

USING THE PI TAPE

BEFORE STARTING:

****ENSURE MACHINE LOCK-OUT
PROCEDURES AND ALL SAFETY
REGULATIONS ARE FOLLOWED****



Clean threads thoroughly and determine if damage or excessive wear is present, which may need refurbishment by a machine shop, before verification.

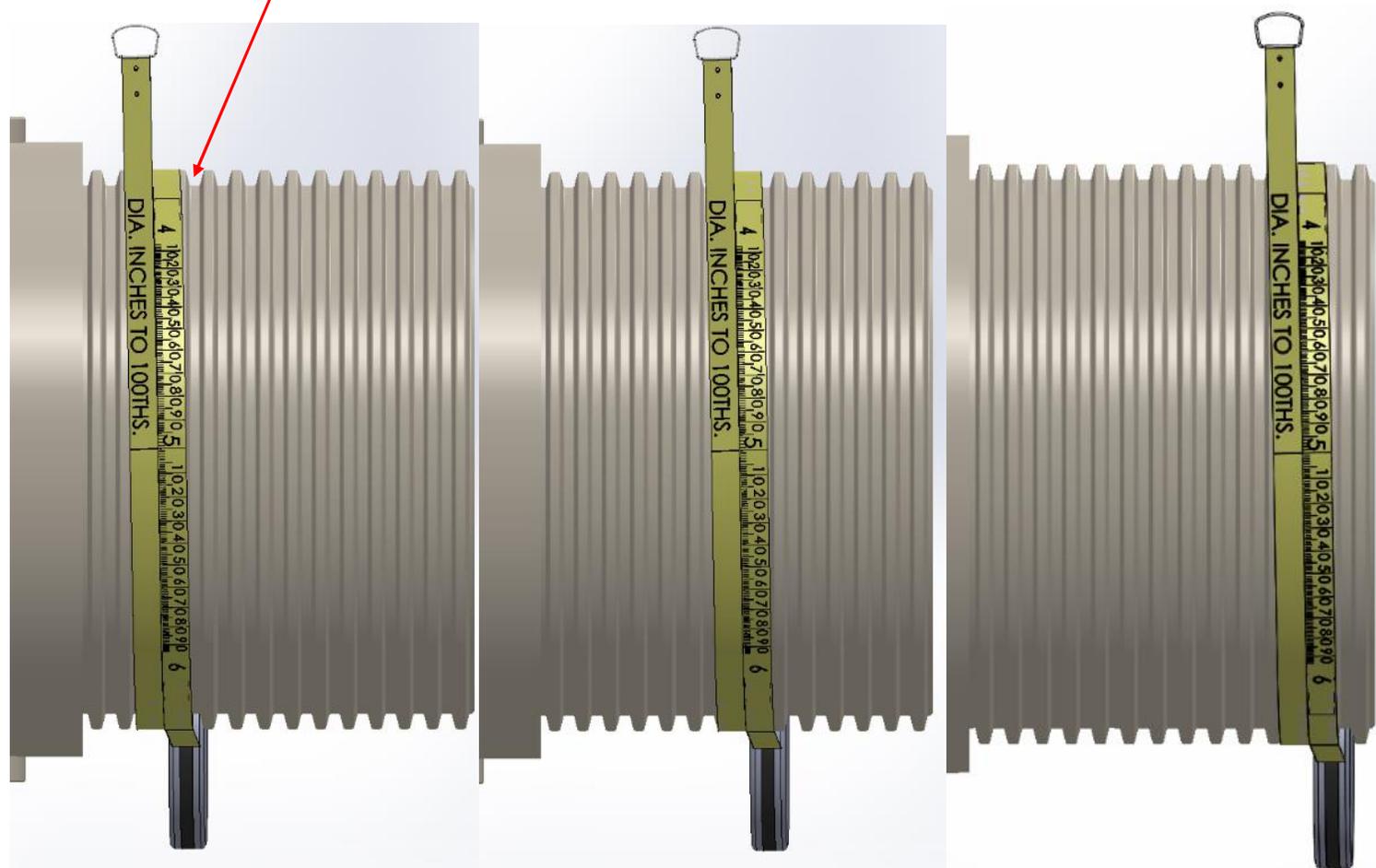
With good thread present, extend your Pi Tape to expose the side with DIA. INCHES TO 100THS. Grab the tape ring in your left hand and pull tape counter clock wise around the shaft that you wish to size.



Clean threads thoroughly and determine if damage or excessive wear is present, which may need refurbishment by a local machine shop, before verification.

Establish your diameter when the tapes edges are aligned, taunt around the shaft. Take measurements at 2 to 3 shaft locations, to insure best reading of size, in case of wear. NOTE: Ensure the tape is parallel, not in anyway on the thread walls. Greater care needs to be taken when TPI (threads per inch) are 6 or less.

Tape shouldn't slip onto thread wall



After we have ensured a good fit for our tape, a size can be determined, in this case as 5.00".

Now establish if your thread is right or Left hand

Your next step is to determine thread form type/ (ACAS, TRAS, UN) and the related pitch

