



# The Gage

FALL 2011

*American Measuring Tool Manufacturers Association*

## President's Message

Barb Bishop, North American Tool Corporation

Look at Some of the Ways AMTMA Can Help Your Business and You:

- *Network Among Your Peers & Keep Abreast of Industry Trends*
- *AMTMA annual meetings*
- *Technical Services, Including Round Robin Programs and Educational Workshops.*
- *Business Surveys*
- *Regulatory Support*
- *Human Resources Support*



Our spring meeting for 2011 was held in Washington D.C. / Virginia area. We toured N.I.S.T. and were surprised at the security and updated equipment that they have there (those who attended know what I mean). Special thanks to John and Blain Mead for their help in suggesting the Lansdowne Resort where we stayed. Next spring we will be in Scottsdale, AZ. At the Chaparral Suites on March 21-23, 2012. We are looking at doing a side trip for a hot air balloon ride with a sunrise breakfast for those early risers. More information will follow. Please watch the website for updates. I am also in the process of arranging the site for 2013 which will be our 40<sup>th</sup> year. If you have a location you wish to visit or have ideas for programs do not hesitate to contact myself or any board member or the AMTMA office.

The association is currently celebrating its 38<sup>th</sup> year anniversary. Where were you 38 years ago? Some of us have difficulty remembering back that far while others were not even in existence. The sale goes for business. Through turbulent times we have persevered and continue to grow. I am honored to be part of this organization as I myself continue to grow. I have worked for one of the original founding fathers and have been blessed with great mentors. Keep in mind as you grow your business to mentor the young people around you. They are the future and we need them! Also consider bringing them with you to a meeting. Our information is there to be shared and what better way than to hear it first-hand. This is a sure way of keeping your company "upfront" and your employees involved. Please take time to look around you to see who could profit from our knowledge and experience.

Many organizations are going through trying times with dwindling membership and we are not untouched. You will only get out what you put in. I am calling on all members to stay involved! This is **your** organization and our success is based on commitment from the board and its members. Let your peers and business associates know the benefits you achieve through membership.

Respectfully,

Barb Bishop

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## New AMTMA officers for 2011 / 2012

President: Barb Bishop, North American Tool Corp.  
Vice President: Steve Pike, Mitutoyo America Corp.  
Secretary: Blain Mead, Master Gage and Tool Co.

## New Board Members

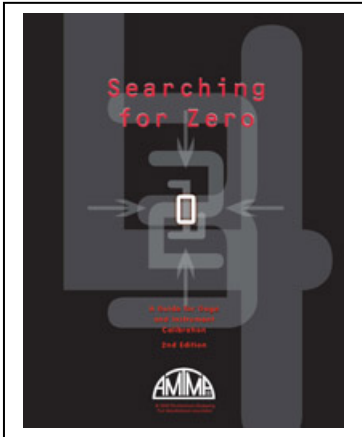
Congratulations to the following three members elected to serve on the AMTMA board of directors for the next three years:

John Gehret - Vermont Thread Gage LLC  
Mark Fridman - Mark-10 Corporation  
Larry McLaughlin - Greenslade & Company

Thanks to the following members coming off the Board for all their efforts for the past three years:

Bill Fridman – Mark-10 Corporation  
Mike Hope - Hemco Gage Corporation  
Barb Bishop - North American Tool Corporation

## Support the AMTMA



## MEMBERSHIP AWARDS

S-T Industries	25 Years as an AMTMA member
Atlas Thread Gage, Inc.	25 Years as an AMTMA member
PMC Lone Star	25 Years as an AMTMA member
R L Schmitt Co. Inc.	20 Years as an AMTMA member
Ledford Gage Lab, Inc.	20 Years as an AMTMA member
A.A. Jansson, Inc.	20 Years as an AMTMA member
Deltronic Corporation	15 Years as an AMTMA member
Mark-10 Corporation	10 Years as an AMTMA member
Brunswick Instrument, Inc.	10 Years as an AMTMA member

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## Spring Meeting 2012

MARCH 21-23, 2012  
Chaparral Suites  
Scottsdale, AZ

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## Plan now for the March 2012 Annual Meeting!



Mark your calendar for March 21-23 2012 for the next Annual General Membership meeting of the AMTMA at the Chaparral Suites in Scottsdale, AZ.

Topics are being planned to include Technical sessions and other business topics.

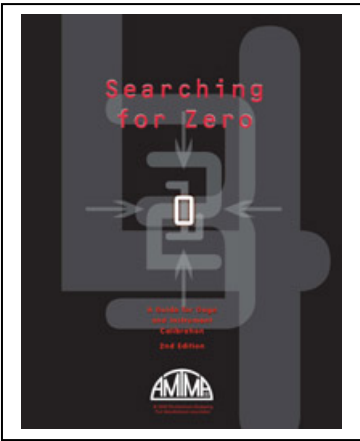
We are also planning on having a plant tour. Please let me if you have any topics you would like to address at this meeting.



