

PMC LONE STAR



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SIZE CONTROL



How to Adjust a Thread Ring Gage to a Truncated Setting Plug

PMC Lone Star Technical Brief Doc. 102 Rev. C

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August 4, 2009

9. Steps 7 & 8 may need to be repeated several times to obtain the proper adjustment.
10. Once proper adjustment of the thread ring has been obtained, gently unscrew the truncated setting plug gage from the thread ring gage.
11. Once again, screw the truncated setting plug gage into the thread ring gage approximately one and half turns, lay thread ring gage flat on a stable surface so the truncated setting plug gage is standing vertically out of the thread ring gage. Attempt to move the truncated setting plug gage from side to side while holding thread ring gage down against surface to detect shake, if shake is detected, bell mouth condition is present and ring needs to be repaired.
12. Remembering the feel at the one and a half threads engagement, continue to screw the thread ring gage over the truncated and full-form sections of the truncated setting plug gage. The drag, should remain approximately the same with perhaps a bit more drag in the full-form section because of greater flank contact.
13. Remove the truncated setting plug gage from the thread ring gage and repeat step 12 on the other side of the thread ring gage. The drag between the truncated setting plug gage and the thread ring gage should feel the same from either side of the thread ring gage ensuring a straight pitch diameter.

When the thread ring gage is set to the truncated setting plug gage with a uniform feeling over the entire length of the truncated setting plug gage, with no end play, it is correctly adjusted. However, it should be noted that because of tolerances in the manufacture of both the thread ring gage and the truncated setting plug gage, and that unless they are manufactured at the same time, or ordered to be mated with each other, allowances must be made in the assembly feel or fit to compensate for slight differences. For example, a slight difference in angle and/or lead will cause more drag at full engagement than during a partial engagement. This is not a serious condition because both the thread ring gage and the truncated setting plug gage may well be within specifications.