

# DEPTH

thread  
depth



thread  
depth

# COMBI THREAD/DEPTH PLUG GAGES - INCH

## COMBI STANDARD



Scale = 0.025"/division (Max. thread depth resolution is 1/2 division = 0.012")

## COMBI HI-RESOLUTION



Scale = 0.050"/division Vernier = 0.005" resolution per division for thread depth

The **COMBI** and **COMBI HI-RESOLUTION** Gage  
Check functional thread size & thread depth in one operation!

CLASS 2B or 3B STEEL  
X TOLERANCE

SIZE	THRDS PER INCH			HANDLE SIZE	STANDARD MEASURING DEPTH	GO / NG MEMBERS ONLY	STANDARD 0.025" / DIVISION		HI-RESOLUTION 0.005" / DIVISION	
	UNC	UNF	UNEF				STANDARD COMBI HDL ONLY	STANDARD COMPLETE GAGE	HI-RESOLUTION COMBI HANDLE ONLY	HI-RESOLUTION COMPLETE GAGE
2 (.086)	56	64		200	.400"	\$61.00	\$278.00	\$400.00	\$441.00	\$563.00
3 (.099)	48	56			.400"	55.00	278.00	388.00	441.00	551.00
4 (.112)	40	48			.550"	55.00	278.00	388.00	441.00	551.00
5 (.125)	40	44			.550"	53.00	278.00	384.00	441.00	547.00
6 (.138)	32	40			.550"	51.00	278.00	380.00	441.00	543.00
8 (.164)	32	36			300	.975"	51.00	273.00	375.00	441.00
10 (.190)	24	32		.975"		51.00	273.00	375.00	441.00	543.00
12 (.216)	24	28		.975"		53.00	273.00	379.00	441.00	547.00
12 (.216)			32	.975"		88.00	273.00	449.00	441.00	617.00
1/4 (.250)	20	28		1.00"		43.00	273.00	359.00	441.00	527.00
1/4 (.250)			32	1.00"		85.00	273.00	443.00	441.00	611.00
5/16 (.3125)	18	24		400	1.60"	47.00	348.00	442.00	555.00	649.00
5/16 (.3125)			32		1.60"	86.00	348.00	520.00	555.00	727.00
3/8 (.375)	16	24			1.60"	47.00	348.00	442.00	555.00	649.00
3/8 (.375)			32		1.60"	98.00	348.00	544.00	555.00	751.00
7/16 (.4375)	14	20			1.60"	47.00	348.00	442.00	555.00	649.00
7/16 (.4375)			28		1.60"	100.00	348.00	548.00	555.00	755.00
1/2 (.500)	13	20		500	2.00"	51.00	366.00	468.00	569.00	671.00
1/2 (.500)			28		2.00"	103.00	366.00	572.00	569.00	775.00
9/16 (.5625)	12	18			2.00"	61.00	366.00	488.00	569.00	691.00
9/16 (.5625)			24		2.00"	108.00	366.00	582.00	569.00	785.00
5/8 (.625)	11	18			2.35"	61.00	366.00	488.00	569.00	691.00
5/8 (.625)			24		2.35"	108.00	366.00	582.00	569.00	785.00
11/16 (.6875)			24	600	3.20"	112.00	624.00	848.00	882.00	1,106.00
3/4 (.750)	10	16			3.20"	77.00	624.00	778.00	882.00	1,036.00
3/4 (.750)			20		3.20"	120.00	624.00	864.00	882.00	1,122.00
13/16 (.8125)			20		3.20"	126.00	624.00	876.00	882.00	1,134.00
7/8 (.875)	9	14			3.20"	78.00	624.00	780.00	882.00	1,038.00
7/8 (.875)			20		3.20"	126.00	624.00	876.00	882.00	1,134.00
Up to 1-5/16	CALL FOR PRICING AND AVAILABILITY								CALL FOR PRICING AND AVAILABILITY	

CHROME PLATED MEMBERS: ADD 50% TO LIST PRICE. \***TIALN MEMBERS**: MULTIPLY LIST PRICE BY 3.25  
LONG FORM CERTIFICATION \$20 PER MEMBER.

