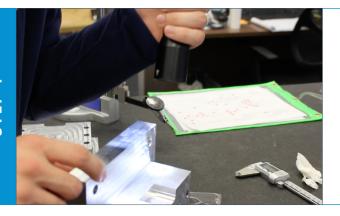


Pro Tips: Checking Thread Depths

STEP 1



Check the part immediately for burrs and chips at the bottom of the hole. Holes should be clear and free of oil and threads should look sharp.

STEP 2



Check threads with a calibrated thread gauge.

- The Go side should easily go all the way in and should not bind.
- The No-Go side should not turn more than 2 revolutions.

STEP 3



Check thread depth with calipers & a mating piece, a go/no-go gauge, or, if the hole is deeper than the gauge allows, an off-the-shelf screw.

- Insert the mating piece, go/no-go gauge, or screw into the threaded hole.
- Use calipers to measure the depth the above item engaged in the hole to determine depth of the hole.

NOTE: Tapping deeper than required is better than being too shallow.

If you find any defects in this process, check your tools. Plug taps should be clean and sharp. Single point tools should be the same.