

Overall length	GO part	NOT-GO part	Recess length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_1	ℓ_2	ℓ_3	ℓ_n	ℓ_s	Ds	K	ℓ_k

JIS

①

Spiral Fluted Taps
(for blind hole)

②

Spiral Fluted Taps
(for through hole)

③

Spiral Pointed Taps
(for through hole)

④

Hand Taps

⑤

Cemented
Carbide Taps

⑥

Roll Taps

⑦

Special Thread Taps
Simple Inspection Tools

⑧

Pipe Taps

⑨

Thread Mills
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments

JIS

⑦-57

SITD

SITD

Simple Thread Inspection Tools,
Tandem Type

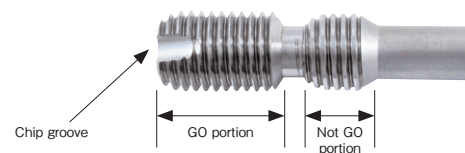
Specification

HSS



Product Features

- The SITD has two "screw threaded portions" in an integrated shape on one gauge. It has sections for Go threads and Not Go threads combined, thus it can be used in a continuous measurement of the GO (GP) and the NOT GO (NP / WP) with one plug gauge. It is an inspection tool that can be completed in one measurement.
- SITD is installed in a screw tightening machine when used.
- For use with small diameter fine pitch threads. Smooth measurement can be carried out by using the stepped thread even for screw inspection that is difficult to insert.
- To ensure accurate inspection, it is mandatory to remove all small debris in the inside of the internal thread before inserting the gauge into the thread thus, the chip groove end part is used for this purpose.



The accuracy of the SITD

The single pitch diameter tolerance, the pitch tolerance and the threads half angle allowance are all important in the accurate measurement of an internal screw thread. The SITD gauges are manufactured to the same accuracy as that of a thread plug gauge.

■Comparison between the GO screw thread "GB-6H" and the GO screw thread plug gauge "GP-6H"

Unit : mm

Size	Major Diameter				Pitch Diameter				Pitch Tol.	Thread Half Angle Tol.
	Basic Size	Max	Min	Tol.	Basic Dia.	Max	Min	Tol.	(±)	(± Min.)
GB-6H M6 × 1	6.000	6.023	6.001	0.022	5.350	5.3675	5.3565	0.011	0.005	15
GP-6H M6 × 1	6.000	6.023	6.001	0.022	5.350	5.3675	5.3565	0.011	0.005	15

The pitch diameter is a single pitch diameter tolerance.
The tolerance of the pitch also includes the deviation of the lead.

■Comparison of NOT GO thread portion "NB-6H" and NOT GO screw thread plug gauge "NP-6H"

Unit : mm

Size	Major Diameter				Pitch Diameter				Pitch Tol.	Thread Half Angle Tol.
	Basic Size	Max	Min	Tol.	Basic Dia.	Max	Min	Tol.	(±)	(± Min.)
NB-6H M6 × 1	5.7055	5.7165	5.6945	0.022	5.500	5.511	5.500	0.011	0.005	16
NP-6H M6 × 1	5.7055	5.7165	5.6945	0.022	5.500	5.511	5.500	0.011	0.005	16

The pitch diameter is a single pitch diameter tolerance.
The tolerance of the pitch also includes the deviation of the lead.

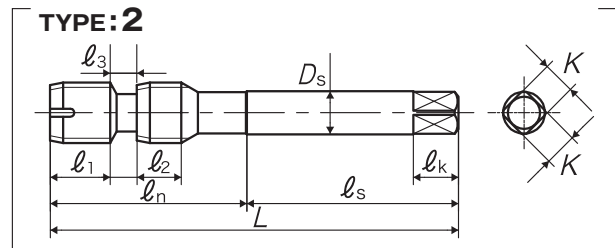
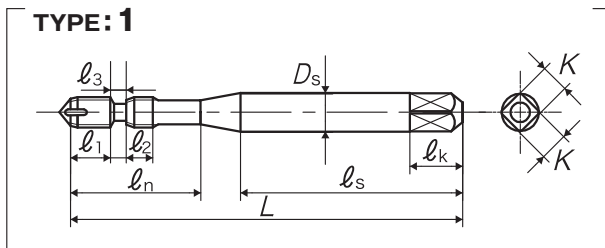
- * The screw thread precision is the same as a thread gauge, but since some of the specifications like length of screw thread portion and the relief shape of the thread root are originated by YAMAWA. Therefore, these gauges are not to be called "thread gauge" and distinguished as "simple inspection tools for internal screw threads".

