

MIL-STD-133B
15 MARCH 1963

SUPERSEDING
MIL-STD-133A
27 MARCH 1959

MILITARY STANDARD

GAGES, PLUG, PLAIN CYLINDRICAL,
GO
FOR
MINOR DIAMETERS OF STANDARD
CLASSES OF INTERNAL THREADS



FED SUP CLASS
5220

Mil-Std-133B
15 March 1963

DEPARTMENT OF DEFENSE
WASHINGTON 25, D.C.

**Gages, Plug, Plain Cylindrical, Go for Minor Diameters of Standard
Classes of Internal Threads**

Mil-Std-133B

1. This standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, and the Air Force, effective 15 March 1963.

2. Recommended corrections, additions, or deletions should be addressed to Headquarters, DSA, Standardization Division, Washington 25, D. C.

CONTENTS

Paragraph	Page
1. Scope	1
2. Referenced Documents	2
3. Definitions	2
4. General Requirements	3
4.1.1 Tables I, II, and III - Tabulation of Design and Identification Data	3
4.1.2 Table IV - Listing of Mil-Std Part Numbers in Numerical Sequence	3
5. Procurement	4

FIGURES

Figure	
1. Go Plain Plug Gage (Wire Type)	5
2. Go Plain Plug Gage (Taperlock Type)	6
3. Go plain Plug Gage (Trilock Type)	7

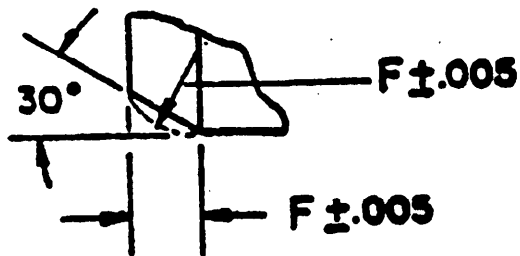
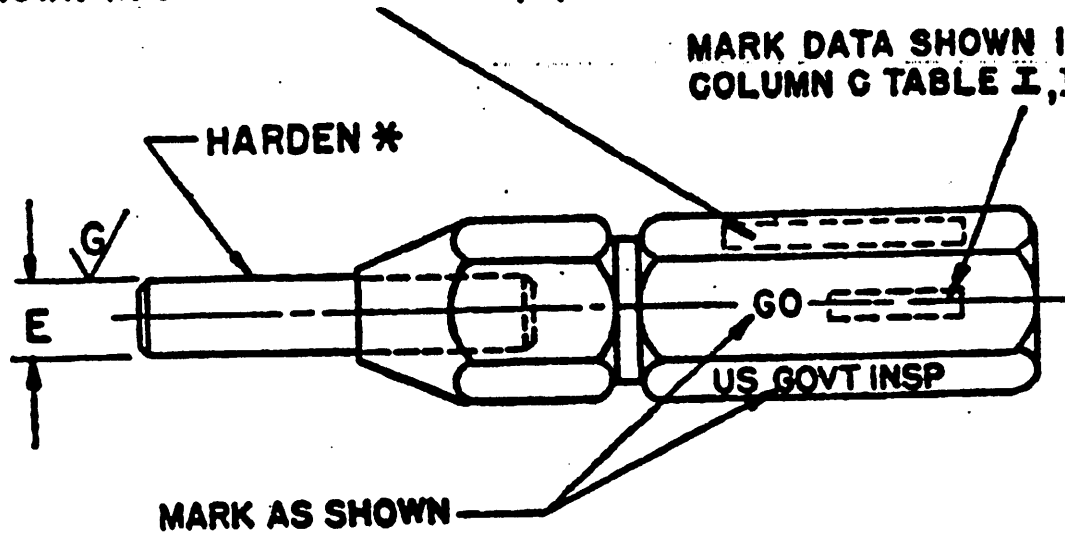
TABLES

Table	
I. Tabulation of Design and Identification Data - Unified Standard Thread	9
II. Tabulation of Design and Identification Data - American National Standard Thread	25
III. Tabulation of Design and Identification Data - Special (UNS) Threads	35
IV. Listing of Mil-Std Part Numbers in Numerical Sequence	36

