

**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Superseded page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

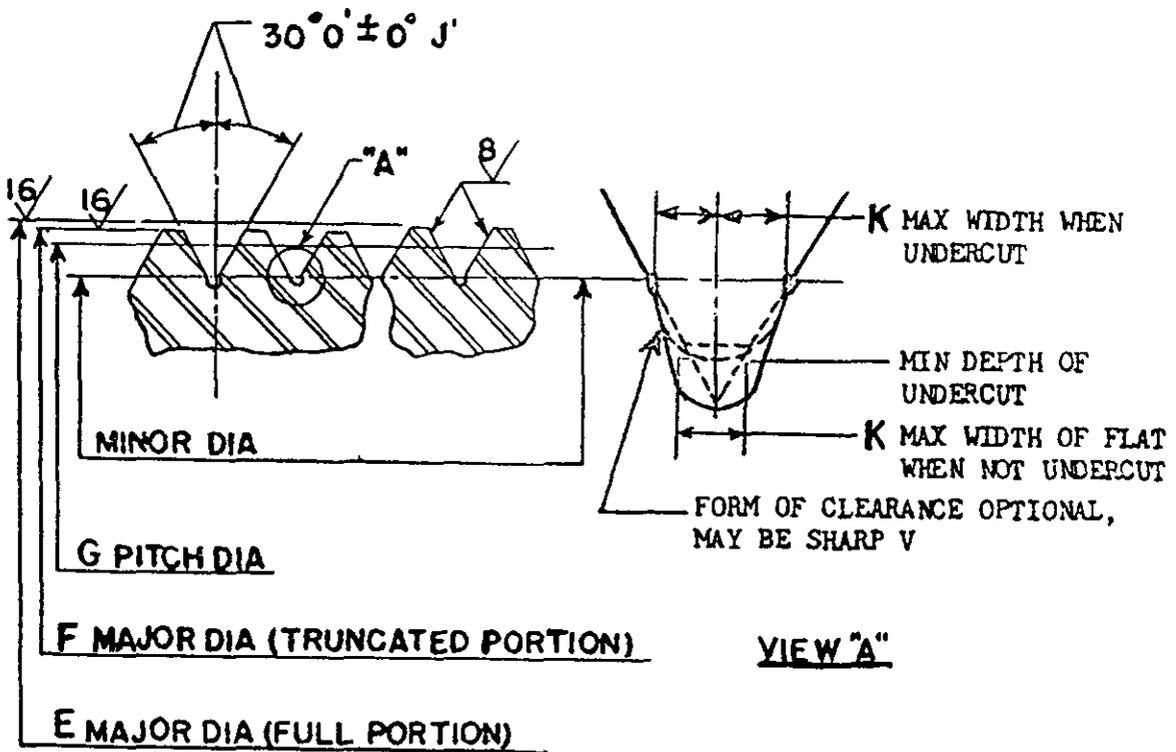
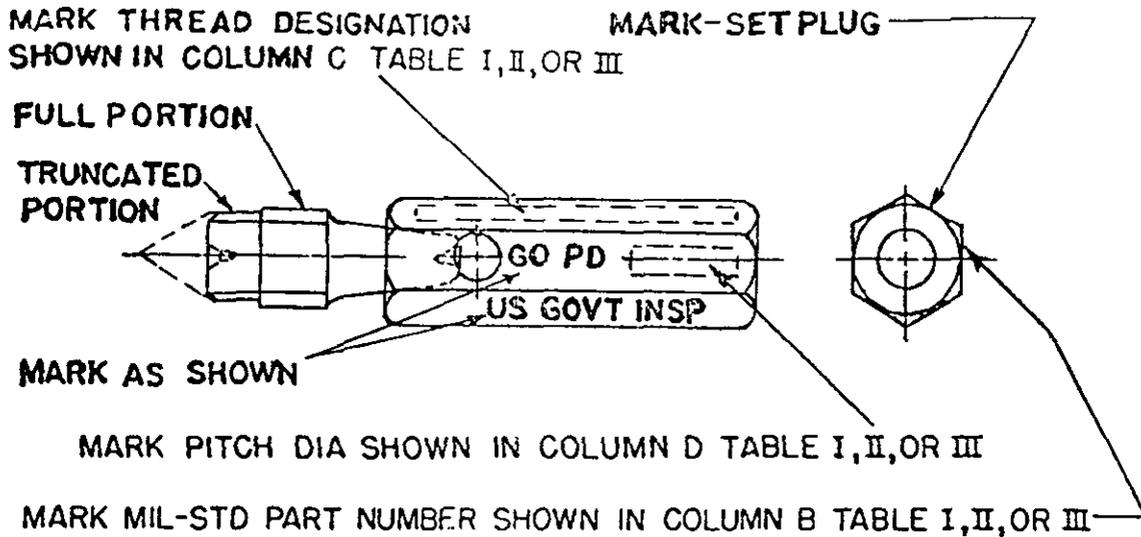
8 Thread Series—8 UN.

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.*								
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.**