The SITD is distinguished as a simple inspection tool of internal screw threads.

Overall length	GO part	NOT-GO part	Recess length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_1	ℓ_2	ℓ_3	ℓ_n	ℓ_s	Ds	K	ℓ_k

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JIS



Segment : 7B

Size	Class	Code	L (mm)	ℓ_1 (mm)	ℓ_2 (mm)	ℓ_3 (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	TYPE	MSRP
For Metric Threads													
M2 × 0.4	6H	ITDM62.0E	42	4	2	1.2	12	27	3	2.5	5	1	¥ 28,400 □
M2 × 0.25	5H	ITDM52.0B	42	4.9	1.3	1	12	27	3	2.5	5	1	¥ 38,600 □
M2.2 × 0.45	6H	ITDM62.2F	42	4.4	2.3	1.4	12	27	3	2.5	5	1	¥ 28,400 □
M2.2 × 0.25	5H	ITDM52.2B	42	5.8	1.3	1	12	27	3	2.5	5	1	¥ 38,600 □
M2.3 × 0.4	6H	ITDM62.3E	42	4	2	1.2	12	27	3	2.5	5	1	¥ 28,400 □
M2.3 × 0.25	5H	ITDM52.3B	42	4.9	1.3	1	12	27	3	2.5	5	1	¥ 38,600 □
M2.5 × 0.45	6H	ITDM62.5F	46	4.4	2.3	1.4	14	29	3	2.5	5	1	¥ 25,600 □
M2.5 × 0.35	6H	ITDM62.5D	46	5.2	1.8	1.1	14	29	3	2.5	5	1	¥ 34,500 □
M2.6 × 0.45	6H	ITDM62.6F	46	4.4	2.3	1.4	14	29	3	2.5	5	1	¥ 25,600 □
M2.6 × 0.35	6H	ITDM62.6D	46	5.2	1.8	1.1	14	29	3	2.5	5	1	¥ 34,500 □
M3 × 0.5	6H	ITDM63.0G	46	5	2.5	1.5	14	26	4	3.2	6	1	¥ 25,100 □
M3 × 0.35	6H	ITDM63.0D	46	6.1	1.8	1.1	14	26	4	3.2	6	1	¥ 34,100 □
M3.5 × 0.6	6H	ITDM63.5H	52	6.2	3	1.8	16	29	5	4	7	1	¥ 23,800 □
M3.5 × 0.35	6H	ITDM63.5D	52	8.1	1.8	1.1	16	29	5	4	7	1	¥ 33,500 □
M4 × 0.7	6H	ITDM64.0I	52	5.4	3.5	2.1	17	29	5	4	7	1	¥ 23,800 □
M4 × 0.5	6H	ITDM64.0G	52	7	2.5	1.5	17	29	5	4	7	1	¥ 29,100 □
M4.5 × 0.75	6H	ITDM64.5J	60	6.9	3.8	2.3	21	33	5.5	4.5	7	1	¥ 23,600 □
M4.5 × 0.5	6H	ITDM64.5G	60	9	2.5	1.5	21	33	5.5	4.5	7	1	¥ 29,200 □
M5 × 0.8	6H	ITDM65.0K	60	6.6	4	2.4	22	33	5.5	4.5	7	1	¥ 23,600 □
M5 × 0.5	6H	ITDM65.0G	60	9	2.5	1.5	22	33	5.5	4.5	7	1	¥ 29,200 □
M5.5 × 0.5	6H	ITDM65.5G	62	11	2.5	1.5	26	33	6	4.5	7	1	¥ 29,600 □
M6 × 1	6H	ITDM66.0M	62	7	5	3	26	33	6	4.5	7	1	¥ 23,100 □
M6 × 0.75	6H	ITDM66.0J	62	8.9	3.8	2.3	26	33	6	4.5	7	1	¥ 25,400 □
M7 × 1	6H	ITDM67.0M	70	11.9	5	3	34	36	6.2	5	8	2	¥ 25,000 □
M7 × 0.75	6H	ITDM67.0J	70	13.8	3.8	2.3	34	36	6.2	5	8	2	¥ 26,300 □
M8 × 1.25	6H	ITDM68.0N	70	8.9	6.3	3.8	34	36	6.2	5	8	2	¥ 23,600 □
M8 × 1	6H	ITDM68.0M	70	11	5	3	34	36	6.2	5	8	2	¥ 23,600 □
M8 × 0.75	6H	ITDM68.0J	70	12.9	3.8	2.3	34	36	6.2	5	8	2	¥ 27,500 □
M9 × 1.25	6H	ITDM69.0N	75	13.8	6.3	3.8	37	38	7	5.5	8	2	¥ 32,100 □
M9 × 1	6H	ITDM69.0M	75	15.9	5	3	37	38	7	5.5	8	2	¥ 32,100 □
M9 × 0.75	6H	ITDM69.0J	75	17.8	3.8	2.3	37	38	7	5.5	8	2	¥ 32,100 □
M10 × 1.5	6H	ITDM6010O	75	11	7.5	4.5	37	38	7	5.5	8	2	¥ 23,800 □
M10 × 1.25	6H	ITDM6010N	75	12.9	6.3	3.8	37	38	7	5.5	8	2	¥ 23,800 □
M10 × 1	6H	ITDM6010M	75	15	5	3	37	38	7	5.5	8	2	¥ 23,800 □
M10 × 0.75	6H	ITDM6010J	75	16.9	3.8	2.3	37	38	7	5.5	8	2	¥ 30,500 □
M11 × 1.5	6H	ITDM6011O	82	14.9	7.5	4.5	40	42	8.5	6.5	9	2	¥ 24,500 □
M11 × 1	6H	ITDM6011M	82	18.9	5	3	40	42	8.5	6.5	9	2	¥ 31,800 □
M11 × 0.75	6H	ITDM6011J	82	20.8	3.8	2.3	40	42	8.5	6.5	9	2	¥ 31,800 □
M12 × 1.75	6H	ITDM6012P	82	11.9	8.8	5.3	40	42	8.5	6.5	9	2	¥ 24,500 □
M12 × 1.5	6H	ITDM6012O	82	14	7.5	4.5	40	42	8.5	6.5	9	2	¥ 24,500 □
M12 × 1.25	6H	ITDM6012N	82	15.9	6.3	3.8	40	42	8.5	6.5	9	2	¥ 24,500 □

