



Van Keuren



Prices have changed! Call 800-825-4272 for current prices!

Precision Testing and Measuring Tools



“...this Catalog is dedicated to those who require precision measurements...”

**H.L. Van Keuren
1889-1952**

Van Keuren has a long history of innovation in the development and production of very precise, very round and very straight cylinders and ultra flat surfaces.

Today Van Keuren is drawing on its long gaging heritage and expanding its capability to serve you by adding the manufacturing resources and gaging products of THREADS Inc. and HITCO. The expanded resources and additional products allow Van Keuren to improve its gage offering and array of services to you, our gaging customers!

If your product requires precise measurement, inspection and certification, use Van Keuren precision gages and instruments.

If your product reaches for the ultimate in custom fit, challenge Van Keuren to match the requirement.

If your product utilizes gaging that requires periodic inspection and calibration traceable to the NIST, contact Van Keuren.

***Gages are precision measuring tools
... handle them properly!***

- ***Clean the part before gaging.*** Get rid of dirt, coolant and chips.
- ***Do not force the gage.*** Use reasonably light pressure only.
- ***Protect the gage from damage.*** Nicks and burrs allow inaccurate results.
- ***Keep gages clean and lightly oiled.*** This increases wear life.
- ***Avoid handling gaging surfaces.*** Fingerprints cause rust.

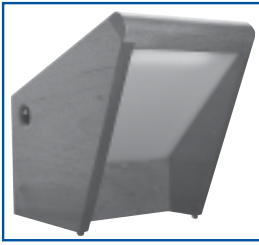
A \$10.00 handling charge is applied if the order does not meet \$25.00 net minimum. • Prices are subject to change without notice. • All prices are FOB factory.