MIL-STD-133B
15 MARCH 1963

MARK MIL-STD PART NUMBER
SHOWN IN COLUMN B TABLE I,II,OR III

MARK DATA SHOWN IN
COLUMN C TABLE I,II,OR III



ENLARGED VIEW
CHAMFER OR RADIUS ON
BOTH ENDS OF WIRE

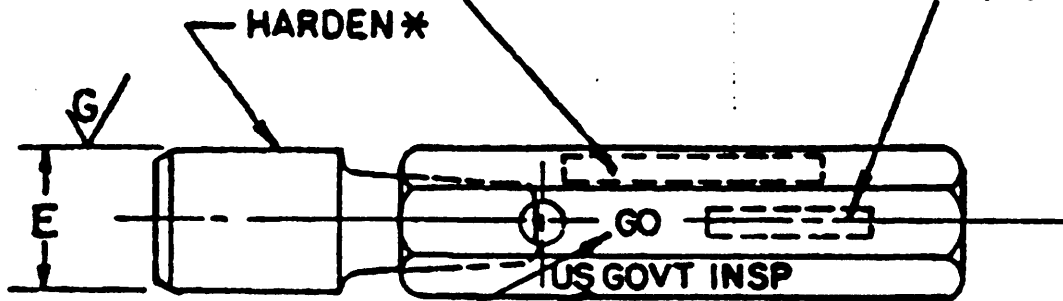
* HARDEN: ROCKWELL OR EQUIVALENT

C55 TO C60 FOR DIA UP TO AND INCL .10
C60 TO C63 FOR DIA ABOVE .10 TO AND INCL .20
C63 TO C66 FOR DIA ABOVE .20

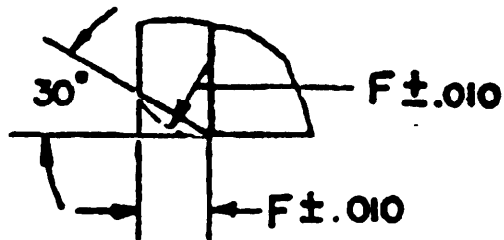
FIGURE 1. Go plain plug gage (wire type).

MIL-STD-133B
15 MARCH 1963

MARK MIL-STD PART NUMBER
SHOWN IN COLUMN B TABLE I, II, OR III
MARK DATA SHOWN IN
COLUMN C TABLE I, II, OR III



MARK AS SHOWN



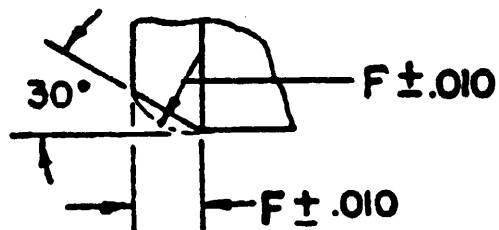
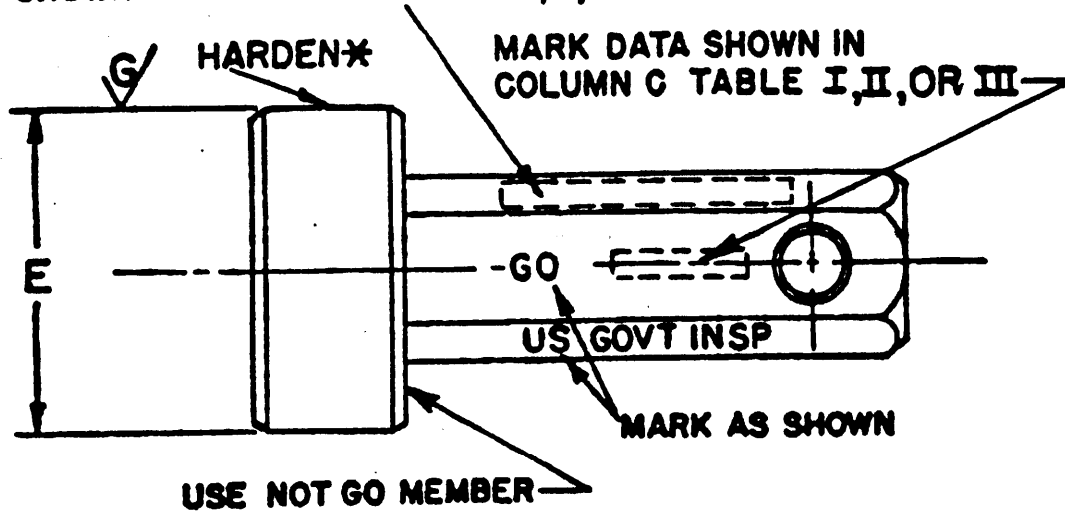
ENLARGED VIEW
CHAMFER OR RADIUS