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## ASME B1 Thread Committee Report

The ASME B1 thread standards meeting was held May 10 – 12, 2011 in Old Scottsdale, AZ. Following is the report on these meetings.

**B1.1 60° product threads:** Nothing new to report

**The revised B1.2** is still in draft form at this time. Sections have been reviewed and approved.

**B1.5, acme threads:** no new activity

**B1.8, stub acme threads:** will be revised soon

**B1-9, buttress threads:** some changes proposed for symbols and wording.

**B1.20, pipe threads:** David Katz brought up the issue of using 3 dimensional drawings in the specification. Angel Guzman stated he had not seen this in other documents. It was agreed if they need to be used to show a clearer picture, we would incorporate if possible. There was a discussion on the letter submitted by Guy Cuccio on changing of gage point from end of pipe to last scratch of thread.

Guy passed out a copy of his proposed change for review. There was a discussion on the specification and whether to revise it. David Katz pointed out that section 8.1 refers to the “End of the Pipe” as the gauging reference. Section 8.1 and 8.2 refer to the “End of the Thread”, but also refer to figure 6, which shows gauging to the end of the pipe. David Katz referred to the specification N1.5, section 1.7.2.1 which describes how to handle chamfer size on the product. It describes that the purchaser and supplier should agree on gauging points if chamfers exceed major diameter of the internal and minor diameter of external.

Alan Sheppard brought up the turns engagement method, Guy Cuccio stated that the turn’s method is not an accurate way to check pipe threads. David Katz said this part of the specification will be put in the appendix of the new revision. It was discussed that some manufacturers’ practice is to make large chamfers on external threads to protect the thread, especially on large fittings. They feel that the threads are good and the specification should allow this practice by not counting the excess of chamfer when gaging the parts. Additionally, this would better ensure adequate thread engagement. Some manufacturers have had auditors not agree with this practice because it is not allowed in the specification.

**Working group on thread gage calibration:** The working Group on Calibration completed the review of Lowell Johnson’s assignment, inspection and calibration of internal and external, segments and rolls.

Al Barrows explained the following tasks that still needed to be done

Review non-threaded gages in the current B1.2, table 12 items 8-16, table 13, items 8 thru 15 and table 14.

Wording for progressive set plugs

Wording for the calibration of the new vs. used gages

Incorporate table 12,13 & 13 notes from current B1.2 document

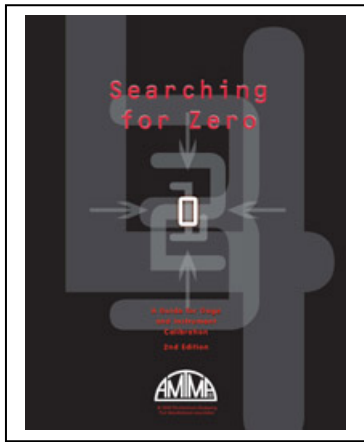
Integration of appendix A from current B1.2 document

**B1.10 unified miniature screw threads:** The B1.10-2004 unified miniature screw thread document is current and available from ASME.

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# ANNOUNCEMENTS

R.L.

## Schmitt Co., Inc./ Livonia MI

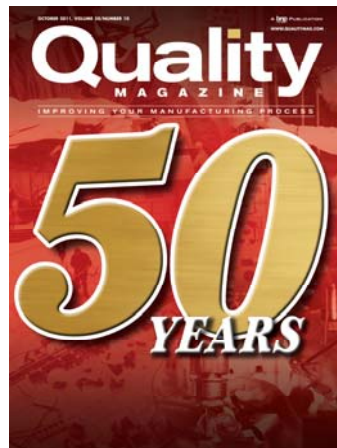
The R.L. Schmitt Co. has recently purchased additional equipment for their line of special solid carbide cutting tools. The addition of a new Rollomatic 628X will now allow them to increase exports by 40%.

Besides the cutting tools, the new equipment will allow them to manufacture extremely intricate gages for the medical industry.

And due to the demand, they have put another thread grinder on-line to reduce delivery time. Both Bruce and Paul plan on being around for a long time.

On a personal note, we'd like all to wish Paul congratulations on his marriage to Dawn Sanchez on October 1<sup>st</sup>.

## Quality Magazine Celebrates its 50<sup>th</sup> Anniversary!



The October issue of *Quality* marks our 50<sup>th</sup> Anniversary, as our first issue published in October 1962. I would personally like to thank our clients both new and old, as we know that without advertising support there would be no *Quality* Magazine. Secondly, a very special thank you for those advertisers whose ads appeared in our first issue and continue to support us today fifty years later. Throughout our October issue you'll see a special designation on their ads recognizing them as original advertisers. These companies have stood the test of time as they serve the manufacturing community with innovative products and great technology.