TABLE OF CONTENTS

DESCRIPTION	LIST #	PAGE	DESCRIPTION	LIST #	PAGE
MONOCHROMATIC LIGHTS		2	TAPERLOCK HSS THREAD PLUG GAGES TIN COATED ...		31
C & L Series	24-20		TiN Coated Taperlock HSS	19-00TI	
REFLEX INTERFERENCE VIEWER		2	TRILOCK REVERSIBLE STEEL THREAD PLUG GAGES		32
U Series Lights	24-20		Trilock Reversible Style	19-00TRI	
Helium Replacement Tubes	24-20		HELICAL COIL TAPERLOCK STEEL GAGES (STI)		33
OPTICAL FLATS		3	Helical Coil Gages (STI)	19-00THC	
Calibrated Quartz Flats	24-10		REVERSIBLE THREAD PLUG GAGES DIMENSIONS		34
RECONDITIONED OPTICAL FLATS		3	Reversible Dimensions	—	
OPTICAL FLATS PARALLEL SETS		3	REVERSIBLE STEEL THREAD PLUG GAGES		35
Optical Flats Parallel Sets Parallel to .000004"	24-10		Reversible Style Work Plug Gages	19-00W REV	
Optical Flats Parallel Sets	24-10		METRIC STEEL THREAD PLUG GAGES		36
THREAD MEASURING WIRES		4-5	Metric Taperlock Work Plugs	19-00MT	
60 Degree Threads	16-00		REVERSIBLE METRIC STEEL THREAD PLUGS		37
60 Degree Metric Threads	16-00		Reversible Metric Thread Plugs	19-00H	
3-WIRE THREAD MEASURING SYSTEM		6-7	Metric - Inch Pitch Equivalents	—	
60 Degree Thread 3-Wire Sets w/Holder	16-20H		THREAD RING GAGE BASIC DIMENSIONS		38
60 Degree Metric Thread Wire Sets w/Hldr	16-20H		Thread Ring Gage Dimensions		
THREAD MEASURING WIRE SETS		7	Thread Ring Gage Holders	15-35	
Thread Measuring Wire Sets	16-00S		THREAD RING GAGES		39-40
GRAND MASTER CALIBRATION SETS		8	Ring Gages	19-00R	
Grand Master Calibration Sets	16-00S		TRUNCATED THREAD SETTING PLUGS ,		
Special Thread Measuring Wires	16-10		BASIC DIMENSIONS		41
29 Degree Acme Best Thread	16-00		Thread Setting Plug Gage Dimensions	—	
GEAR MEASURING WIRES MASTER SETS		9	TRUNCATED THREAD SETTING PLUGS		42-43
Gear Measuring Wires Master Sets	17-00M		Truncated Setting Plugs	19-00S	
GEAR MEASURING WIRES		10-11	METRIC THREAD RING GAGES		44
Grade A Master Gear Wires	17-00		Metric Thread Rings	19-00MR	
Special Gear Measuring Wires +/- .000010	17-10		METRIC THREAD SETTING PLUGS		45
Flatted Gear Wires	17-00		Truncated Setting Plugs	19-00MS	
WIRETYPE REVERSIBLE PLUG GAGES		12	TAPER PIPE GAGES - NPT		46
Reversible Plain Plug Gages	10-00		Taper Pipe Gages - NPT Dimensions	—	
WIRETYPE REVERSIBLE PLUG GAGES - CHROME		13	Ring Dimensions	—	
Reversible Plain Plug Gages - Chrome ..	11-00		L1 Single End Plug Gages - NPT	19-00TP	
EXTRA LENGTH WIRETYPE PLUG GAGES		14	L1 Thin Ring Gages - NPT	19-00TP	
Extra Length Steel Reversible Plain Plug Gage			TAPER PIPE GAGES - NPTF		47
Members	15-00		Taper Pipe Gages - NPTF Dimensions	—	
DEPTH NOTCHES		14	Taper Pipe Gages - NPTF	19-00TPF	
AIR GROOVES		14	FLEXIBLE HOLE LOCATION GAGES		48
HEX GAGES, DOUBLE END		15	Flexible Hole Location Gages	19-00HL	
Double End ANSI/ASME B107.17M	19-69		PLAIN SNAP GAGES		49
Double End ANSI B18.3	19-69		Plain Snap Gages - Model SC	19-41	
TAPERLOCK PLUG GAGES		16	Plain Snap Gages - Model SMC	19-41	
Taperlock Plug Gages	13-00		OUTSIDE MICROMASTER MASTER		50
PROGRESSIVE TAPERLOCK PLUG GAGES		17	Surveillance Masters	16-70	
Steel & Chrome Progressive Taperlock Style	13-24		VERNIER CALIPER MASTERS		50
PROGRESSIVE TRILOCK PLUG GAGES		18	Vernier Caliper Masters	16-75	
Steel & Chrome Progressive Trilock Style	13-34		DEPTH MICROMETER MASTERS		50
TRILOCK PLUG GAGES		19	Depth Micrometer Masters	16-80	
Trilock Cylindrical Plug Gages	14-00		INSPECTION & CALIBRATION SERVICE		51
MASTER DISKS		20-21	CYLINDRICAL RING & PLUG GAGE REPAIR PROGRAM 51		
Steel • Bilateral Tolerance	14-00MD		Salvage of Standard A.G.D. Cylindrical Ring and Plug Gages		
CYLINDRICAL PLAIN RING GAGES		22-24	Shipping Address for Inspection and Salvage of Standard		
Steel and Chrome Ring Gages	18-00		A.G.D. Cylindrical Ring and Plug Gage		
STANDARD GAGEMAKERS TOLERANCE		25	Thread Wire & Gear Wire Products		
Gagemakers Tolerance Chart			Optical Flats		
TABLE OF THREAD PITCH DIAMETER LIMITS		26-27	Threaded Products		
TAPERLOCK STEEL THREAD PLUG GAGES		28-30	Plain Wire Plugs, Disks & Rings		
Class X Thread Gage Tolerances	—		Pipe Products		
Taperlock Style Work Plug Gages	19-00T		EDP NUMERICAL LISTING with PRICES		52-60



