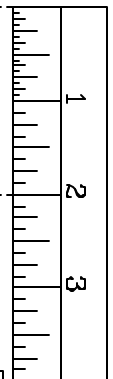


Measure at Least 2" of Thread on all Stems
 Some stems may have an odd number of threads per inch.
 Stem "A" has 3 1/2 threads per inch
 Stem "B" has 4 threads per inch.

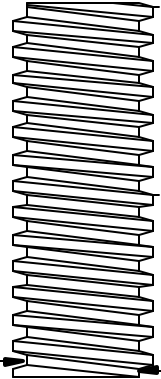
Stem od:



Minor ϕ :



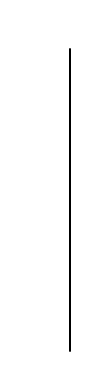
Thread Depth: *



TPI:



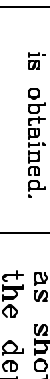
of Leads:



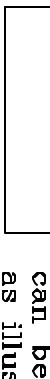
RH or LH:



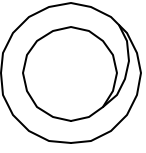
Land Width @ Major ϕ :



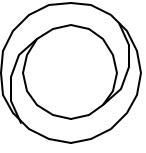
Land Width @ Minor ϕ :



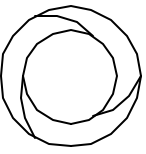
Land Width @ Minor ϕ :



Single



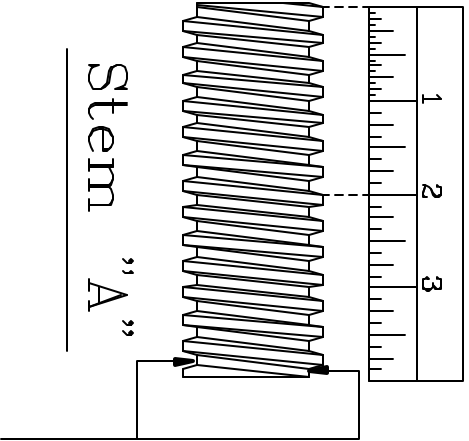
Double



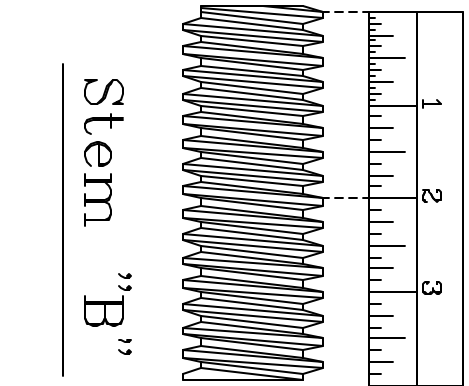
Triple Lead

The illustrations above represent end views, each with a different "Lead." If an end view is unavailable, then the lead can be determined by following the groove of the thread with some pointing device or with your finger. If a thread appears to have been skipped, then the stem has a double lead. If two threads have been skipped, then the stem has a triple lead. Etc.

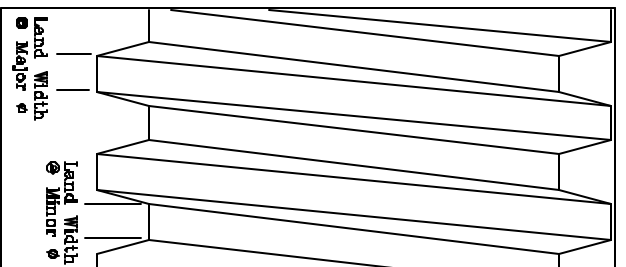
* Please insure Thread Depth measurement is obtained.



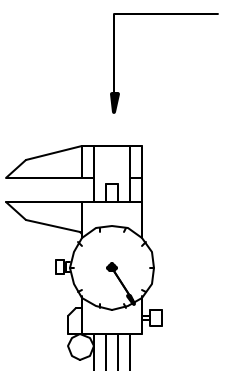
Stem "A"



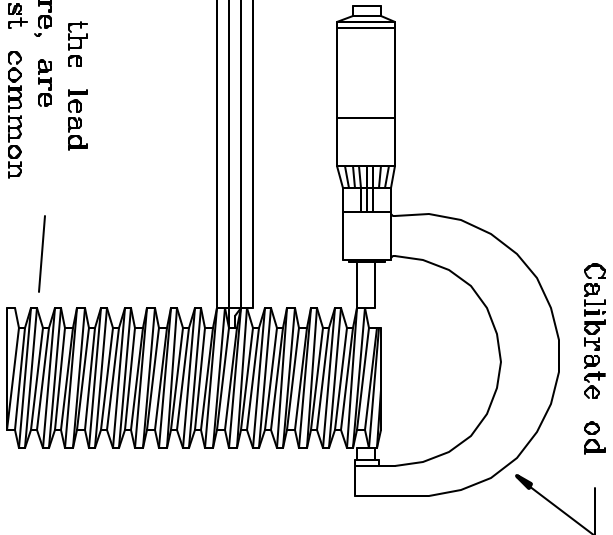
Stem "B"



A small Caliper can be effective in measuring the Minor Diameter as shown above, or the depth of thread can be checked as illustrated below.



NOTE: threads with the lead angled as shown here, are "Left Hand," the most common for stems.



Calibrate od

Rev	Description	Drawn by:	CCS
		Checked by:	TIV
		Date:	11-1-96
		Approved:	J. L. Vollmer
		Unit	mm
		C. I. Actuation	
		Stem Thread Verification	
		Drawn: 950317	