

# Standard Thread Measuring Wires

## CHECK YOUR PITCH DIAMETERS

Vermont Gage Thread Measuring Wires, used together with a micrometer, are used to quickly and accurately measure pitch diameters of external threads. They are perfect for calibrating or checking wear on thread plug gages, and can be used to monitor and control pitch diameters of manufactured threads.

- **Tolerance (+/- .000010") of calibrated nominal diameter (+/- .000020") of nominal best wire diameter**
- **Tool Steel; 59/64 Rc**
- **2" long**
- **2 microinch finish**
- **Within .00001" round**
- **100% inspected**
- **ASME B89.1.17**
- **Certificate of Accuracy included**
- **See page 113 for Calibration Services**



## INCH WIRES

[n] Threads per Inch	[G] Nominal Best Wire Diameter (Decimal)	[C] Nominal Constant (Decimal)	Order No. 3-Wire Set
120	.00481	.00722	351100510
100	.00577	.00866	351101010
96	.00601	.00902	351101510
90	.00642	.00962	351102010
80	.00722	.01083	351102510
72	.00802	.01203	351103010
64	.00902	.01353	351103510
56	.01031	.01546	351104010
50	.01155	.01732	351104510
48	.01203	.01804	351105010
44	.01312	.01968	351105510
40	.01443	.02165	351106010
36	.01604	.02406	351106510
32	.01804	.02706	351107010
30	.01925	.02887	351107510
28	.02062	.03093	351108010
27	.02138	.03208	351108510
26	.02221	.03331	351109010
24	.02406	.03608	351109510
22	.02624	.03936	351110010
20	.02887	.04330	351110510
18	.03208	.04811	351111010
16	.03608	.05413	351111510
14	.04124	.06186	351112010
13	.04441	.06662	351112510
12	.04811	.07217	351113010
11 1/2	.05020	.07531	351113510
11	.05249	.07873	351114010
10	.05774	.08660	351114510
9	.06415	.09623	351115010
8	.07217	.10825	351115510
7 1/2	.07698	.11547	351116010
7	.08248	.12372	351116510
6	.09623	.14434	351117010
5 1/2	.10497	.15746	351117510
5	.11547	.17321	351118010
4 1/2	.12830	.19245	351118510
4	.14434	.21651	351119010
3 1/2	.16496	.24744	351119510
3 1/4	.17765	.26647	351120010
3	.19245	.28868	351120510
2 3/4	.20995	.31492	351121010
2 1/2	.23094	.34641	351121510
2	.28868	.43301	351122010

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## METRIC WIRES

Pitch	Nominal Best Wire Diameter (mm)	[C] Nominal Constant (mm)	Order No. 3-Wire Set
.2	.1155	.1732	352100510
.25	.1299	.1949	352101010
.25	.1443	.2165	352101510
.3	.1732	.2598	352102010
.35	.2021	.3031	352102510
.4	.2309	.3464	352103010
.45	.2598	.3897	352103510
.5	.2887	.4330	352104010
.6	.3464	.5196	352104510
.7	.4041	.6062	352105010
.75	.4330	.6495	352105510
.8	.4619	.6928	352106010
.9	.5196	.7794	352106510
1.0	.5774	.8660	352107010
1.25	.7217	1.0825	352107510
1.5	.8660	1.2990	352108010
1.75	1.0104	1.5155	352108510
2.0	1.1547	1.7321	352109010
2.5	1.4434	2.1651	352109510
3.0	1.7321	2.5981	352110010
3.5	2.0207	3.0311	352110510
4.0	2.3094	3.4641	352111010
4.5	2.5981	3.8971	352111510
5.0	2.8868	4.3301	352112010
5.5	3.1754	4.7631	352112510
6.0	3.4641	5.1962	352113010
7.0	4.0415	6.0622	352113510
8.0	4.6188	6.9282	352114010
9.0	5.1962	7.7942	352114510
10	5.7735	8.6603	352115010

## 29° ACME WIRES

[n] Threads per Inch	[G] Nominal Best Wire Diameter (Decimal)	Order No. 3-Wire Set
1	.51645	353100510
1 1/3	.38734	353101010
1 1/2	.34430	353101510
1 3/4	.29511	353102010
2	.25823	353102510
2 1/2	.20658	353103010
3	.17215	353103510
3 1/2	.14756	353104010
4	.12911	353104510
4 1/2	.11477	353105010
5	.10329	353105510
5 1/2	.09390	353106010
6	.08608	353106510
7	.07378	353107010
8	.06456	353107510
9	.05738	353108010
10	.05164	353108510
12	.04304	353109010
14	.03689	353109510
16	.03228	353110010
18	.02869	353110510
20	.02582	353111010

No constant is included with Acme Wires because the constant must be calculated for each thread size.

THREADS

## THREAD MEASURING WIRE SETS

Description	Order No.
4 to 80 TPI (34 sizes in set)	359100530
5 to 80 TPI (30 sizes in set)*	359101030
6 to 36 TPI (20 sizes in set)*	359101530
.2 to 10mm Pitch (30 sizes in set)	359102030
.3 to 6mm Pitch (23 sizes in set)	359102530

\*7-1/2 and 22 threads per inch wires not included