MONOCHROMATIC LIGHTS



• C-2 Monochromatic Light

- The correct monochromatic light can increase accuracy in measurement as well as actually improve inspection speed.
- All Van Keuren lights use a helium light source with a light of 23.13 millionth wavelength (587.6 nm).
- Van Keuren supplies monochromatic lights in three styles, made with and two materials – Fine Woods and PVC.
- Used to increase accuracy in measurement

C & L SERIES LIGHTS List #24-20

Series Description	Size/Weight Information				EDP No.	Price
	Width	Height	Depth	Weight		
C-1 Monochromatic Light Work size up to a full 4" square.	6-1/2"	7-1/2"	9"	7 lbs.	V760100	530.40
C-2 Monochromatic Light (Standard) Work size to over 6" diameter.	12"	11"	11"	16 lbs.	V760101	696.56
C-2 PV Monochromatic Light White high density case for use in a clean room.	12"	11"	11"	16 lbs.	V760102	N/A
C-3 Monochromatic Light Work capacity of over 12".	22"	16-1/2"	18-1/2"	42 lbs.	V760103	1,139.82
Standard L-1A Monochromatic Light Work size up to 8".	15"	22-1/2"	17"	50 lbs.	V760200	1,969.72
Standard L-2A Monochromatic Light Work size up to 12".	15"	22-1/2"	17"	50 lbs.	V760201	2,414.50

REFLEX INTERFERENCE VIEWER



• U-6 Reflex Viewer shown with Optical flat.

- For rapid production inspection with maximum precision on polished or lapped work.
- In the Van Keuren Reflex Viewer, the Optical Flat is secured above the light in a fixed cell; the work is placed on top of the flat and bands noted.
- Keeping the work on top of the flat avoids serious distortion due to the weight of the flat when the work is small or delicate. Work larger than the flat can be inverted and moved across the flat for two or more observations.
- Handling of the optical flat is entirely eliminated and risk of accidental damage or excessive wear is greatly diminished.

U SERIES LIGHTS List #24-20

Series Description	Size/Weight Information				EDP No.	Price
	Width	Height	Depth	Weight		
U-6 Monochromatic Reflex Interference Viewer For use with 6" flat.	10-1/2"	17"	14"	19 lbs.	V760300	1,920.06
U-12 Monochromatic Reflex Interference Viewer For use with 12" flat.	24"	48"	24"	46 lbs.	V760302	4,295.67
U-14 Monochromatic Reflex Interference Viewer For use with 14" flat. Larger units available.	30"	48"	31"	80 lbs.	V760303	5,187.33

HELIUM REPLACEMENT TUBES List #24-20

Series Description	Size	EDP No.	Price
C-1	5" Square	V760500	142.51
C-2	6 Run	V760502	174.64
C-3	10 Run	V760501	190.40
L-1A	10 Run	V760501	190.40
L-2A	10 Run	V760501	190.40
U-6	6 Run	V760502	174.64
U-12	6 Run	V760502	174.64
Small chart (12" x 17")			10.00
Large wall chart (38" x 25")		V980139	18.36
Video on optical flats		V980141	29.16



- Van Keuren furnishes optical flats using only the most carefully selected annealed clear fused quartz.
- Fused quartz possesses a very low coefficient of linear expansion and is resistant to abrasion.
- All Van Keuren Optical Flats come furnished in a felt lined fitted case with a certificate of calibration stating the actual flatness directly traceable to the National Institute of Standards & Technology.
- For micro-coating, call customer service for a quote. Micro-coating is applied to the flat to help clarify the image. Generally it is applied to one surface.