EFFECTIVE 1/1/17  
REV 1.1

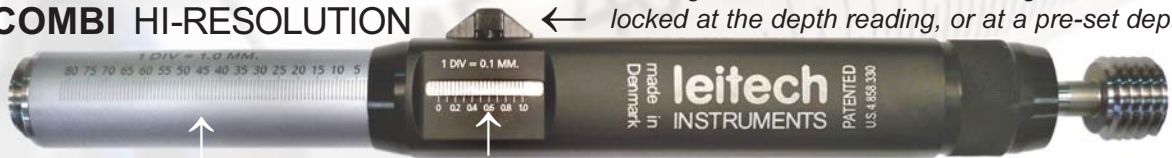
# COMBI THREAD/DEPTH PLUG GAGES - METRIC

## COMBI STANDARD



Scale = 0.5 mm/division (Max. thread depth resolution is 1/2 division = 0.25 mm)

## COMBI HI-RESOLUTION



Scale = 1.0 mm/division Vernier = 0.1 mm resolution for thread depth

Locking device allows the measuring sleeve to be locked at the depth reading, or at a pre-set depth

The COMBI and COMBI HI-RESOLUTION Gage  
Check functional thread size & thread depth in one operation!

STEEL  
6H TOLERANCE

METRIC SIZE AND PITCH	HANDLE SIZE	STANDARD MEASURING DEPTH	GO / NG MEMBERS ONLY	STANDARD 0.5 mm / DIVISION		HI-RESOLUTION 0.1 mm / DIVISION	
				STANDARD COMBI HANDLE ONLY	STANDARD COMPLETE GAGE	HI-RESOLUTION COMBI HANDLE ONLY	HI-RESOLUTION COMPLETE GAGE
M2 x 0,4	200	12.0 mm	\$80.00	\$278.00	\$438.00	\$441.00	\$601.00
M2,5 x 0,45		12.0 mm	73.00	278.00	424.00	441.00	587.00
M3 x 0,5		12.0 mm	73.00	278.00	424.00	441.00	587.00
M3,5 x 0,6		12.0 mm	62.00	278.00	402.00	441.00	565.00
M4 x 0,7	300	23.5 mm	62.00	273.00	397.00	441.00	565.00
M5 x 0,8		25.0 mm	62.00	273.00	397.00	441.00	565.00
M6 x 1,0		28.0 mm	55.00	273.00	383.00	441.00	551.00
M7 x 1,0	400	42.0 mm	53.00	348.00	454.00	555.00	661.00
M8 x 1,25		42.0 mm	53.00	348.00	454.00	555.00	661.00
M8 x 1,0		42.0 mm	53.00	348.00	454.00	555.00	661.00
M9 x 1,25		42.0 mm	56.00	348.00	460.00	555.00	667.00
M10 x 1,5		49.0 mm	56.00	348.00	460.00	555.00	667.00
M10 x 1,25		49.0 mm	56.00	348.00	460.00	555.00	667.00
M10 x 1,0		49.0 mm	75.00	348.00	498.00	555.00	705.00
M10 x 0,75		49.0 mm	56.00	348.00	460.00	555.00	667.00
M11 x 1,5		49.0 mm	58.00	348.00	464.00	555.00	671.00
M12 x 1,75		49.0 mm	58.00	348.00	464.00	555.00	671.00
M12 x 1,5		49.0 mm	58.00	348.00	464.00	555.00	671.00
M12 x 1,25		49.0 mm	58.00	348.00	464.00	555.00	671.00
M12 x 1,0	49.0 mm	79.00	348.00	506.00	555.00	713.00	
M14 x 2,0	500	59.0 mm	66.00	366.00	498.00	569.00	701.00
M14 x 1,5		59.0 mm	66.00	366.00	498.00	569.00	701.00
M15 x 1,5		59.0 mm	72.00	366.00	510.00	569.00	713.00
M15 x 1,0		59.0 mm	72.00	366.00	510.00	569.00	713.00
M16 x 2,0		59.0 mm	67.00	366.00	500.00	569.00	703.00
M16 x 1,5		59.0 mm	67.00	366.00	500.00	569.00	703.00
M16 x 1,0	59.0 mm	94.00	366.00	554.00	569.00	757.00	
M17 x 1,5	600	86.0 mm	78.00	624.00	780.00	882.00	1,038.00
M17 x 1,0		86.0 mm	78.00	624.00	780.00	882.00	1,038.00
M18 x 2,5		86.0 mm	84.00	624.00	792.00	882.00	1,050.00
M18 x 1,5		86.0 mm	84.00	624.00	792.00	882.00	1,050.00
M20 x 2,5		86.0 mm	92.00	624.00	808.00	882.00	1,066.00
M20 x 1,5		86.0 mm	92.00	624.00	808.00	882.00	1,066.00
M20 x 1,0		86.0 mm	91.00	624.00	806.00	882.00	1,064.00
M22 x 2,5		86.0 mm	94.00	624.00	812.00	882.00	1,070.00
M22 x 1,5		86.0 mm	94.00	624.00	812.00	882.00	1,070.00
Up to M33		CALL FOR PRICING AND AVAILABILITY				CALL FOR PRICING AND AVAILABILITY	

