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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 10922-2025

Replacing GB/T 10922-2006

**Gauges for pipe threads with 55 degree thread angle where
pressure-tight joints are not made on the threads**

55°非密封管螺纹量规

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1.Structure and Drafting Rules of Standardization Documents". Drafting. This document replaces GB/T 10922-2006 "55° Non-Sealing Pipe Thread Gauges". Compared with GB/T 10922-2006, the only changes are structural adjustments. Aside from editorial changes, the main technical changes are as follows:

- a) Added terms and definitions (see Chapter 3);
- b) The requirements for functionality and features have been changed (see Table 2,.2006 version);
- c) The formula for the minor diameter of the stop thread plug gauge has been modified (see Figure 8, Figure 8 in the.2006 version);
- d) The Vickers hardness value of the measuring face of the measuring head was changed (see 10.4.1,
9.4.1 in the.2006 edition);
- e) The requirements for thread plug gauge testing parameters and testing instruments have been changed (see Table 9,.2006 edition);
- f) The requirements for thread ring gauge testing parameters and testing instruments have been changed (see Table 10,.2006 edition);

g) The formula for the minor diameter of the stop thread ring gauge has been modified (see Table B.1, Table B.1 in the.2006 edition);

h) Increased wear tolerance of the thread gauge pitch diameter (see Table B.1). Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents. This document was proposed by the China Machinery Industry Federation. This document is under the jurisdiction of the National Technical Committee on Standardization of Measuring Instruments and Gauges (SAC/TC132). This document was drafted by Chengdu Xincheng Measurement Tools Co., Ltd. and Chengdu Tool Research Institute Co., Ltd. The main drafters of this document are. Xu Yan, Zhao Panzong, Xu Gang, and He Yixian. This document was first published in 1989, revised for the first time in.2006, and this is the second revision. 55° Non-Sealing Pipe Thread Gauge

1 Scope

GB/T 10922-2025 is the Chinese national standard on gauges for pipe threads with 55 degree thread angle where pressure-tight joints are not made on the threads, in the field of metrology and measurement. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 31 October 2025 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 May 2026. Classification: ICS 17.040.30, CCS J42. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This document specifies the symbols and descriptions, tolerances, requirements, acceptance and testing, marking and packaging of 55° non-sealing pipe thread gauges. This document applies to the inspection of 55° non-sealing pipe threads as specified in GB/T 7307-2001.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included. For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies. This document.

GB/T 7307-2001 55° Non-sealing Pipe Threads

GB/T 14791 Thread Terminology

3 Terms and Definitions

The terms and definitions defined in GB/T 14791 apply to this document.

4.Symbols and Explanations The symbols and descriptions listed in Table 1 apply to this document. Table

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