Neither would there be a *Quality* Magazine without our loyal subscribers. We have worked hard to satisfy the information needs by providing our readers with timely information in the media format they request, both digitally and in print. Our monthly print edition continues to be the back bone of our brand, while our new online initiatives continue to grow. We salute the **American Measuring Tool Manufacturers Association** for your past support, and look forward to the next fifty years!

Regards,

A handwritten signature in black ink that reads 'Darrell Dal Pozzo'.

Darrell Dal Pozzo  
Publisher  
[dalpozzod@bnpmedia.com](mailto:dalpozzod@bnpmedia.com)

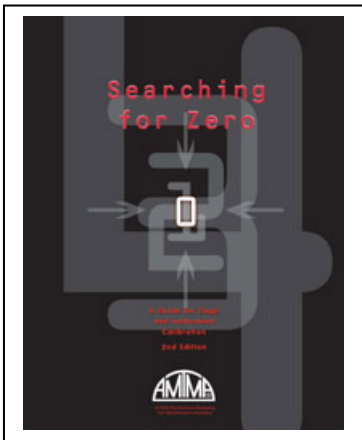
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## Seland Joins Quality Magazine as Editor in Chief

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### Support the AMTMA



Darryl Seland has joined Quality Magazine as its new editor in chief. He will work out of the company's office in West Chester, PA.

Seland brings more than ten years of experience in trade magazine publishing having worked for magazines covering the financial sector and construction and heavy equipment markets. Most recently, Seland served as editor in chief and associate publisher for another of the company's titles, CircuiTree, a magazine devoted to the printed circuit board industry. Seland also holds an MBA and a bachelors Degree in Journalism.

In his new role, Seland will take over responsibilities for Quality's Vision & Sensors and NDT magazines, as well as provide direction and leadership for the breadth of Quality magazines' offerings to its readers.

"I look forward to the opportunity and to covering this very innovative market," says Seland. "Like the metrology and quality inspection industries themselves, Quality magazine is about innovation. We will continue to not only deliver the information its readers want and need, but also deliver it in an innovative way, whether through print, digital editions, eNewsletters and online."

Darryl may be reached at [selandd@bnpmedia.com](mailto:selandd@bnpmedia.com).

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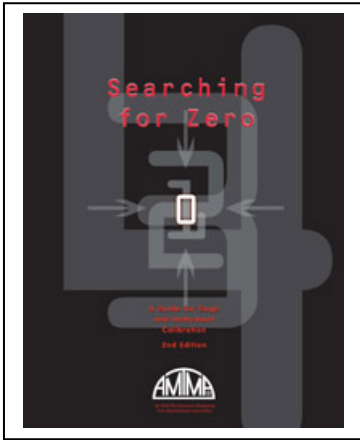
## Master Gage & Tool Co. Danville Open House Was a Great Success!

Master Gage & Tool Co. had a record breaking number of customers participate in their September 15, 2011 open house and seminar event at their main office in Danville, VA. MG&T also had a high level of turn out from their valued suppliers. The two groups together lent itself to a very informative day.

MG&T customers benefited from seminars from Nikon Metrology on 3D Laser Scanning and Newage Instruments on Hardness Testing. Customers also found time to visit many other suppliers in attendance. Suppliers included Renishaw with the new Equator, Mountz with their line of torque tools, Gradient Lens with their borescope line, Newage Instrument with their full line of hardness testers, Nikon Metrology with their Video Measurement Systems, Microscopes, CMM's, and Laser Scanning Systems, Mark-10 with their force and torque equipment, Mitutoyo with their surface roughness tester and hand tools and product representation by Glastonbury Southern Gage.

Master Gage & Tool Co. looks forward to next year's event.

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## Tid Bits, By Hill Cox A Can of Worms

As you know, all quality systems require before and after readings when instruments are calibrated. In other words, if you tweaked something during the process, auditors want to know how good or bad it was before you tweaked it not just the state of it after doing so. The logic behind this requirement is pretty basic. If the instrument was out to lunch before being brought into line during calibration, what sort of damage- if any- was done while it was out of spec ?

If it's serious enough, a product or component part recall may be required. When you consider fixed limit gages, this requirement can be ignored because there is no tweaking involved. Some auditors try to make a case that adjustable thread rings would fall into this category because they are often adjusted. Usually they back down when advised that to do so would require a range of setting plugs for every thread ring gage to determine the pre-adjustment size. And since many customer squawk at the price of regular ring calibration, they'd go ballistic if the costs of the required masters were figured into the price.

But, there is one element that could be verified on this basis- the minor diameter. Three point internal micrometers could provide both the before and after readings. Alternatively, plain plug gages could do the job. This could have no or little relationship to actual pitch diameter but sooner or later some bright spark will make the case for it to be reported on a before / after basis. Since few labs bother to check the minor diameter after resetting a ring, I can see folks who do the job with before / after readings being considered non-competitive to those who do as little as possible for price considerations.