CHROME PLATED MEMBERS: ADD 50% TO LIST PRICE. \*TIALN MEMBERS: MULTIPLY LIST PRICE BY 3.25  
LONG FORM CERTIFICATION \$20 PER MEMBER.

# COMBI HELICAL COIL (STI) THREAD PLUG GAGES

## COMBI STANDARD



Scale = 0.025"/division (Max. thread depth resolution is 1/2 division = 0.012")

## COMBI HI-RESOLUTION



Scale = 0.050"/division Vernier = 0.005" resolution per division for thread depth

The **COMBI** and **COMBI HI-RESOLUTION** Gage  
Check functional thread size & thread depth in one operation!

STEEL	X TOLERANCE	STANDARD 0.025" DIVISIONS						HI-RESOLUTION 0.005" DIVISIONS			
		HDL SIZE	MEAS DEPTH	MEMBERS ONLY		STAND. COMBI HANDLE	STANDARD COMPLETE GAGE		HI-RES COMBI HANDLE	HI-RESOLUTION COMPLETE GAGE	
				GO & 2B NG	3B NG		2B	3B		2B	3B
2 (.086)-56 UNC	200	.400"	\$84.00	\$93.00	\$278.00	\$446.00	\$455.00	\$441.00	\$609.00	\$618.00	
4 (.112)-40 UNC	300	.780"	72.00	88.00	273.00	417.00	433.00	441.00	585.00	601.00	
6 (.138)-32 UNC		.780"	79.00	85.00	273.00	431.00	437.00	441.00	599.00	605.00	
8 (.164)-32 UNC		.840"	79.00	85.00	273.00	431.00	437.00	441.00	599.00	605.00	
10 (.190)-24 UNC		.840"	75.00	83.00	273.00	423.00	431.00	441.00	591.00	599.00	
10 (.190)-32 UNF		.840"	75.00	83.00	273.00	423.00	431.00	441.00	591.00	599.00	
1/4 (.250)-20 UNC	400	1.50"	67.00	76.00	348.00	482.00	491.00	555.00	689.00	698.00	
1/4 (.250)-28 UNF		1.50"	67.00	76.00	348.00	482.00	491.00	555.00	689.00	698.00	
5/16 (.3125)-18 UNC		1.50"	71.00	78.00	348.00	490.00	497.00	555.00	697.00	704.00	
5/16 (.3125)-24 UNF		1.50"	71.00	78.00	348.00	490.00	497.00	555.00	697.00	704.00	
3/8 (.375)-16 UNC		1.54"	71.00	78.00	348.00	490.00	497.00	555.00	697.00	704.00	
3/8 (.375)-24 UNF		1.54"	71.00	78.00	348.00	490.00	497.00	555.00	697.00	704.00	
7/16 (.4375)-14 UNC	500	2.00"	71.00	79.00	366.00	508.00	516.00	569.00	711.00	719.00	
7/16 (.4375)-20 UNF		2.00"	71.00	79.00	366.00	508.00	516.00	569.00	711.00	719.00	
1/2 (.500)-13 UNC		2.00"	74.00	83.00	366.00	514.00	523.00	569.00	717.00	726.00	
1/2 (.500)-20 UNF		2.00"	74.00	83.00	366.00	514.00	523.00	569.00	717.00	726.00	

