

3 WIRE UNIT



Technical Specifications

Available for micrometer with 6.35mm, 6.50mm and 8.0mm spindle diameters.

Formula to obtain the pitch diameter E*

$E = M - 3d + 0.866025P$ Where

E = Pitch Diameter

P = Screw Thread Pitch

d = Diameter of the wire

M = Measurement over the wire

* For Metric and UNF Screws

Range	Accuracy Diametrical Tolerance	Hardness	Sizes
0.25 - 5 mm Pitch Threads (1 Unit = 03 Wires)	±0.5µm	700 HV	0.170mm, 0.195mm, 0.220mm, 0.250mm, 0.290mm, 0.335mm, 0.390mm, 0.455mm, 0.530mm, 0.620mm, 0.725mm, 0.895mm, 1.100mm, 1.350mm, 1.650mm, 2.050mm, 2.550mm, 3.20mm

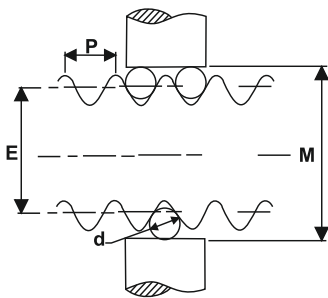
Features

- Available for micrometer with 6.35mm, 6.50mm and 8.0mm spindle diameters
- Available in single pair or in complete set
- Each 3-wire unit set consists of two holders
- Wires are mounted on the holder to enable easy positioning over the thread during measurement. Wires are hardened, ground and lapped
- Each set consists of 18 assorted sizes of wires

Applications

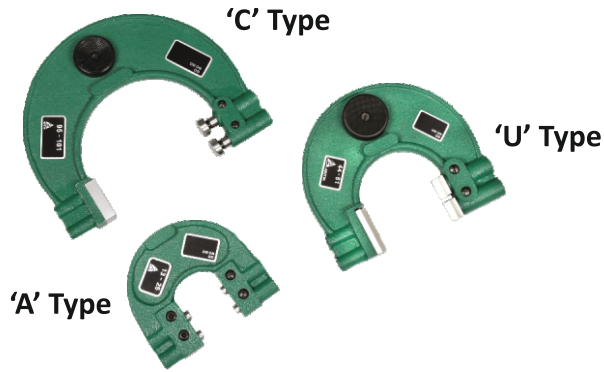
Measurement of the pitch diameter of screw threads using standard micrometer

PITCH DIAMETER CHART



$P_{Value} = \frac{P}{2} * \cot(\frac{\alpha}{2}) - d * [\cos(\frac{\alpha}{2}) - 1]$		For 60° P value = 0.866P - d		Where d is mean diameter of wire				
		For 55° P value = 0.960P - 1.166d						
Thread Type, Corresponding pitch & P Value								
Nominal size of wire in mm	ISO Metric (MM)		Unified & ISO TPI (INCH)		Whitworth TPI Parallel Threads		British Associate (B.A.)	
	Pitch P	P value	TPI	P Value	TPI	P value	No.	P value
0.170	0.25	0.047	--	--	--	--	10	0.146
	0.30	0.090	--	--	--	--	--	--
0.195	--	--	80	0.080	--	--	9	0.154
0.220	0.35	0.083	72	0.086	--	--	--	--
0.250	0.40	0.096	64	0.094	--	--	7	0.175
0.290	0.45	0.100	56	0.103	--	--	6	0.172
	0.50	0.143	--	--	--	--	--	--
0.335	0.60	0.185	48	0.123	40	0.219	5	0.174
	--	--	--	--	--	--	4	0.253
0.390	--	--	44	0.110	36	0.223	3	0.251
	--	--	40	0.160	--	--	--	--
0.455	0.70	0.151	36	0.156	32	0.232	2	0.246
	0.75	0.195	--	--	--	--	1	0.348
	0.80	0.238	--	--	--	--	--	--
0.530	0.90	0.249	32	0.157	28	0.253	0	0.350
	--	--	28	0.256	--	--	--	--
0.620	1.00	0.246	26	0.226	26	0.216	--	--
0.725	1.25	0.358	24	0.192	22	0.264	--	--
	--	--	22	0.275	20	0.375	--	--
	--	--	20	0.375	19	0.439	--	--
	--	--	19	0.433	--	--	--	--
0.895	1.50	0.404	18	0.327	18	0.312	--	--
	--	--	--	--	16	0.482	--	--
1.100	1.75	0.416	16	0.275	14	0.460	--	--
	--	--	14	0.471	--	--	--	--
	--	--	13	0.592	--	--	--	--
1.350	2	0.382	12	0.483	12	0.459	--	--
	--	--	11	0.650	11	0.644	--	--
1.650	2.5	0.515	10	0.550	10	0.516	--	--
	--	--	9	0.794	9	0.788	--	--
2.050	3.0	0.548	8	0.700	8	0.660	--	--
	3.5	0.981	7	1.092	7	1.096	--	--
2.550	4.0	0.914	6	1.116	6	1.094	--	--
	4.5	1.347	--	--	--	--	--	--
3.200	5.0	1.130	5	1.199	5	1.149	--	--
	5.5	1.563	4.5	1.688	4.5	1.692	--	--
4.000	6	1.196	4	1.499	4	1.437	--	--
	--	--	--	--	3.5	2.308	--	--