CALIBRATED QUARTZ FLATS List #24-10

Size Diameter Thick	Working .000004" EDP No.	Price	Master .000002" EDP No.	Price	Reference .000001" EDP No.	Price
SINGLE SURFACE						
1" x 1/2"	V860101	117.00	V860201	125.00	V860301	133.00
2" x 5/8"	V860102	188.00	V860202	200.00	V860302	218.00
3" x 11/16"	V860103	310.00	V860203	347.00	V860303	407.57
4" x 3/4"	V860104	428.00	V860204	512.82	V860304	598.47
5" x 7/8"	V860105	647.42	V860205	684.13	V860305	822.05
6" x 1"	V860106	898.04	V860206	999.35	V860306	1,303.31
8" x 1 5/16"	V860108	2,018.74	V860208	2,221.85	V860307	2,470.64
10" x 1 11/16"	V860110	3,490.50	V860210	4,033.18	V860310	4,315.84
12" x 2"	V860112	5,456.32	V860212	6,541.62	V860312	6,924.69
DOUBLE SURFACE						
1" x 1/2"	V860401	150.00	V860501	167.00	V860601	175.00
2" x 5/8"	V860402	218.00	V860502	237.00	V860602	255.00
3" x 11/16"	V860403	375.00	V860503	443.85	V860603	541.41
4" x 3/4"	V860404	513.00	V860504	570.19	V860604	769.78
5" x 7/8"	V860405	769.78	V860505	904.38	V860605	1,062.69
6" x 1"	V860406	1,079.40	V860506	1,265.32	V860606	1,683.25
8" x 1 5/16"	V860408	2,550.71	V860508	2,865.81	V860608	3,596.33
10" x 1 11/16"	V860410	4,655.50	V860510	4,881.16	V860610	5,706.09
12" x 2"	V860412	6,951.75	V860512	7,781.24	V860612	9,493.67



Furnished in fitted felt-lined case. Sizes 14" x 2 1/2", 15" x 2 1/2", 16" x 3" – Price on application, single and double surface. Central hole prices furnished upon request.

RECONDITIONED OPTICAL FLATS

- Your worn, scratched and opaque flats can be resurfaced to any desired accuracy, single or double surface, and will be indistinguishable from new flats.
- The reworked flats will be certified, showing traceability to the National Institute of Standards and Technology with the test number and date.
- Substantial savings can be realized on small and large flats in all three accuracies. Consult factory for an estimate.
- Microcoating on rework at full price.

OPTICAL FLATS PARALLEL SETS

OPTICAL FLATS PARALLEL SETS - PARALLEL TO .000004" List #24-10

Type of Set	Size	EDP No.	Price
Set Op-2A , two parallels	1" x 1/4"	V839900	375.00
Set Op-2AA , two parallels	1" x 1/2"	V839901	375.00
Set Op-2B , two parallels	1-1/4" x 1/2"	V839903	425.00
Set Op-2C , two parallels	1" x 1"	V839905	500.00
Set Op-2AA , metric parallels	25.4mm x 12.7 mm	V839902	N/A

Flats in optical parallel sets differ in thickness by approximately .0125", providing a parallelism check at two spindle positions, each one-half turn apart. For metric micrometers, the difference is 0.25 mm.

OPTICAL FLATS PARALLEL SETS List #24-10

Case #1	Working Accuracy .000004"	EDP No.	Price
1-OP2B	Optical Parallels	V830001	CALL FOR CURRENT PRICES
1-2" x 5/8"	Double Surface		
1-2" x 5/8"	Single Surface Coated		
1-3" x 11/16"	Double Surface		
1-4" x 3/4"	Single Surface Coated		
Case #2	Master Accuracy .000002"	V830002	CALL FOR CURRENT PRICES
1-2" x 5/8"	Double Surface		
1-2" x 5/8"	Single Surface Coated		
1-3" x 11/16"	Double Surface		
1-4" x 3/4"	Single Surface Coated		
Case #3	Reference Accuracy .000001"	V830003	CALL FOR CURRENT PRICES
1-2" x 5/8"	Double Surface		
1-2" x 5/8"	Single Surface Coated		
1-3" x 11/16"	Double Surface		
1-5" x 3/4"	Single Surface Coated		