I hesitate opening this can of worms but it's an element we will have to deal with sooner or later. Now's the time to do it so we can keep it practical. Your thoughts would be appreciated and could become part of a Calibration Procedure put out by the AMTMA. Alternatively, we could just take the worms and go fishing - a more appealing idea for me.

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**MAY 2011 AMTMA MEETING**

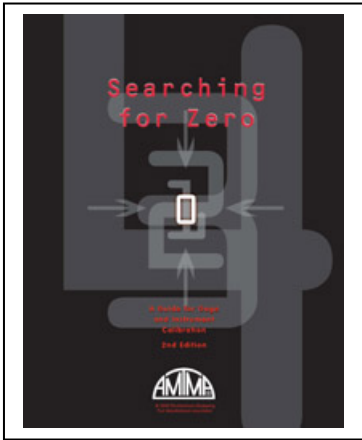


**Waiting for the bus to N.I.S.T.  
Jim Gregory is checking for his I.D.**



**There talking about Gregory's I.D.**

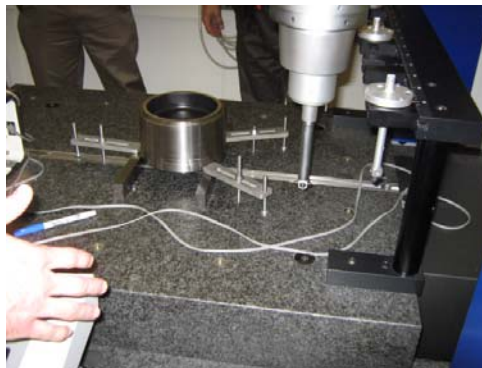
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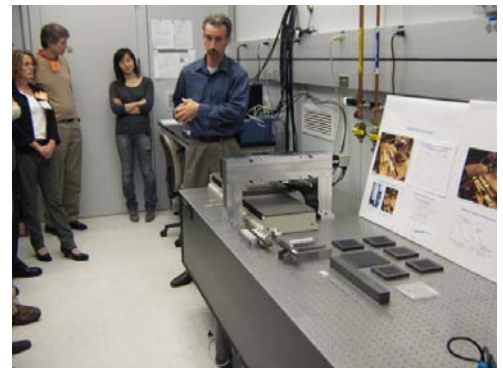
**API Gage Inspection area**



**API Grand Master Gages**

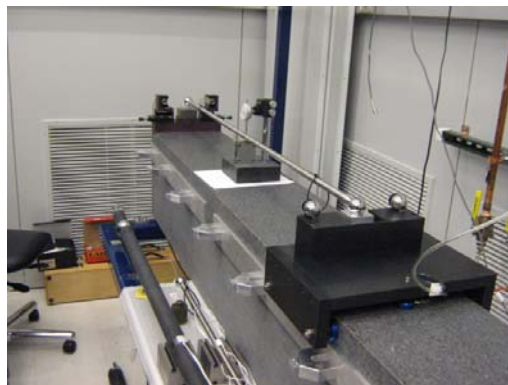


**Measuring Master API thread plug**



**Special Measuring Projects**

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**Master Ball Bar Calibration**



**The New N.I.S.T. Gage  
Calibration Building**

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**API Gage Inspection area  
 Deltronic Corp.  
 15 Year Membership Award**



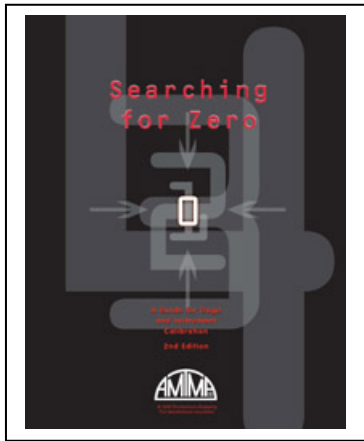
**Special Measuring Project  
 Ledford Gage Lab  
 20 Year Membership Award**



**PMC Lone Star  
 25 Years Membership Award**



**Mark-10 Corp.  
 10 Years Membership Award**



**Barb Bishop  
 Board Member Award**



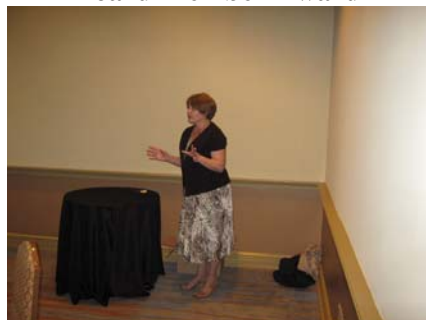
**Steve Popovic  
 Presidents Award**

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**Barb Bishop  
 Our New President**