



ACCUMETRICS LIMITED

ID PIN Gage Procedure Used To Determine Absolute ID Size

Drop Thru means that the gage pin can be inserted vertically in a sample and will drop thru to the table top. ID = Needs .0005" minimum clearance over gage pin.

Go Free means that the gage pin can be inserted full length with no resistance. ID = At least .0004" higher than the gage pin.

Go means that the gage pin can be inserted resistance free virtually full length (2") into the ID of a sample. ID = At least .0003" higher than gage pin.

Go Tight means that the gage pin can be inserted with slight resistance virtually full length (2") into the ID of a sample. ID = .0002" higher than pin gage.

Start means that the gage pin can be inserted up to 100% of gage diameter, but not full length. ID = .0001" higher than page pin.

Tip means the gage pin can enter the tube, but no more than approximately 25% of the gage diameter. ID = the gage pin. (This takes into account radius of gage and tube deburring.)

The above table presumes a straight, round, & deburred sample! Some thought and allowances must be made for tubing which is not straight or round.

If the OD/wall ratio is equal to or greater than 20:1 ovality will impact less on all but Go Free and Drop Thru conditions as the gage will tend to round up the tube.