



Thread Trend® Thread Gaging System



The Thread Trend® Gaging System provides an effective and economical method for accurate thread measurement. Thread Trend is easy to use and maintain due to its simple and functional design.

The Thread Trend Gaging System provides measurement of pitch diameter, assembleability and other important thread features. Simply fit the Thread Trend Gage with a set of rolls and an indicating device. Roll sets are available in two styles—Full Form or Pitch Diameter (“cone & vee”)—and in two basic size “formats”—standard rolls or mini-rolls. Our original standard rolls accommodate 1/2" through 2-1/4" diameter pieces and threads from 6 to 32 pitch (inch series) and 1mm to 4mm (metric series). Our new mini-rolls enable the Thread Trend to be used for sizes as small as #4 (.112") UNC, UNF threads and 2.5mm diameter metric threads. Mini rolls provide a range of 24-48 pitch (inch series) and .45mm-1.00mm (metric series). Add an AGD dial indicator or a Fowler electronic indicator for applications where SPC is desired. (Reverse-reading indicators are preferred.) A Sylvac probe can be used for obtaining remote readout.

The Thread Trend System is ideal for setting up and monitoring thread production. Its simple design permits even unskilled personnel to obtain accurate readings. Rolls are adjusted with a standard micrometer or caliper—no templates or special tools are required for quick, precise set-ups.

The basic unit has a large adjustment range of .112" to 2 1/4" (2.5mm to 57mm). Thread Trend accepts any AGD dial indicator, electronic AGD indicator, Ultra-Logic probe or Sylvac probe (with an 8mm to 3/8" bushing).

Accepts any AGD Indicator , electronic indicator or Sylvac probe (using an 8mm to 3/8" bushing)





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Of the various methods for thread measurement available, no one method is “best”—different methods offer different advantages. However, we are confident you will find that the Thread Trend Gaging System offers many advantages and provides a superior method for getting the job done quickly, easily, economically and with optimum precision.

Special Features:

- Ideal for setting up and monitoring thread production.
- Simple design permits even unskilled personnel to obtain accurate readings.
- Large adjustment range: one gage measures from .112" through 2-1/4" (2.5mm through 57mm).
- Rolls may be adjusted with a standard micrometer or caliper—no templates or special tools are required.
- Accepts any AGD dial indicator or electronic indicator or Sylvac probe (using an 8mm to 3/8" bushing).
- Provides measurement of pitch diameter, assembleability, and other important thread features.
- Standard and mini-rolls—Full Form or Pitch Diameter (“cone & vee”)—plus special rolls are available.
- Controls quality of fit by detecting roundness irregularities.
- An electronic indicator makes the system ideal for linking to SPC systems.
- Ideal for special applications such as circlip grooves, plain outside diameter roundness and more.
- Screws for the rolls are recessed, allowing measurements to be accomplished close to the shoulder of a workpiece.
- Accurately measures pre-plated or post-plated threads.
- Simplified mechanism provides superior repeatability.
- Long-wearing steel rolls are hardened and deep-stabilized (hardened to 61-63RC).
- The three-roll design is ideal for pointing out imperfections in roundness due to lobing.
- The Thread Trend System is highly cost effective. Its unique design makes it less expensive than fixed limit gages and gages of similar design. No templates or special tooling is required for set-up, and the design features a built-in stand.
- Left or right hand threads are measured with the same rolls and the same setting (simply reverse the lower rolls).
- The Thread Trend Gaging System conforms to H-28, ANSI and other specifications for screw thread measuring.
- The price of the Thread Trend Gage includes a user manual and the required hardware for changing and adjusting rolls. (Not included: roll sets, indicator and master setting standards).

Full Form Rolls (Series #53-255 & 53-258): Roll sets listed under this series are full form contour rolls which provide a full measure of assemble-ability and are overall indicators of the status of a thread.

Pitch Diameter (Cone & Vee) Rolls (Series No. 53-260 & 53-265): The Pitch Diameter series utilizes thread rolls which have been ground to provide a truncated thread form for accurate measuring of the “pitch” diameter of a chosen thread. By isolating a single characteristic of a thread, data may be collected using any of our data collection devices—such as a GagePort. Data can be sent to a host computer (such as an IBM PC) and, with our “SPC Express” software or comparable program, data may be analyzed and maintained for permanent storage.

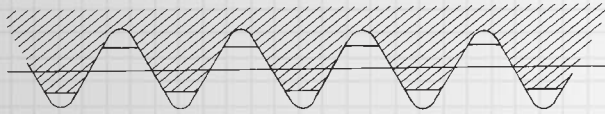
Differential Readings: By using both Full Form and Pitch Diameter rolls, “differential” readings may indicate problems with angle, lead, drunkenness, roundness, etc.

Additional Roll Styles: Special rolls are available to measure minor diameter, root diameter, lead error, concentricity of plain diameters, & roundness errors due to the lobing effect of thread rolling.

