Mil-Std-273B:**

1. The following pages of Mil-Std-273B have been revised and supersede the pages listed:

| <i>New page</i> | <i>Date</i> | <i>Superseded page</i> | <i>Date</i> |
|-----------------|----------------|------------------------|---------------|
| ii | 28 August 1964 | ii | 15 March 1963 |
| iii | 28 August 1964 | iii | 15 March 1963 |
| 1 | 28 August 1964 | 1 | 15 March 1963 |
| 3 | 28 August 1964 | 3 | 15 March 1963 |
| 72 | 28 August 1964 | 72 | 15 March 1963 |

2. Retain this notice and insert before the table of contents.
3. Holders of Mil-Std-273B will verify that page changes and additions indicated above have been entered and will destroy the previous notice (notice page only). The latest notice (notice page) will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the Military Standard is completely revised or cancelled.

MIL-STD-273B
28 August 1964

DEPARTMENT OF DEFENSE
WASHINGTON, D.C.

Gages, Plug, Thread, Setting, Class W, for the Go Gages Unified Standard Classes 2A and 3A and American National Standard Class 3 External Threads.

Mil-Std-273B

1. This Military Standard has been approved by the Department of Defense and is mandatory for use by all Departments and Agencies of the Department of Defense.
2. Recommended corrections, additions, or deletions should be addressed to Commanding Officer, U.S. Army, Frankford Arsenal, ATTN: SMUFA-5500, Philadelphia, Pa. 19137.

Supersedes page ii of 15 March 1963.

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1. SCOPE

1.1 This standard covers pertinent design data and Mil-Std Part Numbers for American Gage Design Standard truncated thread setting plug gages for go gages for Unified Standard classes 2A and 3A and American National Standard class 3 external threads.

1.2 The same truncated thread setting plug gage is applied to classes 3 and 3A threads having the same nominal size and threads per inch.

1.3 The design data for truncated thread setting plug gages employs class W 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, D.C.)

SPECIFICATIONS

Mil-S-7742—Screw Threads, Standard, Optimum Selected Series, General Specification for.

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 Service."

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, D.C.)

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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 provides tabulated design data required for manufacture and inspection and is also arranged in ascending size sequence according to thread designation for American National Standard gages. Table III contains thread designations previously listed in the Standard series of Unified Standard thread (with the exception of 1.0000-14UNS-3A, NS-3 W (see 1.2) which was listed also in the American National Thread 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 designation for each trun-

cated thread setting 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 5220-749-8000 may be marked 7498000 on the gage.

4.1.1.4 Columns E to K 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, H, and K is inches; column J 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.

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

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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 Number 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 document 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.

6. SPECIAL REQUIREMENTS (U.S. Air Force)

6.1 U.S. Air Force procurement and supply will normally be limited to the aeronautical screw thread selections contained in Mil-S-7742, and within the following series and sizes.

Coarse Thread Series—UNC. No. 1
 (.073)—64 through 1-8.

Fine Thread Series—UNF. No. 0
 (.060)—80 through 1½-12.

Extra Fine Thread Series—UNEF. ¼-
 32 through 1½-18.

6.2 Procurement and supply of gages in the series listed below shall be permitted only when justifiable requirements exist:

