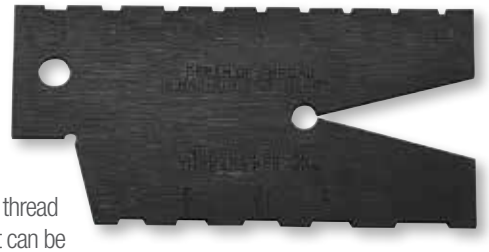
284 Acme Standard Screw Thread Gage

HARDENED
29º



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This gage is a standard for grinding and setting tools when cutting Acme threads. Acme threads have the same depth as square threads but the sides of the threads are at an inclination of 14-1/2º (29º included angle). This form of thread is used extensively and has in many instances replaced the square thread in machine construction. The advantages of the Acme thread are its strength and the ease by which it can be cut compared with square threads. The angles and edges of this gage are hardened, ground and carefully tested.

In use, the angle on the thread cutting tool is checked on the large precision-ground V at the end of the gage. The tool is then ground on the end to the width of the slot of whatever pitch is being turned. It is then set in the lathe using the half angle.

Fixed Gages		
Cat. No.	**EDP**	**Description**
284	51319	Acme Standard Screw Thread Gage

Standards for Sheet and Wire Gages with Corresponding Starrett Gages

Dimensions of Sizes in Decimal Parts of an Inch						
No. of Wire Gage	**281 American or Brown & Sharpe**	**188 and 245 Birmingham or Stubs' Iron Wire**	**287 Washburn & Moen, Worcester, MA***	**280 American S. & W. Co's. Music Wire Gage**	**Stubs' Steel Wire**	**283 U.S. Standard Gage for Sheet and Plate Iron and Steel**
00000000	0.7314					
0000000	0.6514					
000000	0.5800			0.004		0.4688
00000	0.5165			0.005		0.4375
0000	0.46	0.454	0.3938	0.006		0.4063
000	0.4096	0.425	0.3625	0.007		0.375
00	0.3648	0.38	0.331	0.008		0.3438
0	0.3249	0.34	0.3065	0.009		0.3125
1	0.2893	0.3	0.283	0.01	0.227	0.2813
2	0.2576	0.284	0.2625	0.011	0.219	0.2656
3	0.2294	0.259	0.2437	0.012	0.212	0.25
4	0.2043	0.238	0.2253	0.013	0.207	0.2344
5	0.1819	0.22	0.207	0.014	0.204	0.2188
6	0.1620	0.203	0.192	0.016	0.201	0.2031
7	0.1443	0.18	0.177	0.018	0.199	0.1875
8	0.1285	0.165	0.162	0.02	0.197	0.1719
9	0.1144	0.148	0.1483	0.022	0.194	0.1563
10	0.1019	0.134	0.135	0.024	0.191	0.1406
11	0.0907	0.12	0.1205	0.026	0.188	0.125
12	0.0808	0.109	0.1055	0.029	0.185	0.1094
13	0.0720	0.095	0.0915	0.031	0.182	0.0938
14	0.0641	0.083	0.08	0.033	0.18	0.0781
15	0.0571	0.072	0.072	0.035	0.178	0.0703
16	0.0508	0.065	0.0625	0.037	0.175	0.0625
17	0.0453	0.058	0.054	0.039	0.172	0.0563
18	0.0403	0.049	0.0475	0.041	0.168	0.05
19	0.0359	0.042	0.041	0.043	0.164	0.0438
20	0.0320	0.035	0.0348	0.045	0.161	0.0375
21	0.0285	0.032	0.0318	0.047	0.157	0.0344
22	0.0253	0.028	0.0286	0.049	0.155	0.0313
23	0.0226	0.025	0.0258	0.051	0.153	0.0281
24	0.0201	0.022	0.023	0.055	0.151	0.025
25	0.0179	0.02	0.0204	0.059	0.148	0.0219
26	0.0159	0.018	0.0181	0.063	0.146	0.0188
27	0.0142	0.016	0.0173	0.067	0.143	0.0172
28	0.0126	0.014	0.0162	0.071	0.139	0.0156
29	0.0113	0.013	0.015	0.075	0.134	0.0141
30	0.0100	0.012	0.014	0.08	0.127	0.0125
31	0.0089	0.01	0.0132	0.085	0.12	0.0109
32	0.0080	0.009	0.0128	0.09	0.115	0.0102
33	0.0071	0.008	0.0118	0.095	0.112	0.0094
34	0.0063	0.007	0.0104		0.11	0.0086
35	0.0056	0.005	0.0095		0.108	0.0078
36	0.005	0.004	0.009		0.106	0.0070
37	0.0045				0.103	0.0066
38	0.0040				0.101	0.0063
39	0.0035				0.099	
40	0.0031				0.097	

* Also called the U.S. Steel Wire Gage