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Aerospace — UNJ threads — Gauging

Aéronautique et espace — Filetage UNJ — Vérification par calibres

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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

This second edition cancels and replaces the first edition (ISO 15872:2002), which has been technically revised and includes the following changes:

— unused symbols have beenremoved from Table 1: WGO, WNG, Z1, ZPL, and ZR.

— Figures have been changed to align with 8.1.

— Normative references have been updated.

— Terminology has been updated.

— The document has been editorially revised.

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Aerospace — UNJ threads — Gauging

1 Scope

This document provides methods for the gauging of ISO UNJ threads complying with ISO 3161.

Other methods of ensuring that the product is within the specified limits can be used, provided that correlation with the specified gauges is established.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1, *Geometrical product specifications (GPS) — Standard reference temperature for the specification of geometrical and dimensional properties*

ISO 3161, *Aerospace — UNJ threads — General requirements and limit dimensions*

3 Terms, definitions, symbols and abbreviated terms

3.1 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5408 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— IEC Electropedia: available at http://www.electropedia.org/

— ISO Online browsing platform: available at http://www.iso.org/obp

3.1.1
best wire size
cylinder or sphere which has a radius so that it will contact the thread flanks at the pitch cylinder intersection

Note 1 to entry: The radius of the best wire or sphere is theoretically equal to 0,288 68*P*.

3.1.2
indicating gauge
device having contacts which will precisely compare the size of a work piece thread to a setting standard of known dimensions

Note 1 to entry: The value for the indicated characteristic thus established is the dimensional value attributed to the work piece. An indicating gauge can have contacts designed to measure any thread characteristic. This document specifies the characteristics and designs for ISO UNJ threads.

3.1.3
simple pitch diameter
diameter of an imaginary cylinder intersecting an actual thread over the width of one groove where that width is equal to one half of the basic pitch

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3.1.4
virtual pitch diameter
pitch diameter of the smallest (for external threads) or largest (for internal threads) perfect thread form with GO gauge profile which can engage the product threads for a distance equal to the GO gauge thread engagement

3.2 Symbols and abbreviated terms

See Table 1.

Table 1 — Symbols, abbreviated terms and definitions

Symbol or abbreviated term	Definition
D_1	Basic minor diameter of the internal thread of a workpiece
d_2	Basic pitch diameter of the external thread of a workpiece
es	Fundamental deviation of the external thread of a workpiece
EI	Fundamental deviation of the internal thread of a workpiece
H	Height of the triangle of a thread profile
H_1	Tolerance for the diameter of plain plug gauges
H_P	Tolerance on the size of check plug gauges for plain calliper gauges
(LSL)	Lower specification limit
m	Distance between the middle of the tolerance zones TR of a screw ring gauge and TCP of a GO check plug
(USL)	Upper specification limit
P	Pitch

Symbol or abbreviated term	Definition
$T_{\alpha 1}/2$	Tolerance for each flank angle of a profile with complete flanks
$T_{\alpha 2}/2$	Tolerance for each flank angle of a profile with truncated flanks
T_{CP}	Tolerance on the pitch diameter of GO and NOT GO screw check plugs, wear check plugs and setting plugs
T_d	Tolerance for the major diameter of the external thread of a workpiece
T_{d2}	Tolerance for the pitch diameter of the external thread of a workpiece
T_{d3}	Tolerance for the minor diameter of the external thread of a workpiece
T_{D1}	Tolerance for the minor diameter of the internal thread of a workpiece
T_P	Pitch tolerance
T_{D2}	Tolerance for the pitch diameter of the internal thread of a workpiece
T_{PL}	Tolerance for the pitch diameter of GO and NOT GO screw plug gauges
T_{R}	Tolerance for the pitch diameter of GO and NOT GO screw ring gauges

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