FOR GAGES TO MIL-T-21309E ADD 25% TO THE ABOVE PRICES.  
FOR CHROME PLATED MEMBERS: ADD 50% TO LIST PRICE.  
LONG FORM CERTIFICATION \$20 PER MEMBER.

# COMBI TAPER PIPE THREAD PLUG GAGES

## COMBI STANDARD



Scale = 0.025"/division (Max. thread depth resolution is 1/2 division = 0.012")

## COMBI HI-RESOLUTION



Scale = 0.050"/division Vernier = 0.005" resolution per division for thread depth

The **COMBI** and **COMBI HI-RESOLUTION** Gage  
Check functional thread size & thread depth in one operation!

MEMBERS SUPPLIED WITH BASIC NOTCH	SIZE	HDL SIZE	STANDARD 0.025" DIVISIONS						HI-RESOLUTION 0.005" DIVISIONS		
			REPLACEMENT MEMBERS			STANDARD COMPLETE GAGE			HI-RESOLUTION COMPLETE GAGE		
			NPT	NPTF PLUGS		NPT	NPTF		NPT	NPTF	
L1 OR L3	6-STEP PLAIN	L1 or L3		6-STEP PLAIN	L1 or L3		6-STEP PLAIN				
1/16 (.0625)-27	400	\$144.00	\$151.00	\$183.00	\$492.00	\$499.00	\$531.00	\$699.00	\$706.00	\$738.00	
1/8 (.125)-27		120.00	130.00	183.00	468.00	478.00	531.00	675.00	685.00	738.00	
1/4 (.250)-18	500	130.00	141.00	187.00	496.00	507.00	561.00	699.00	710.00	756.00	
3/8 (.375)-18	600	141.00	163.00	195.00	765.00	787.00	819.00	1,023.00	1,045.00	1,077.00	
1/2 (.500)-14		151.00	206.00	199.00	775.00	830.00	823.00	1,033.00	1,088.00	1,081.00	

LONG FORM CERTIFICATION FOR PIPE THREAD MEMBERS \$55

# COMBI CYLINDRICAL PLUG/DEPTH GAGES - INCH + METRIC

## COMBI STANDARD



Scale = 0.025" / 0.5 mm (Max. thread depth resolution is 1/2 division = 0.012" / 0.25 mm)

## COMBI HI-RESOLUTION



Scale = 0.050" / 1.0 mm per division Vernier = 0.005" / 0.1 mm resolution per division for thread depth

Locking device allows the measuring sleeve to be locked at the depth reading, or at a pre-set depth

The COMBI and COMBI HI-RESOLUTION Gage  
Check functional size & depth in one operation!