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(for blind hole)

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Premium Thread Mills

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Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Metal Surgical Instruments

⑫

JIS

⑦-58

□=In stock at manufacturer.

Think threads with

Overall length	GO part	NOT-GO part	Recess length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_1	ℓ_2	ℓ_3	ℓ_n	ℓ_s	Ds	K	ℓ_k

JIS

SITD Simple Thread Inspection Tools, Tandem Type

Size	Class	Code	L (mm)	ℓ_1 (mm)	ℓ_2 (mm)	ℓ_3 (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	TYPE	MSRP
M12 × 1	6H	ITDM6012M	82	18	5	3	40	42	8.5	6.5	9	2	¥ 25,800 □
M14 × 2	6H	ITDM6014Q	88	10	10	6	43	45	10.5	8	11	2	¥ 25,800 □
M14 × 1.5	6H	ITDM6014O	88	14	7.5	4.5	43	45	10.5	8	11	2	¥ 25,800 □
M14 × 1.25	6H	ITDM6014N	88	15.9	6.3	3.8	43	45	10.5	8	11	2	¥ 29,100 □
M14 × 1	6H	ITDM6014M	88	18	5	3	43	45	10.5	8	11	2	¥ 29,100 □
M15 × 1.5	6H	ITDM6015O	95	14.9	7.5	4.5	47	48	12.5	10	13	2	¥ 28,600 □
M15 × 1	6H	ITDM6015M	95	18.9	5	3	47	48	12.5	10	13	2	¥ 28,600 □
M16 × 2	6H	ITDM6016Q	95	10	10	6	47	48	12.5	10	13	2	¥ 29,000 □
M16 × 1.5	6H	ITDM6016O	95	14	7.5	4.5	47	48	12.5	10	13	2	¥ 29,000 □
M16 × 1	6H	ITDM6016M	95	18	5	3	47	48	12.5	10	13	2	¥ 30,800 □
M17 × 1.5	6H	ITDM6017O	100	21.9	7.5	4.5	49	51	14	11	14	2	¥ 30,800 □
M17 × 1	6H	ITDM6017M	100	25.9	5	3	49	51	14	11	14	2	¥ 30,800 □
M18 × 2.5	6H	ITDM6018R	100	13	12.5	7.5	49	51	14	11	14	2	¥ 29,800 □
M18 × 2	6H	ITDM6018Q	100	17	10	6	49	51	14	11	14	2	¥ 29,800 □
M18 × 1.5	6H	ITDM6018O	100	21	7.5	4.5	49	51	14	11	14	2	¥ 29,800 □
M18 × 1	6H	ITDM6018M	100	25	5	3	49	51	14	11	14	2	¥ 31,100 □
For Unified Threads													
No.2-56UNC	2B	ITDM2UN2E	42	4.4	2.3	1.4	12	26	3	2.5	5	1	¥ 30,500 □
No.2-64UNF	2B	ITDM2UN2D	42	4.9	2	1.2	12	26	3	2.5	5	1	¥ 30,500 □
No.3-48UNC	2B	ITDM2UN3F	46	3.9	2.6	1.6	14	28	3	2.5	5	1	¥ 30,500 □