Threads in the American National Series

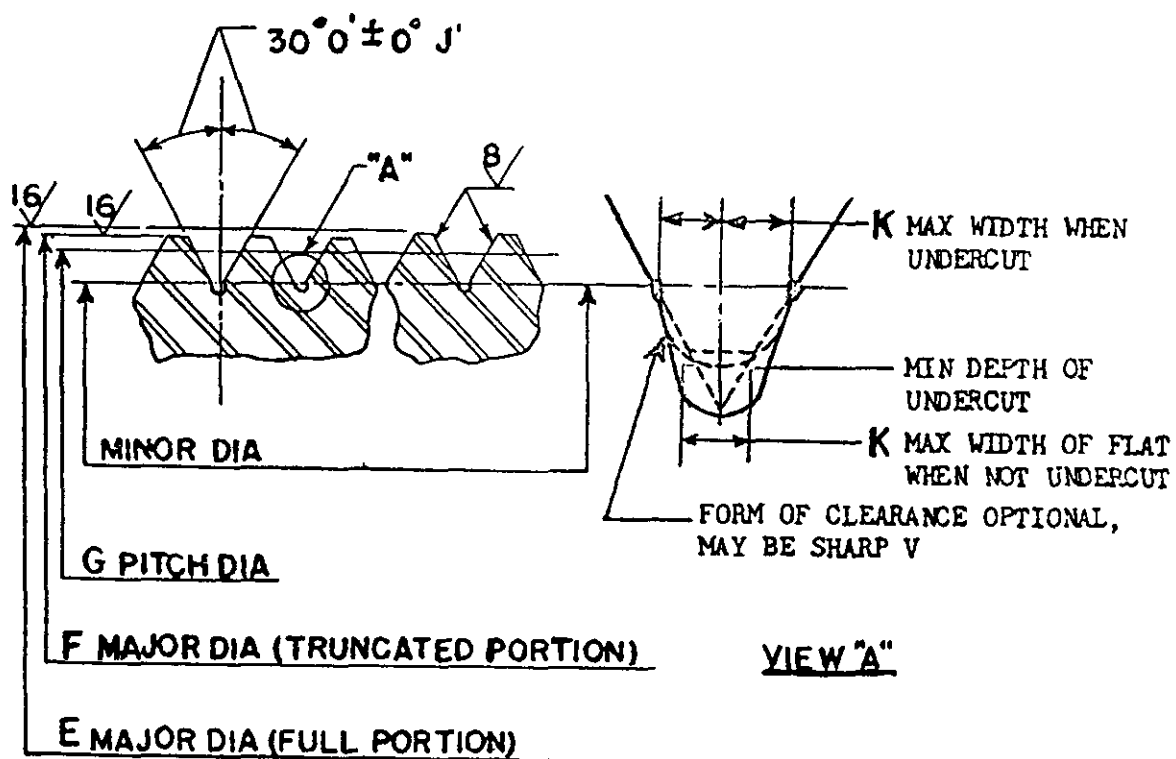
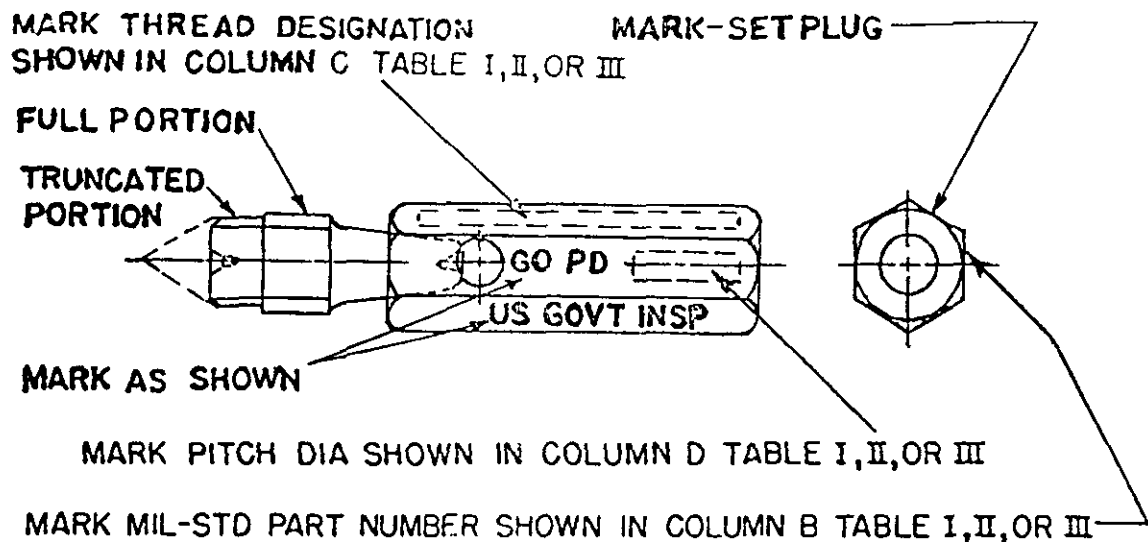
8 Thread Series—8 UN.