Quantity discount: **MEMBERS ONLY**

Same size & class: 2 pc. -10%...3 or more pc. - 15%

**STANDARD** 0.025" or 0.5mm DIVISIONS **HI-RESOLUTION** 0.005" or 0.1mm DIVISIONS

SIZE RANGE	MEAS DEPTH	HDL	CLASS	MEMBER ONLY		STANDARD COMBI HDL ONLY	STANDARD COMPLETE GAGE	HI-RES COMBI HDL ONLY	HI-RES COMPLETE GAGE		
				GO	NO GO						
.080" - .138" 2.00mm - 3.50mm	.400" 10.0mm	200	XX	\$121.00	\$110.00	\$278.00	\$509.00	\$441.00	\$672.00		
			X	112.00	98.00					488.00	651.00
			Y or Z	86.00	79.00					443.00	606.00
.138" - .250" 3.50mm - 6.35mm	.900" 20.0mm	300	XX	116.00	104.00	273.00	493.00	441.00	661.00		
			X	105.00	94.00					472.00	640.00
			Y or Z	81.00	74.00					428.00	596.00
.250" - .470" 6.35mm - 12.00mm	1.55" 41.0mm	400	XX	128.00	115.00	348.00	591.00	555.00	798.00		
			X	116.00	104.00					568.00	775.00
			Y or Z	88.00	83.00					519.00	726.00
.470" - .625" 12.00mm - 16.00mm	2.00" 51.0mm	500	XX	128.00	116.00	366.00	591.00	569.00	813.00		
			X	118.00	99.00					583.00	786.00
			Y or Z	94.00	85.00					545.00	748.00
.625" - .874" 16.00mm - 22.00mm	3.00" 75.0mm	600	XX	142.00	139.00	624.00	905.00	882.00	1163.00		
			X	132.00	130.00					886.00	1144.00
			Y or Z	128.00	125.00					877.00	1135.00
UPTO 1-5/16" UPTO 33mm	CALL FOR PRICING AND AVAILABILITY							CALL FOR PRICING AND AVAILABILITY			

FOR CHROME PLATED MEMBERS: ADD 50% TO LIST PRICE.  
LONG FORM CERTIFICATION \$20 PER MEMBER.

## COMBI CALIBRATION MASTER

Calibrate your **COMBI** Gage for depth with the **leitech Calibration Master**. Simply dial in the thread pitch on the master, and calibrate the depth measuring scale.\*

Inch.....\$400.00  
Metric.....\$400.00

Long Form Certification for the **leitech** Calibration Master.....\$195.00



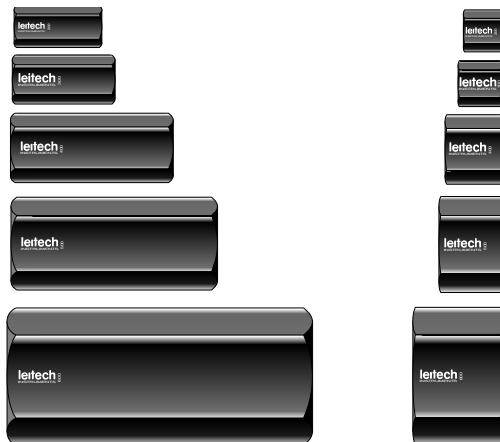
\*For complete depth calibration procedure, see page 6

## COMBI MEMBER REMOVAL SLEEVES

For the removal of GO / NOT GO thread gage members from **COMBI** handles.

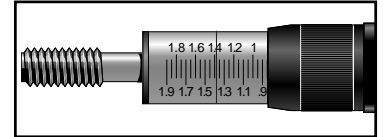
**COMBI Member Removal Sleeve Kit**  
Includes sleeves for all handle sizes.....\$168.00/Kit

<b>COMBI Member Removal Sleeves</b>	
#200 Handle.....	\$27.00/Set
#300 " .....	31.00/Set
#400 " .....	39.00/Set
#500 " .....	44.00/Set
#600 " .....	57.00/Set

