ISO 1502:1996-02 (E)

ISO_general-purpose metric screw threads_- Gauges and gauging

Co	ntents	
	Pa	age
1	Scope	1
2	Normative references	1
3	Symbols and abbreviations	1
4	Types of gauges	3
4.1	Gauges for external threads of workpieces and their check plugs and setting plugs	_
4.2	Gauges for internal threads of workpieces	3
5	Gauging of workpieces	3
5.1	Gauging of external threads	3
5.2	Gauging of internal threads	4
5.3	Inspection gauging	4
6	Reference temperature	4
7	Function, checking and use of gauges	4
7.1	Gauges for external threads of workpieces and their check plugs and setting plugs	_
7.2	Gauges for internal threads of workpieces	8
8	Tolerance zones for the diameters of gauges (see figures 1 and 2)	8
9	Tolerance zones for plain gauges (see figures 3 and 4)	11
10	Thread profiles for gauges	13
10.	1 Profiles with complete flanks (see figures 5 and 6)	13
10.	2 Profiles with truncated flanks (see figures 7 and 8)	16
10.	· · · · · · · · · · · · · · · · · · ·	ed 18
11	General features of screw gauges	19
11.	1 Gauges for external threads of workpieces	19
11.3	2 Gauges for internal threads of workpieces	19

	11.3	Blunt start of thread	19		
•	12	Tolerances and permissible wear for pitch diameters of gauges (see tables 4 to 9)	21		
•	13	Formulae for calculation of gauge limits	23		
	13.1	Screw gauges for external threads of workpieces	23		
٠	13.2	Plain gauges for the major diameters of external threads of workpieces	23		
	13.3	Screw gauges for internal threads of workpieces	23		
	13.4	Plain gauges for the minor diameters of internal threads of workpieces	23		
Annex					
	Α	Bibliography	27		