Female Acme NoGo(Low Limit)Plug Gauge Instruction Sheet

1-1/4" – 3-1/4" Female Acme NoGo(Low Limit)Plug Gauges

NoGo Plug Gauges are intended for use with female acme threads only.

* It is recommended that this service procedure be conducted at a minimum of every six months or as necessary depending on conditions and the frequency by which the fittings are used.

Warning: Acme Thread NoGo Gauges are set to exact tolerances and must not be mishandled or dropped as this will impact their accuracy.

Step I
Remove hose assembly from system and ensure no pressure/gas is trapped in the assembly before proceeding to step II. Failure to follow these instructions could result in an explosion and/or fire, causing property damage and personal injury or death.

Step II
Remove acme filler coupling from hose using the appropriate tools/pipe wrench , being careful to minimize damage to the fitting. Carefully remove the retaining clip (if present)located behind the rear portion of the female acme nut by sliding it past the male pipe thread end of the filler coupling nipple. Next remove the female acme nut from the filler coupling nipple. Once disassembled, be sure to inspect all components, including the sealing surface on the face of the filler nipple, for any visible defects or damage prior to gauging. If visible defects exist skip to step V and replace acme filler coupling.

Step III
Align the NoGo Plug Gauge with the female acme thread by putting the threaded portion of the gauge toward the female acme filler nut. Start the gauge thread by rotating the gauge counter-clockwise ¼ of a turn to align the gauge with lead female acme thread. Once lead thread has aligned itself into the gauge, rotate gauge clock-wise until the gauge will no longer thread into the part. **Do not** use any tools or devices to tighten gauge into acme filler nut, plug gauges are intended for hand tightening only!

Step IV
Once the gauge has been fully engaged into the female acme thread, you can judge the level of wear. A new acme filler nut will travel approximately ¼ to 1 full turn onto the NoGo Plug Gauge. This is an acceptable range for a new filler coupling. A filler coupling has become too worn (out of tolerance) and must be replaced immediately when the NoGo Plug Gauge travels the full length of the thread stopping at or near the bottom of the female acme filler nut.

Step V
If the female acme nut is determined to be acceptable, reassemble the filler nipple to the female acme nut and replace the acme nut retaining ring (if present) to its original installation groove, located on the fill nipple body behind the female acme filler nut. If the female acme nut is determined to be worn out of tolerance replace using quality MEC acme filler couplings.

Install, operate, and maintain Marshall Excelsior Co. equipment in accordance with federal, state, and local codes, and these instructions. The installation in most states must also comply with NFPA #58, ANSI K61.1 and DOT standards.

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