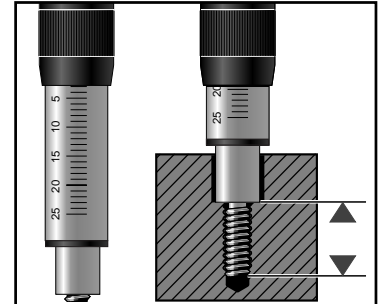


## COMBI SPECIAL PRODUCTS

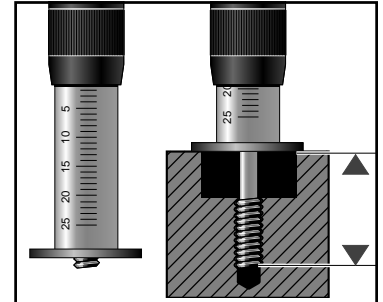
**COMBI** gages can be modified for your special requirements. Examples include the following: custom etched depth lines, extended measuring depth for extra reach, modified bushings to seat in or clear chamfers, oversized bushings to span counterbores, special size pitch diameters or thread forms, and gages larger than our standard 7/8" or 22.0mm. Other applications quoted per your request.



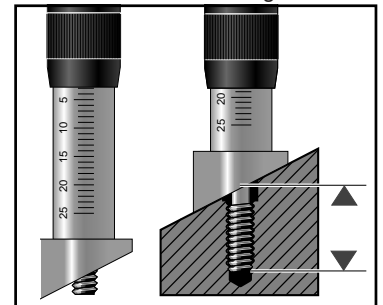
Custom etched depth lines



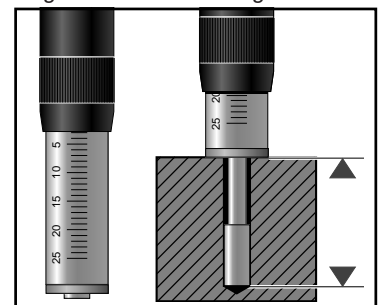
Reduced sleeve bushing



Oversize sleeve bushing



Angled sleeve bushing



Plain plug gage for drill depth or minor diameter checks. See page 5 for COMBI cylindrical prices.



Tapered sleeve bushing

Extended measuring depth

# DEPTH CALIBRATION PROCEDURE: COMBI AND COMBI HI-RESOLUTION GAGES

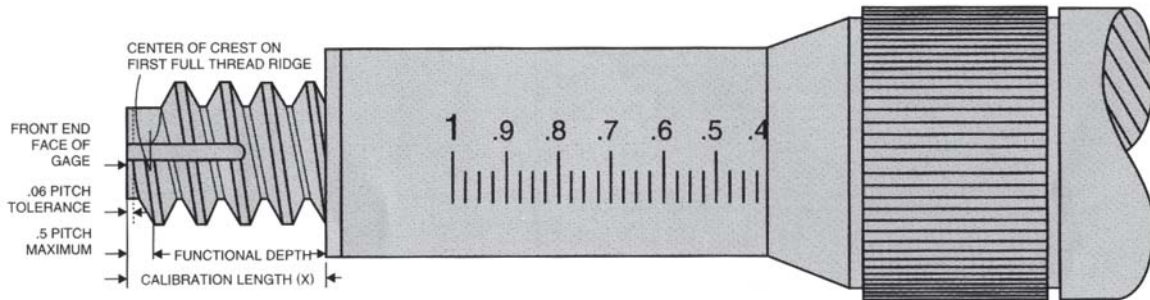
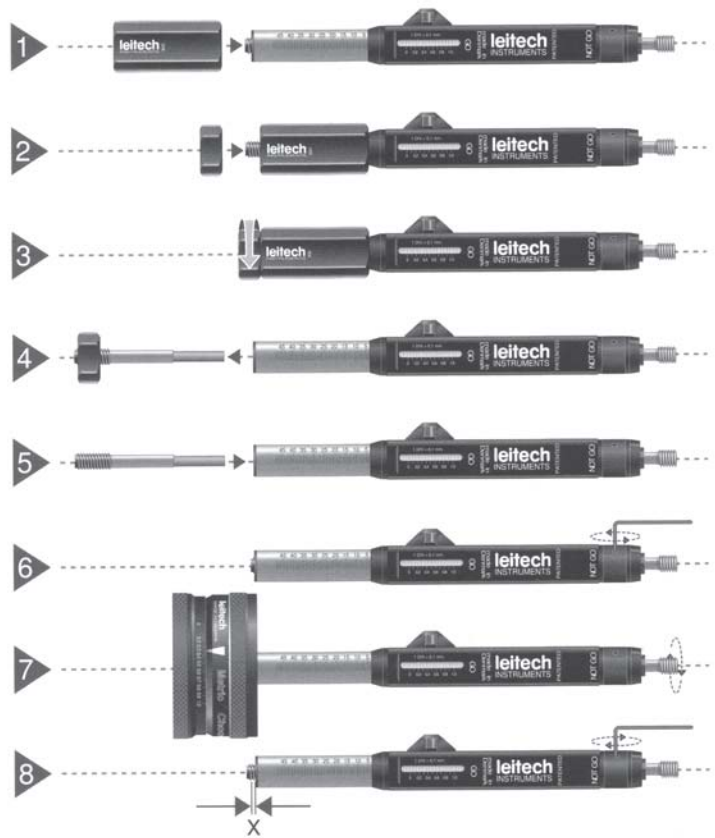
leitech COMBI gage members are made to a special taperlock design, and are easily changed with **COMBI Member Removal Sleeves**, a **COMBI Calibration Master**, and a nut of the correct size (*available from customer inventories*).