*HARDEN: ROCKWELL OR EQUIVALENT
C63 TO C66

FIGURE 2. Go Plain Plug Gage (Taperlock Type)

MIL-STD-133B
15 MARCH 1963

MARK MIL-STD PART NUMBER
SHOWN IN COLUMN B TABLE I, II, OR III



ENLARGED VIEW
CHAMFER OR RADIUS
ON BOTH ENDS

* HARDEN: ROCKWELL OR EQUIVALENT
C63 TO C66

FIGURE 2. Go plain plug gage (tri-lock type)

Mil-Std-133B
 15 MARCH 1963

Table I. Tabulation of Design and Identification Data - Unified Standard Thread (Continued)

FIGURE NO.	MARKING ON GAGE HANDLE		COMPONENT THREAD DESIGNATION	GAGE DIMENSIONS		FINISH
	MIL-STD PART NUMBER	GO DIA		DIAMETER	CHAMFER	
A	B	C	D	E	F	G
1	5220-742-2764	.216	.2500-32UNEF-2B, 3B	.2162 + .0001	.015	8
1	5220-742-3346	.252	.3125-18UNC-1B, 2B, 3B	.2524 + .0003	.015	8
1	5220-742-3442	.258	.3125-20UN-2B, 3B	.2584 + .0003	.015	8
1	5220-742-3586	.267	.3125-24UNF-1B, 2B, 3B	.2674 + .0003	.015	8
1	5220-742-3694	.274	.3125-28UN-2B, 3B	.2742 + .0001	.015	8
1	5220-742-3774	.279	.3125-32UNEF-2B, 3B	.2792 + .0001	.015	8
1	5220-742-4228	.307	.3750-16UNC-1B, 2B, 3B	.3074 + .0003	.030	8
1	5220-742-4450	.321	.3750-20UN-2B, 3B	.3212 + .0001	.030	8
1	5220-742-4594	.330	.3750-24UNF-1B, 2B, 3B	.3302 + .0001	.030	8
1	5220-742-4690	.336	.3750-28UN-2B, 3B	.3362 + .0001	.030	8
1	5220-742-4770	.341	.3750-32UNEF-2B, 3B	.3412 + .0001	.030	8
1	5220-742-5080	.360	.4375-14UNC-1B, 2B, 3B	.3604 + .0003	.030	8
1	5220-742-5240	.370	.4375-16UN-2B, 3B	.3704 + .0003	.030	8
1	5220-742-5448	.383	.4375-20UNF-1B, 2B, 3B	.3834 + .0003	.030	8
1	5220-742-5700	.399	.4375-28UNEF-2B, 3B	.3992 + .0001	.030	8
1	5220-742-5780	.404	.4375-32UN-2B, 3B	.4042 + .0001	.030	8
1	5220-742-5994	.417	.5000-13UNC-1B, 2B, 3B	.4174 + .0003	.030	8
1	5220-742-6234	.432	.5000-16UN-2B, 3B	.4324 + .0003	.030	8
1	5220-742-6456	.446	.5000-20UNF-1B, 2B, 3B	.4462 + .0001	.030	8
1	5220-742-6696	.461	.5000-28UNEF-2B, 3B	.4612 + .0001	.030	8
1	5220-742-6776	.466	.5000-32UN-2B, 3B	.4662 + .0001	.030	8
1	5220-742-6878	.472	.5625-12UNC-1B, 2B, 3B	.4724 + .0003	.030	8

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL
(See Instructions - Reverse Side)

1. DOCUMENT NUMBER		2. DOCUMENT TITLE	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
b. ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
5. PROBLEM AREAS			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	

(TO DETACH THIS FORM, CUT ALONG THIS LINE.)