



JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS B 0261 : 2004

(JMA)

**Parallel screw thread gauges—
Measuring method of gauges**

ICS 21.040.10

Reference number : JIS B 0261 : 2004 (E)

PROTECTED BY COPYRIGHT

 **Documents**
Document Sharing Hub

85

Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee, as the result of proposal for revision of Japanese Industrial Standard submitted by Japan Precision Measuring Instruments Association (JMA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14. Consequently **JIS B 0261 : 1992** is replaced with this Standard.

In this revision, confirms conformity to the normative references, and measuring items, positions, gists and instruments are amended.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

Date of Establishment: 1955-03-05

Date of Revision: 2004-02-20

Date of Public Notice in Official Gazette: 2004-02-20

Investigated by: Japanese Industrial Standards Committee

Standards Board

Technical Committee on Testing and
Measurement Technology

JIS B 0261 : 2004, First English edition published in 2004-06

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

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

© JSA 2004

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

Printed in Japan

PROTECTED BY COPYRIGHT

Contents

		Page
1	Scope	1
2	Normative references	1
3	Definitions	1
4	Measuring items, position, gists and instruments	1
5	Measurement for pitch diameter of thread plug gauge.....	3
6	Measurements for pitch of thread plug gauge	4
7	Measurement for half angle of thread plug gauge.....	5
8	Measurement for minor diameter of thread ring gauge	5
Annex 1 (normative)	Formula for calculating pitch diameter in the method of three wires to be applied for the case of screw thread with coarser pitch or lesser number of threads per inch than that of standard coarse threads.....	7
Annex 2 (normative)	Calculating formula for pitch diameter in the method of three wires alternative to the test table 2	8

Parallel screw thread gauges— Measuring method of gauges

1 Scope This Japanese Industrial Standard specifies measuring method of screw thread plug gauges and ring gauges (hereafter referred to as “thread gauges”) among limit gauges for parallel screw threads having single-start thread with symmetrical ridge defined in **JIS B 0251**, **JIS B 0254** or **JIS B 0255** and others according as them.

2 Normative references The following standards contain provisions which, through reference in this Standard, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

- JIS B 0101 *Screw threads and fasteners—Vocabulary*
- JIS B 0251 *Limit gauges for metric screw threads*
- JIS B 0254 *Screw thread limit gauges for parallel pipe threads*
- JIS B 0255 *Limit gauges for unified screw threads*
- JIS B 0271 *Three wires for screw thread measuring*
- JIS B 0659-1 *Geometrical Product Specifications (GPS)—Surface texture : Profile method ; Measurement standards—Part 1 : Material measures*
- JIS B 7153 *Measuring microscopes*
- JIS B 7502 *Micrometer callipers*
- JIS B 7506 *Gauge blocks*
- JIS B 7520 *Indicating micrometers*
- JIS B 7725 *Vickers hardness test—Verification of testing machines*
- JIS B 7726 *Rockwell hardness test—Verification of testing machines*
- JIS Z 2244 *Vickers hardness test—Test method*
- JIS Z 2245 *Rockwell hardness test—Test method*

3 Definitions For the main terms used in this Standard, definition of **JIS B 0101** shall apply.

4 Measuring items, position, gists and instruments The measuring items, positions, gists and instruments for thread gauges are given in table 1.

If other measurements are required than these items, any appropriate method shall apply.