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Reconfirmed 2017

Australian Standard®

Pipe threads where pressure-tight joints are made on the threads

Part 2: Verification by means of limit gauges



This Australian Standard® was prepared by Committee ME-028, Screw Threads. It was approved on behalf of the Council of Standards Australia on 30 September 2007.
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- Australian Chamber of Commerce and Industry
- Australian Stainless Steel Development Association
- Engineers Australia
- Federal Chamber of Automotive Industries
- Materials Australia
- Plastics Industry Pipe Association of Australia
- University of Wollongong

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STANDARDS AUSTRALIA

RECONFIRMATION

OF
AS ISO 7.2—2008
Pipe threads where pressure-tight joints are made on the threads
Part 2: Verification by means of limit gauges

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NOTES

Australian Standard®

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Originated as part of AS 1722.1—1975.
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PREFACE

This Standard was prepared by the Joint Standards Australia Committee ME-028, Screw Threads to supersede (in part), AS 1722.1—1975, *Pipe threads of Whitworth form,* Part 1: *Sealing pipe threads*.

The objective of this Standard is to provide manufacturers of pipe fittings and associated equipment with the requirements for limit gauges for the verification of pipe threads where pressure-tight joints are made on the threads.

This Standard is Part 2 of a two-part series on pipe threads where pressure-tight joints are made on the threads. Part 1 specifies the dimensions, tolerances and designation.

This Standard is identical with and has been reproduced from ISO 7-2:2000, *Pipe threads where pressure-tight joints are made on the threads,* Part 2: *Verification by means of limit gauges*.

As this Standard is reproduced from an international standard, the following applies:

(a) Its number appears on the cover and title page while the international standard number appears only on the cover.

(b) In the source text ‘this part of ISO 7’ should read ‘this Australian Standard.’

(c) A full point substitutes for a comma when referring to a decimal marker.

The term ‘normative’ has been used in this Standard to define the application of the annex to which it applies. A ‘normative’ annex is an integral part of a Standard.

References to International Standards should be replaced by references to Australian or Australian/New Zealand Standards, as follows:

Reference to International Standard		*Australian Standard/New Zealand Standard*	
ISO		AS ISO	
7	Pipe threads where pressure-tight joints are made on the threads	7	Pipe threads where pressure-tight joints are made on the threads
7-1	Part 1: Dimensions, tolerances and designation	7.1	Part 1: Dimensions, tolerances and designation

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INTRODUCTION

This revision of ISO 7-2 has been undertaken with the aim of providing a unified gauging system which could be adopted worldwide and thus eliminate the differing gauging results obtained with the use of gauges in accordance with ISO 7-2:1982 and existing national practices. This revision also includes details of plain ring gauges to provide additional means of checking ISO 7-1 external threads and a parallel modified thread form check ring gauge for checking taper full form threaded plug gauges.

AUSTRALIAN STANDARD

Pipe threads where pressure-tight joints are made on the threads —

Part 2:
Verification by means of limit gauges

1 Scope

This part of ISO 7 specifies a process using limit gauges, for the validation of taper internal and external threads and parallel internal threads on piping systems components and other products, the dimensions and tolerances of which are detailed in ISO 7-1.

The gauging system described may not be suitable, without special precautions, for gauging of threads on injection moulded plastic workpieces.

This part of ISO 7 does not cover completely all the requirements necessary for full control of thread quality and dimensions. Additional control of tools and equipment and visual inspection during production are required to ensure complete compliance with ISO 7-1, for example the length of useful thread on internally threaded workpieces should be checked by direct measurement.

Annex A gives a summary of the gauges included in this part of ISO 7, together with details of the thread elements controlled by each gauge and gauge identification numbers.

In the event of a dispute over compliance with the requirements of ISO 7-1, the gauges in this part of ISO 7 are to be considered as decisive for the thread elements which they control on the workpiece.

2 Normative reference

The following normative document contains provisions which, through reference in this text, constitute provisions of this part of ISO 7. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 7 are encouraged to investigate the possibility of applying the most recent edition of the normative document indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 7-1:1994, *Pipe threads where pressure-tight joints are made on the threads — Part 1: Dimensions, tolerances and designation.*

3 Terms and definitions

For the purposes of this part of ISO 7, the terms and definitions given in ISO 7-1 and the following apply.

3.1
accommodation length
distance from the face of an internally threaded workpiece to the first obstruction which the externally threaded workpiece will encounter on assembly

See Figure 3.

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