No.3-56UNF	2B	ITDM2UN3E	46	4.4	2.3	1.4	14	28	3	2.5	5	1	¥ 30,500 □
No.4-40UNC	2B	ITDM2UN4H	46	3.9	3.2	1.9	14	25	4	3.2	6	1	¥ 29,100 □
No.4-48UNF	2B	ITDM2UN4F	46	4.8	2.6	1.6	14	25	4	3.2	6	1	¥ 29,100 □
No.5-40UNC	2B	ITDM2UN5H	52	5.9	3.2	1.9	16	28	5	4	7	1	¥ 29,100 □
No.5-44UNF	2B	ITDM2UN5G	52	6.4	2.9	1.7	16	28	5	4	7	1	¥ 29,100 □
No.6-32UNC	2B	ITDM2UN6J	52	4.6	4	2.4	17	27	5	4	7	1	¥ 27,900 □
No.6-40UNF	2B	ITDM2UN6H	52	5.9	3.2	1.9	17	27	5	4	7	1	¥ 27,900 □
No.8-32UNC	2B	ITDM2UN8J	60	6.6	4	2.4	22	31	5.5	4.5	7	1	¥ 28,400 □
No.8-36UNF	2B	ITDM2UN8I	60	7.4	3.5	2.1	22	31	5.5	4.5	7	1	¥ 28,400 □
No.10-24UNC	2B	ITDM2UNAM	62	7.5	5.3	3.2	26	32	6	4.5	7	1	¥ 26,400 □
No.10-32UNF	2B	ITDM2UNAJ	62	9.6	4	2.4	26	32	6	4.5	7	1	¥ 26,400 □
No.12-24UNC	2B	ITDM2UNCM	62	6.5	5.3	3.2	26	32	6	4.5	7	1	¥ 26,400 □
No.12-28UNF	2B	ITDM2UNCK	62	7.8	4.5	2.7	26	32	6	4.5	7	1	¥ 26,400 □
1/4-20UNC	2B	ITDM2U04N	70	10.2	6.4	3.8	34	36	6.2	5	8	2	¥ 26,900 □
1/4-28UNF	2B	ITDM2U04K	70	13.2	4.5	2.7	34	36	6.2	5	8	2	¥ 26,900 □
5/16-18UNC	2B	ITDM2U05O	70	7.7	7.1	4.2	34	36	6.2	5	8	2	¥ 28,600 □
5/16-24UNF	2B	ITDM2U05M	70	10.5	5.3	3.2	34	36	6.2	5	8	2	¥ 28,600 □
3/8-16UNC	2B	ITDM2U06P	75	10.7	7.9	4.8	37	38	7	5.5	8	2	¥ 28,600 □
3/8-24UNF	2B	ITDM2U06M	75	14.9	5.3	3.2	37	38	7	5.5	8	2	¥ 28,600 □
7/16-14UNC	2B	ITDM2U07Q	82	12.3	9.1	5.4	40	42	8.5	6.5	9	2	¥ 29,100 □
7/16-20UNF	2B	ITDM2U07N	82	16.6	6.4	3.8	40	42	8.5	6.5	9	2	¥ 29,100 □
1/2-13UNC	2B	ITDM2U08R	88	11.4	9.8	5.9	43	45	10.5	8	11	2	¥ 29,100 □
1/2-20UNF	2B	ITDM2U08N	88	16.9	6.4	3.8	43	45	10.5	8	11	2	¥ 29,100 □
9/16-12UNC	2B	ITDM2U09S	95	10.5	10.6	6.4	47	48	12.5	10	13	2	¥ 32,400 □
9/16-18UNF	2B	ITDM2U09O	95	16.2	7.1	4.2	47	48	12.5	10	13	2	¥ 32,400 □
5/8-11UNC	2B	ITDM2U10U	100	16.4	11.5	6.9	49	51	14	11	14	2	¥ 32,400 □
5/8-18UNF	2B	ITDM2U10O	100	23.5	7.1	4.2	49	51	14	11	14	2	¥ 32,400 □

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Precision Machinery/
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