1. Slide the **Member Removal Sleeve** over the gage member to be replaced. (Green/GO & Red/NOT GO)
2. Thread the nut (supplied by the user) on to the gage member.
3. Tighten the nut against the **Member Removal Sleeve**.
4. Wrench the gage member from the handle.
5. Insert the new gage member. Tap against a soft surface to seat the gage member into the handle.
6. Loosen the two locking screws on the handle with an allen wrench.
7. Dial the pitch on the **Calibration Master**. Place the GO end of the gage into the appropriate size hole. Grasp and turn the NOT GO member and line up the **COMBI** gage measuring scale at the .400" (inch) or 10.00 mm (metric) line.

(As an alternative, assemble a gage block stack corresponding to the calibration length (X) in the chart below. In this procedure, the face of the measuring sleeve should rest on the block stack and the face of the GO member should rest on a reference plane.)

8. Re-tighten the locking screws **finger tight**. The **COMBI** gage is now set at the correct calibration length (X) for accurate functional thread depth measurement.

**Note:** The measuring sleeve is set a few threads back from the face of the GO member to permit easier entry into the product thread.



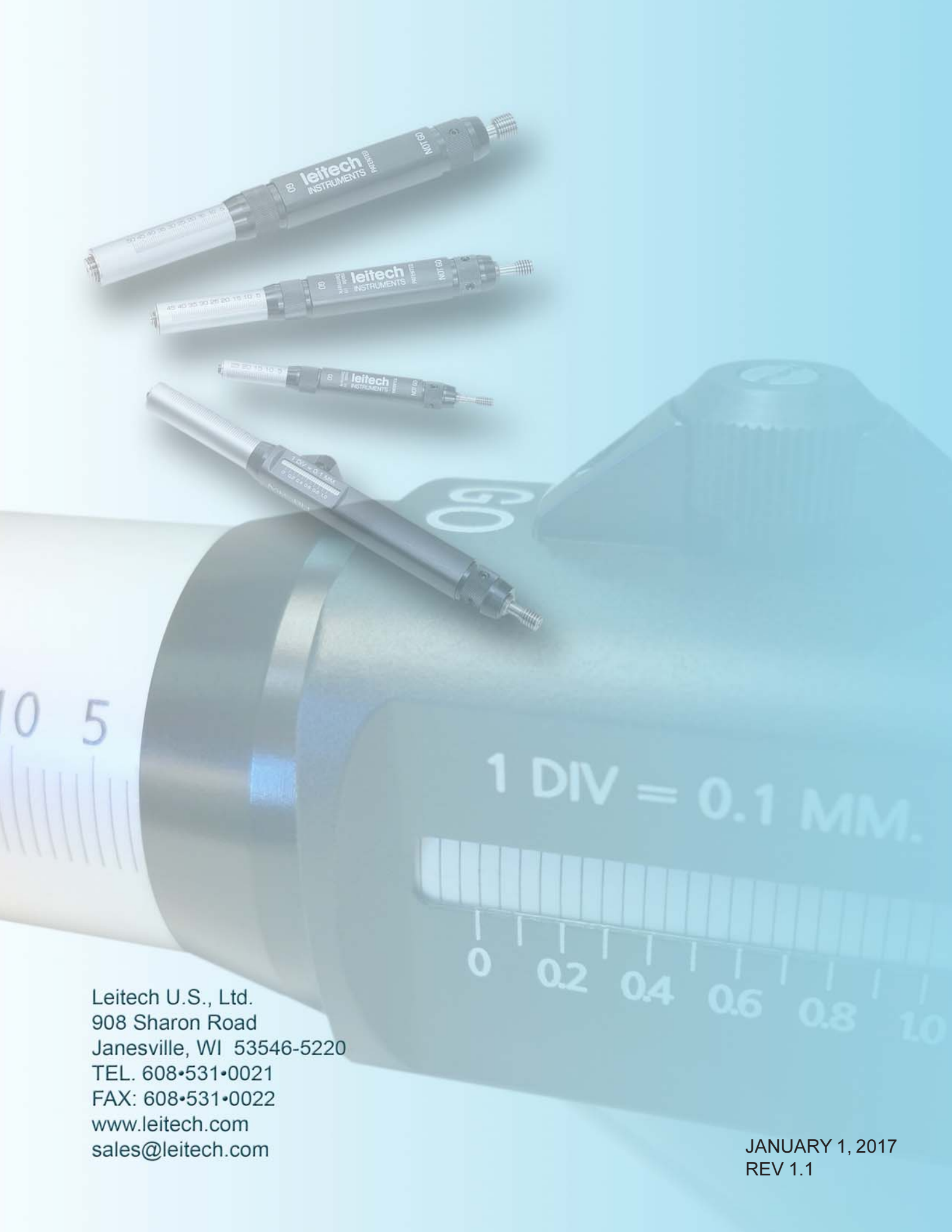