12 Thread Series—12 UN.

16 Thread Series—16 UN.

Special Threads—UNS AND NS.

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TOLERANCE ON LEAD H

FIGURE 1. Truncated thread setting plug gage (taperlock type).

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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 |
| 7519101 | 35 | 7519130 | 40 | 7519158 | 44 | 7519186 | 47 | | |
| 7519102 | 35 | 7519131 | 40 | 7519159 | 44 | 7519187 | 47 | | |
| 7519103 | 35 | 7519132 | 40 | 7519160 | 44 | 7519188 | 47 | | |
| 7519104 | 36 | 7519133 | 40 | 7519161 | 44 | 7519189 | 47 | | |
| 7519105 | 36 | 7519134 | 40 | 7519162 | 44 | 7519190 | 47 | | |
| 7519106 | 36 | 7519135 | 41 | 7519163 | 45 | 7519191 | 47 | | |
| 7519107 | 36 | 7519136 | 41 | 7519164 | 45 | 7519192 | 47 | | |
| 7519108 | 36 | 7519137 | 41 | 7519165 | 45 | 7519193 | 47 | | |
| 7519109 | 36 | 7519138 | 42 | 7519166 | 45 | 7519194 | 47 | | |
| 7519110 | 36 | 7519139 | 42 | 7519167 | 45 | 7519195 | 48 | | |
| 7519111 | 37 | 7519140 | 42 | 7519168 | 45 | 7519196 | 48 | | |
| 7519112 | 37 | 7519141 | 42 | 7519169 | 45 | 7519197 | 48 | | |
| 7519113 | 37 | 7519142 | 42 | 7519170 | 45 | 7519198 | 48 | | |
| 7519114 | 37 | 7519143 | 43 | 7519171 | 45 | 7519199 | 48 | | |
| 7519115 | 37 | 7519144 | 43 | 7519172 | 45 | 7519200 | 48 | | |
| 7519116 | 37 | 7519145 | 43 | 7519173 | 45 | 7519201 | 48 | | |
| 7519117 | 38 | 7519146 | 43 | 7519174 | 46 | 7519202 | 48 | | |
| 7519118 | 38 | 7519147 | 43 | 7519175 | 46 | 7519203 | 49 | | |
| 7519120 | 38 | 7519148 | 43 | 7519176 | 46 | 7519204 | 49 | | |
| 7519121 | 38 | 7519149 | 43 | 7519177 | 46 | 7519205 | 49 | | |
| 7519122 | 38 | 7519150 | 43 | 7519178 | 46 | 7519206 | 49 | | |
| 7519123 | 39 | 7519151 | 43 | 7519179 | 46 | | | | |
| 7519124 | 39 | 7519152 | 43 | 7519180 | 46 | | | | |
| 7519125 | 39 | 7519153 | 44 | 7519181 | 46 | | | | |
| 7519126 | 39 | 7519154 | 44 | 7519182 | 46 | | | | |
| 7519127 | 39 | 7519155 | 44 | 7519183 | 46 | | | | |
| 7519128 | 39 | 7519156 | 44 | 7519184 | 46 | | | | |
| 7519129 | 40 | 7519157 | 44 | 7519185 | 47 | | | | |

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

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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.

Custodians:

Army—MU
Navy—WP
Air Force—11

Review activities:

Army—GL
Navy—SH
Air Force—67, 11

User activities:

Army—MI
Navy—YD
Air Force—85

Preparing activity:

Army—MU
Project No. 52220-0090

Supersedes page 72 of 15 March 1963.