



INDUSTRIAL TECTONICS INC
 7222 W. Huron River Drive
 Dexter, MI 48130



DOUBLE END PLUG GAGE

Please answer all questions completely by filling in the information in the “Answer” column below. Reference: General Drawing 15DEGAG.

<u>QUESTION</u>	<u>ANSWER</u>																				
1. What are the Ball Sizes?	“GO” _____ ” “NO-GO” _____ ”																				
2. What Class – “XX”, “X”, “Y”, or “Z” ? <u>BALL TOLERANCE FOR SIZE .050" - .750" DIAMETER</u> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;"></th> <th style="width: 15%;">Class XX</th> <th style="width: 15%;">Class X</th> <th style="width: 15%;">Class Y</th> <th style="width: 15%;">Class Z</th> </tr> </thead> <tbody> <tr> <td>GO</td> <td>+0.00002</td> <td>+0.00004</td> <td>+0.00007</td> <td>+0.00010</td> </tr> <tr> <td>NO-GO</td> <td>-0.00002</td> <td>-0.00004</td> <td>-0.00007</td> <td>-0.00010</td> </tr> <tr> <td>STD</td> <td>+/-0.00001</td> <td>+/-0.00002</td> <td>+/-0.000035</td> <td>+/-0.00005</td> </tr> </tbody> </table>		Class XX	Class X	Class Y	Class Z	GO	+0.00002	+0.00004	+0.00007	+0.00010	NO-GO	-0.00002	-0.00004	-0.00007	-0.00010	STD	+/-0.00001	+/-0.00002	+/-0.000035	+/-0.00005	
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3. What is the “shank length” dimension and tolerance from the bottom of the ball to the end of the stem? If not specified the shank length will be per the standard shank length on the ITI drawing. Typically this leaves 1” from the bottom of the ball to the handle.																					
4. What is the “shank length” dimension and tolerance from the bottom of the ball to the end of the stem? If not specified the shank length will be per the standard shank length on the ITI drawing. Typically this leaves 1” from the bottom of the ball to the handle.																					
5. Bushings and handles will be selected by Engineering based on stem diameter.																					
6. Do you required special markings or labeling? Please specify. Our standard marking on gage handles is the ball diameter (s) and the designation of “GO” or “NO GO”.																					



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CUSTOMER APPROVAL: _____
 SALES ORDER NUMBER: _____
 PART NUMBER: _____
 SALES ORDER DUE DATE: _____
 SALES COORDINATOR: _____ DATE: _____
 QUANTITY NEEDED: _____
 ADDITIONAL INSTRUCTIONS: _____

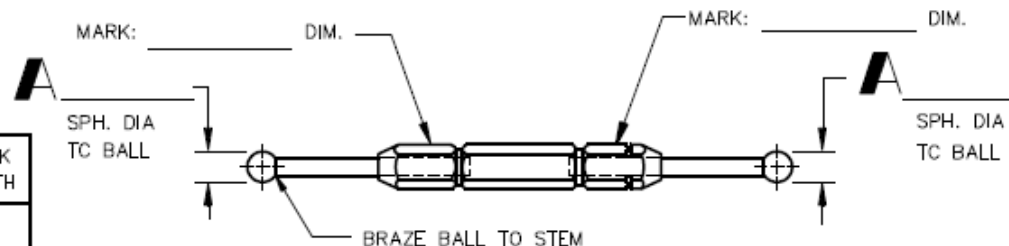
REVISIONS					
LET.	DESCRIPTION	BY	DATE	CHK'D	DATE
A	REVISED	RWH	9/97	RWH	9/97

	DATE	INITIAL
STKROOM ISSUE		
GAGE SIZE *		
MANUFACTURING		
GAGE SIZE *		
QUALITY CONTROL		
VISUAL INSPECTION		
SHIPPING		

* = ATTACH GAGE TAPE TO PRINT

BALL TOLERANCE FOR SIZE .050 - .750 DIAMETER				
	CLASS XX	CLASS X	CLASS Y	CLASS Z
"GO"	+ .00002	+ .00004	+ .00007	+ .00010
"NO-GO"	- .00002	- .00004	- .00007	- .00010
"STD"	+/- .00001	+/- .00002	+/- .000035	+/- .00005

A	B	C	SHANK P/N	SHANK DIA.	SHANK LENGTH
.0500 - .0900	1W	045	3150014	045	2.00
.0630 - .1250	1W	065	3150015	062	
.0940 - .1920	2W	096	3150016	093	
.1570 - .3120	2W	159	3150017	156	
.1880 - .3750	3W	188	3150018	187	2.50
.2510 - .5020	3W	252	3150019	250	
.3760 - .7500	4W	382	3150020	375	



ASSEMBLED GAGE

(1) DE HANDLE: **B** (2) BUSHINGS: **C**

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:

FRACTIONS= ± .XX=±. 010

ANGLES= ± 1° .XXX=±. 005

BREAK ALL SHARP CORNERS:
 .02 x 45°

DRAWN	CHECKED
HECKAMAN	JCC
10-13-93	10-13-93
SCALE NONE	REQ'D.
MATERIAL SEE ABOVE	
DO NOT SCALE	

INDUSTRIAL TECTONICS INC.
 A KAYDON COMPANY DEXTER, MICHIGAN

(15'S) DOUBLE END
 PLUG GAGES (TAB.)

SHEET NUMBER 1 OF 1	
PART NUMBER 15DEGAG	REV. A