

Buttress Runout Gage Thread Runout

BR-2001 Series



**BR-2001 Series
Buttress Runout Gage**



Checks Runout Thread

The BR-2001 Buttress runout gage insures proper thread pullout on runout type threads. Thread runout is the measurement of the abruptness with which the buttress thread is terminated at the triangle end of the thread. A rapid pull-out of the cutting tool results in steep slope at the end of the thread. This causes high stress at the contact point when the coupling is made-up.

The run out gage is a three point gage having two fixed points and one movable point attached to a balanced dial indicator. Accuracy of the gage is verified by zeroing the dial indicator on a flat surface. If the indicator does not read zero, the dial is adjusted by unscrewing the thumb screw, turning dial to zero and tightening the thumb screw. The gage zero should be verified after tightening the thumb screw.

Two possible thread runout conditions can occur; (1) before the base of the triangle (near the pin end) and (2) within or beyond the apex of the triangle.

If the thread terminates before the base of the triangle the movable pointer is placed in the last thread groove 90° prior to the thread termination and the gage rotated clockwise until the pointer exits the thread groove and rides on the pipe surface. If the thread terminates within the triangle, the movable pointer is placed in the thread groove 90° prior to the thread termination or the apex of the triangle, whichever occurs first. The gage is rotated clockwise until the point either exits the thread or passes the triangle apex.




If the thread terminates beyond the apex, place the movable pointer in the thread groove 90° prior to the apex, and rotate the gage clockwise until the pointer passes the triangle apex. The runout is satisfactory if the dial indicator does not exceed +0.005" during the traverse of the thread groove. A dial indicator reading in excess of +.005" is not acceptable. All readings, including negative readings, 0.005" and less are acceptable.

A runout measurement of the coupling is not required since the thread is continuous as it exits.

Features

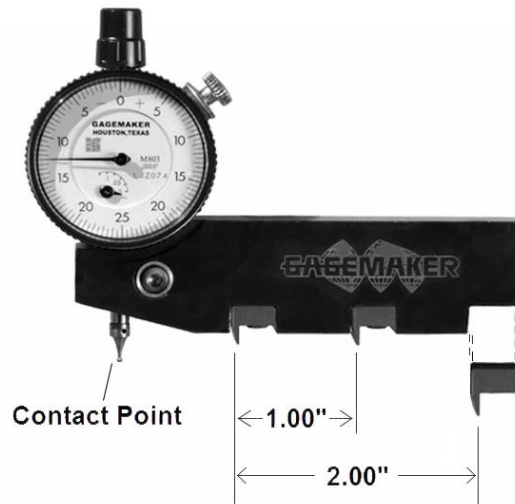
- Inspects external Buttress threads for proper runout thread.
- Replaceable interchangeable contacts.

BR-2001 Buttress Runout Gage

Model	Description	Range
BR-2001		Standard 1" and 2" spacing
BRB-2001		Standard 1" and 2" spacing
BRS-2001		-

The following diagrams display the proper setup and operation for the buttress runout gage, the BR-2001. The BR-2001 ensures proper location pullout of the threading tool during the threading process.

1. The blade contacts are removable and maybe relocated to achieve a 1.00" or a 2.00" distance between them. Arrange the blade contacts so that the blades fall into the perfect thread area of the connection. Connections that have fewer threads may require the 1.00" spacing.
2. Preset the gage by placing the gage vertically on a flat surface with the contact blades pointed down. The indicator contact point should be in contact with the surface.
3. Rotate the bezel to align the zero with the indicator needle. Tighten the bezel clamp.
4. Place the gage on the threaded connector as shown below. Ensure that the contact point is seated in the root of the last imperfect thread.
5. With the gage seated in the thread, sweep the gage around the part to indicate any deviation in the imperfect thread root.
6. Record the deviation on the proper inspection report form.



Point Seated in the Last Thread