

## BSPT PLUG & RING THREAD GAGES # 71007 and # 71005

BSPT - British Standard Pipe Tapered - Standard Tolerance = System B

NOM. THREAD DIA. Inch	THREAD Per Inch	MAJOR DIA. Inch	PITCH DIA. Inch	# 71007 BSPT Plug	# 71005 BSPT Ring
1/8 BSPT	28	.3830	.3601	x	x
1/4 BSPT	19	.5180	.4843	x	x
3/8 BSPT	19	.6560	.6223	x	x
1/2 BSPT	14	.8250	.7793	x	x
3/4 BSPT	14	1.0410	.9953	x	x
1 BSPT	11	1.3090	1.2508	x	x
1 1/4 BSPT	11	1.6500	1.5918	x	x
1 1/2 BSPT	11	1.8820	1.8238	x	x
2 BSPT	11	2.3470	2.8888	x	x

"x" denotes stock availability



# 71007 - BSPT PLUG



# 71005 - BSPT RING

## REFERENCE GUIDE FOR BRITISH STANDARD PIPE THREADS (BSP & BSPT PLUG AND RING GAGES)

The abbreviations "G" and "R" originated in France and Germany respectively. The French "G" stood for "Gas" and was used to denote parallel thread (BSP) only. The German "R" stood for "Rohr" ("Pipe") and was originally used to denote tapered pipe thread (BSPT). Although the Germans did, at one time, use the designation "Rz" [z for "zylindrisch" (cylindrical)] to denote parallel thread (BSP), this is not acceptable today.

### BSP - Parallel Thread (Ref: ISO 228, BS 21, DIN 259, DIN 5157)

Acceptable Designations: G 1/4, G 1/4 A (standard tolerance, G 1/4B (rough tolerance supplied on special request only)

### BSPT - Tapered Thread (Ref: ISO 7/1, ISO 7/2, BS 2779, DIN 2999, DIN 259 & DIN 353) System B Standard Tolerance

Acceptable Designations: R 1/4, Rp 1/4 (Internal Thread), Rc 1/4 (External Thread)

Note: Ring gage preceded by "GLR" (Grenzgewindelehrring) Example: GLR - R 1/4  
Plug gage preceded by "GLD" (Grenzgewindelehrdorne) Example: GLD - Rp 1/4

Metric & Multistandard's British gages are full-form Whitworth (55° radiused roots & crests). Our ring gages are solid, non-adjusting gages as is most common in Europe. Calibration certification is available, if requested at time of order. A nominal charge may apply.

### Description of "System B" BSPT Gages (BS 21:1973):

System B comprises the following types of gages:

1. A taper full-form screw plug gage. This gage has a total length of thread equal to the length of useful thread for maximum gage length and incorporates a step equal to the total tolerance on the position of the gage plane. The upper face of the step is marked positive (+) and the lower face is marked (-).
2. A taper full-form screw ring gage. This gage has a total length of thread equal to the length of useful thread for maximum gage length minus half the wrenching allowance and incorporates a step equal to the total tolerance on the gage length. The upper face of the step is marked positive (+) and the lower face is marked negative (-).
3. A taper plain plug gage. This gage has a overall length equal to the fitting allowance plus 3/4 of the total tolerance on the position of the gage plane and incorporates a step equal to 1 1/4 times the total tolerance on the position of the gage plane. The distance from the gage plane to the upper face of the step is marked positive (+) and the lower face is marked negative (-), but this marking may be omitted where space does not allow for it. The gage will accept internal threads having small errors of taper and thread depth.
4. A taper plain ring gage. This gage has an overall length equal to the length of useful thread for maximum gage length minus half the wrenching allowance. It incorporates a step at the small end of the taper equal to 1 1/4 times the total tolerance on the gage length and having the upper face marked positive (+) and the lower face marked negative (-). The distance from the gage plane to the upper face of the step is equal to the minimum gage length plus the height of the step. The gage is recessed at the small end to a distance representing the negative (-) tolerance for and internal thread measured from the gage plane. This gage will accept external threads having small errors of taper and thread depth.

#### How to Order

Item #: 71007  
Size: 1/2 BSPT  
Quantity: 5  
Tel: 1-888-966-MMCC