INCH		METRIC	
PITCH	CALIBRATION LENGTH (X)	PITCH	CALIBRATION LENGTH (X)
64	.408 in.	0,00 mm	10,00 mm
56	.409 in.	0,20 mm	10,10 mm
48	.410 in.	0,30 mm	10,15 mm
44	.411 in.	0,40 mm	10,20 mm
40	.412 in.	0,45 mm	10,22 mm
36	.414 in.	0,50 mm	10,25 mm
32	.416 in.	0,60 mm	10,30 mm
28	.418 in.	0,70 mm	10,35 mm
24	.421 in.	0,75 mm	10,38 mm
20	.425 in.	0,80 mm	10,40 mm
18	.428 in.	0,90 mm	10,45 mm
16	.431 in.	1,00 mm	10,50 mm
14	.436 in.	1,25 mm	10,62 mm
13	.438 in.	1,50 mm	10,75 mm
12	.442 in.	1,75 mm	10,88 mm
11	.445 in.	2,00 mm	11,00 mm
10	.450 in.	2,50 mm	11,25 mm
9	.456 in.	3,00 mm	11,50 mm
8	.463 in.		

Values from the table are calculated by the formula:

$$\text{Inch calibration length (X)} = .400 \text{ in.} + \left[ .50 \times \frac{1}{\text{pitch}} \right]$$

$$\text{Metric calibration length (X)} = 10,0 \text{ mm.} + [ .50 \times \text{pitch} ]$$

This method will provide conformance to FED-STD-H28, Sec.6A. The crest of the first full thread of all Leitech GO thread members is held to a 0.5 pitch, plus 0 minus .06 pitch tolerance from the front face of the thread member.



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