ADJUSTABLE SNAP GAUGE



Features

- Go/No Go Gauging with Reset Facility in the event of wear
- Available in square, grooved or pin type anvil design for the particular application
- Conforms to IS : 7606-1982

Technical Specifications

Parallelism	3µm upto 32mm 4µm upto 89mm 5µm upto 300mm
Anvil Flatness	1.5µm

'C' Type	'A' Type	'U' Type
(Range in mm) 0-6, 6-13, 13-19, 19-25, 25-32, 32-38, 38-44, 44-51, 51-57, 57-63, 63-70, 70-76, 76-82, 82-89, 89-95, 95-101, 101-108, 108-114, 114-120, 120-127, 127-133, 133-139, 139-146, 146-152, 152-163, 163-175, 175-188, 188-200, 200-213, 213-225, 225-238, 238-250, 250-263	(Range in mm) 0-13, 13-25, 25-38, 38-51, 51-64, 64- 76, 76-95, 95-114, 114-133, 133-152, 152-178, 178-203, 203-229, 229-254, 254-279, 279-305	(Range in mm) 0-6, 6-13, 13-19, 19-26, 26-32, 32-38, 38-44, 44-51, 51-57, 57-67, 67-76, 76-86, 86-95, 95-105, 105-114, 114-124, 124-133, 133-146, 146-159, 159-171, 171-184, 184-197, 197-210, 210-222, 222-235, 235-248, 248-260

Applications

- Useful for checking External Dimensions
- Convenient for checking mass produced components by unskilled labour
- Go & No Go Gauge sizes can be set & checked easily
- Convenient for checking Grooved Dimensions by type A & U

DIAL SNAP GAUGE



Features

- Aluminum frame with plastic handle to provide insulation and firm grip
- Ground and lapped carbide measuring anvils provide high wear resistance and long life. Chattered anvils ensure easy & safe insertion of the work piece
- Collet clamping of sensing device like dial indicators (mechanical or electronic) with 8 mm mounting shank ensures positive clamping and alignment to measuring axis
- Smooth and an rotational movement of the measuring spindle by guide pin
- Adjustable stopper for correct positioning of work piece ensures accuracy in repetitive measurements
- Protector provided to ensure adequate protection to the sensing device
- Cylindrical setting master available on request
- Conforms to IS 14271-1995

Technical Specifications

Measuring Face	14mmx14mm (Carbide Tipped)	Range mm
Parallelism	4µm upto 0-50mm 5µm For 50-75mm 6µm For 75-125mm 8µm For 125-175mm 10µm For 175-200mm 12µm For 250-300mm	0-25 25-50 50-75 75-100 100-125 125-150 150-175 175-200 200-225 225-250 250-275 275-300
Movement of Measuring Anvils	2mm	
Flatness of Anvil	0.0015mm	
Repeatability	0.001mm	
Measuring Force	6N upto 75mm, 7N For 75-125mm, 7.5N For 125-200mm, 8N For 200-300mm	

Applications

- External Diameter Checking
- Dial Snap Gauge is a convenient instrument used for checking mass produced components with speed & precision



Accurate Metrology And Automation Company

(Formerly "Aditya Engineering Company")

- Head Office** : 67, Hadapsar Industrial Estate, Pune-411 013, Maharashtra, India.
 +91-20- 6606 9595, +91 86000 23615
Works : A/P - Khalad, Saswad Jejuri Road, Tal. Purandhar, Pune-412 301, India.
 +91 99700 02528 | adityaengg@adityaengg.com | **GST** : 27AACFA5688G1ZA
 +91 86000 21671 | www.adityaengg.com | **PAN** : AACFA5688G

Authorised Distributor :



MIKT-2023

● Sales Branch Offices ●

Pune	: +91 99700 02573	Delhi	: +91 80107 32455
Nashik	: +91 74474 64750	Bhiwadi	: +91 95551 81100
Kolhapur	: +91 86000 23613	Bengaluru	: +91 95903 25411
Gujarat	: +91 91759 83127	Chennai	: +91 90214 12461
Kolkata	: +91 76776 20966		

Note : Due to continuous Improvements at our end, Specifications are subject to change without prior notice.