



JAPANESE  
INDUSTRIAL  
STANDARD

Translated and Published by  
Japanese Standards Association

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**JIS B 0209-4** : 2001  
(ISO 965-4 : 1998)  
(JFRI/JSA)

**ISO general purpose metric screw  
threads — Tolerances — Part 4: Limits  
of sizes for hot-dip galvanized external  
screw threads to mate with internal  
screw threads tapped with tolerance  
position H or G after galvanizing**

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ICS 21.040.10

Reference number : JIS B 0209-4 : 2001 (E)

## Foreword

This translation has been made based on the original Japanese Industrial Standard established by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee according to the proposal of establishing a Japanese Industrial Standard from The Japan Research Institute for Screw Threads and Fasteners (JFRI)/the Japanese Standards Association (JSA), with a draft of Industrial Standard based on the provision of Article 12 Clause 1 of the Industrial Standardization Law. By this Standard, **JIS B 0209:1997**, **JIS B 0211:1997** and **JIS B 0215:1982** were withdrawn and replaced with **JIS B 0209 Part 1 to Part 3**.

This Standard has been made based on **ISO 965-4:1998** *ISO general purpose metric screw threads — Tolerances — Part 4: Limits of sizes for hot-dip galvanized external screw threads to mate with internal screw threads tapped with tolerance position H or G after galvanizing* for the purposes of making easy to compare this Standard with International Standard; to prepare Japanese Industrial Standard conforming with International Standard; and to propose a draft of International Standard which is based on Japanese Industrial Standard.

**JIS B 0209** series consist of 5 parts with the title of *ISO general purpose metric screw threads — Tolerances*.

- JIS B 0209-1 *Part 1: Principles and basic data*
- JIS B 0209-2 *Part 2: Limits of sizes for general purpose external and internal screw threads — Medium quality*
- JIS B 0209-3 *Part 3: Deviations for constructional screw threads*
- JIS B 0209-4 *Part 4: Limits of sizes for hot-dip galvanized external screw threads to mate with internal screw threads tapped with tolerance position H or G after galvanizing*
- JIS B 0209-5 *Part 5: Limits of sizes for internal screw threads to mate with hot-dip galvanized external screw threads with maximum size of tolerance position h before galvanizing*

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Standards Board

Technical committee on Machine Elements

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In the event of any doubts arising as to the contents,  
the original JIS is to be the final authority.

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**ISO general purpose  
metric screw threads — Tolerances  
— Part 4: Limits of sizes for hot-dip galvanized  
external screw threads to mate  
with internal screw threads tapped with  
tolerance position H or G after galvanizing**

**Introduction** This Japanese Industrial Standard has been prepared based on the first edition of **ISO 965-4** *ISO general purpose metric screw threads — Tolerances — Part 4: Limits of sizes for hot-dip galvanized external screw threads to mate with internal screw threads tapped with tolerance position H or G after galvanizing* published in 1998 without modifying the technical contents.

**1 Scope** This Standard specifies deviations and limits of sizes for pitch and crest diameters for ISO general purpose metric external screw threads conforming to **JIS B 0205-3** having a basic profile according to **JIS B 0205-1**.

External screw threads according to this Standard are intended to mate with internal screw threads tapped with tolerance position H or G after hot dip galvanizing.

The limits of size for the tolerance quality specified are derived from tolerances specified in **JIS B 0209-1** and the fundamental deviations according to the following formula:

$$es_{az} = -(300 + 20P)$$

where,  $es$  is expressed in micrometres;

$P$  is expressed in millimetres.

Products made with thread tolerances in accordance with this Standard may show failure at lower ultimate tensile loads than those specified in **JIS B 1051** due to reduction of the stress area.

External screw threads with thread tolerances according to this Standard must not be mated with internal screw threads with thread tolerances according to **JIS B 0209-5** because such combinations will create severe risk for thread stripping.

- Remarks**
1. If the tolerance class 6az is not specified the external screw threads are to mate with internal screw threads with tolerance position 6AZ if the products are centrifuged and with hot-dip galvanized internal screw threads with tolerance position 6AX if the products are not centrifuged.
  2. The International Standard corresponding to this Standard is as follows.

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and JIS are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21**.