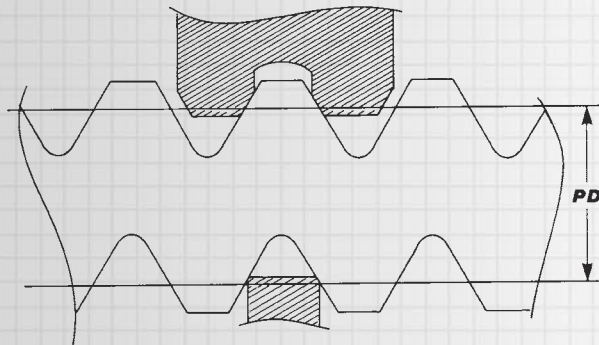
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▲ *Full Form Rolls (Series Nos. 53-255 and 53-258).*



▲ *Pitch Diameter Rolls (Series Nos. 53-260 and 53-265).*

Shaded area: thread gage roll. White area: thread "teeth."

To suit your thread measuring needs, Fowler offers standard roll sets in 2 different styles: "Full Form" rolls (Series No. 53-255 & No. 53-258) & "Pitch Diameter" rolls (Series No. 53-260 & No. 53-265). Available in standard or mini-rolls.

Order No.	Description
53-250-000	Thread Trend Gage with manual and hardware. Roll sets, setting master and indicator are not included.
Accessories:	
54-618-151	Sylvac Digital Indication Unit. (D100S)
54-618-140	Sylvac Display Unit (D-80).
54-618-400	Sylvac Standard Probe.
53-250-010	Backstop assembly—uses either an (AGD 3/8" stem) indicator or a simple rod.
Suggested Indicators:	
54-520-666	Electronic Ultra-Digit Mini Indicator
54-520-555	Sylvac Ultra-Digit Mark IV indicator

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Shop Tools

Order No.	Description
"Full Form" Roll Sets (3 rolls per set)	
Inch Series (for diameters 1/4" thru 2-1/4"):	
53-255-006	6 pitch
53-255-007	7 pitch
53-255-008	8 pitch
53-255-009	9 pitch
53-255-010	10 pitch
53-255-011	11 pitch
53-255-012	12 pitch
53-255-013	13 pitch
53-255-014	14 pitch
53-255-016	16 pitch
53-255-018	18 pitch
53-255-020	20 pitch
53-255-024	24 pitch
53-255-028	28 pitch
53-255-032	32 pitch
Metric Series (for diameters 6mm thru 57mm):	
53-255-001	1.00mm pitch
53-255-125	1.25mm pitch
53-255-150	1.50mm pitch
53-255-175	1.75mm pitch
53-255-200	2.00mm pitch
53-255-250	2.50mm pitch
53-255-300	3.00mm pitch
53-255-350	3.50mm pitch
53-255-400	4.00mm pitch
"Pitch Diameter" Roll Sets (3 rolls per set)	
Inch Series (for diameters 1/4" thru 2-1/4"):	
53-260-006	6 pitch
53-260-007	7 pitch
53-260-008	8 pitch
53-260-009	9 pitch
53-260-010	10 pitch
53-260-011	11 pitch
53-260-012	12 pitch
53-260-013	13 pitch
53-260-014	14 pitch
53-260-016	16 pitch
53-260-018	18 pitch
53-260-020	20 pitch
53-260-024	24 pitch
53-260-028	28 pitch
53-260-032	32 pitch

Order No.	Description
Metric Series (for diameters 6mm thru 57mm):	
53-260-001	1.00mm pitch
53-260-125	1.25mm pitch
53-260-150	1.50mm pitch
53-260-175	1.75mm pitch
53-260-200	2.00mm pitch
53-260-250	2.50mm pitch
53-260-300	3.00mm pitch
53-260-350	3.50mm pitch
53-260-400	4.00mm pitch
"Mini Full Form" Thread Roll Sets (3 rolls per set).	
Inch Series (for diameters #4 thru 1/4"):	
53-258-024	24 pitch
53-258-028	28 pitch
53-258-032	32 pitch
53-258-036	36 pitch
53-258-040	40 pitch
53-258-044	44 pitch
53-258-048	48 pitch
Metric Series (for diameters 2.5mm thru 6mm):	
53-258-045	.45mm pitch
53-258-050	.50mm pitch
53-258-060	.60mm pitch
53-258-070	.70mm pitch
53-258-075	.75mm pitch
53-258-080	.80mm pitch
53-258-100	1.00mm pitch
"Mini Pitch Diameter" Thread Roll Sets (3 rolls per set).	
Inch Series (for diameters #4 thru 1/4"):	
53-265-024	24 pitch
53-265-028	28 pitch
53-265-032	32 pitch
53-265-036	36 pitch
53-265-040	40 pitch
53-265-044	44 pitch
53-265-048	48 pitch
Metric Series (for diameters 2.5mm thru 6mm):	
53-265-045	.45mm pitch
53-265-050	.50mm pitch
53-265-060	.60mm pitch
53-265-070	.70mm pitch
53-265-075	.75mm pitch
53-265-080	.80mm pitch
53-265-100	1.00mm pitch